



Series 400

Power Ditcher - Center Cut

Operator and Parts Manual



Limited Warranty

Remlinger Manufacturing will warrant all products against defects in material and workmanship manufactured and sold by it. Warranty will only be granted after examination by appropriate personnel. This warranty is expressly limited to the replacement or repair of the defective products. This warranty does not obligate Remlinger Manufacturing to cover cost of labor to replace these parts. This warranty is in effect for 1 year after purchase.

Remlinger Manufacturing warrants its own products only and cannot be responsible for damages to equipment on which it is attached or mounted.

Under no circumstances will this Limited Warranty cover any parts or components, in the opinion Remlinger Manufacturing, that has been subject to negligent handling, misuse, alteration, an accident, or if repairs have been made with parts other than those obtained from Remlinger Manufacturing.

Parts claimed to be defective must be returned at the Owner's expense and returned to Remlinger Manufacturing for inspection with shipping charges prepaid. Parts found to be defective will be replaced or repaired and returned promptly free of charge.

For questions or comments about your Remlinger Product contact:

Remlinger Manufacturing Company Inc.
16394 U.S. 224
Kalida, OH 45853

Phone: 1-800-537-7370
Email: technicalsupport@remlingermfg.com
Website: www.remlingermfg.com

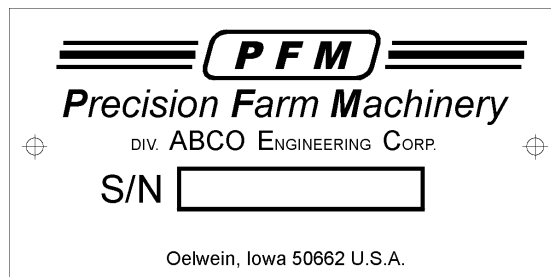
READ THIS MANUAL carefully to learn how to assembly, adjust, operate and service your Remlinger Power Ditcher properly. Failure to do so could result in personal injury or equipment damage.

THIS MANUAL SHOULD BE considered a permanent part of this product and should remain with it at all times for reference.

ALL REFERENCES to Right-Hand and Left-Hand are determined by facing the implement or tool from the rear.

READ AND UNDERSTAND the Limited Warranty before operating the ditcher. The Limited Warranty is located on the inside front cover.

Serial Number for the Power Ditcher is located on the upper Right-Hand side of the drive Housing. The number on the **PFM** metal tag is the ditcher **model number**. The number on the **Remlinger** decal is the **serial number**.



SERIAL NO:
000000000
REMLINGER MFG CO.

Please complete the Registration Form – located on the last page of this manual.

For Your Records

Dealer Purchased From

Name: _____

Address: _____

City: _____ State: _____ Zip: _____

Date Purchased _____

Model No. _____ (located on the Right-Hand side of the Drive Housing)

Serial No. _____ (located on the Right-Hand side of the Drive Housing)

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Checklist

PREDELIVERY CHECKLIST

After the ditcher has been completely assembled, inspect it to be sure it is good running order before delivering it to the customer. Check each item when found satisfactory or after making the necessary adjustments.

- ☐ Ditcher has been assembled properly.
- ☐ All grease fittings have been lubricated.
- ☐ Lubricate all lubrication points; be sure all fittings are taking grease and check all lubrication seals for leakage.
- ☐ Check drive belt tension and adjust, if necessary.

Date Set Up _____

- ☐ Check tightness of all external nuts and bolts. Pay particular attention to those securing the blades.
- ☐ Check that all moving parts are working freely.
- ☐ Connect PTO, check operation of PTO, sheave, belt drive and roter. Watch for any signs of faulty operation, vibration or unusual sounds. After a period of operation, shut off tractor engine. Check for loose bolts.
- ☐ Clean the ditcher and touch up any places where the paint is nicked or scratched. Be sure all decals are properly applied and undamaged.

DELIVERY CHECKLIST

The following check list is a reminder of very important information which should be conveyed directly to the customer at the time the ditcher is delivered. Check off each item as it is fully explained.

- ☐ Advise the customer that the life expectancy of this or any other machine depends on regular lubrication as described in the operator's manual.
- ☐ Give the operator's manual to your customer and explain all operating adjustments and lubrication.
- ☐ Explain the importance of safe and proper operation of the machine. Point out decals warning the operator of the dangers of unsafe operating procedures and conditions.

Date Delivered _____

Signature of Set-up
Technician _____

- ☐ Advise the customer that he must check the torque of nuts and bolts after the first 4 hours of operation.
- ☐ Tell the customer to record the serial number of this ditcher in the space provided on page ii of this manual.
- ☐ Complete Delivery and Warranty Registration forms, listing serial number of machine.
- ☐ Explain Warranty. Have dealer and customer sign form.

Signature of Set-up
Technician _____

SAFETY

RECOGNIZE SAFETY INFORMATION

This is the safety-alert symbol. When you see this symbol on your machine or in this manual, be alert to the potential for personal injury.

Follow recommended precautions and safe operating practices.



UNDERSTAND SIGNAL WORDS

DANGER: Indicates an imminently hazardous situation that if not avoided, will result in death or serious injury. This signal word is to be limited to most extreme situations, typically for machine components that, for functional purposes, cannot be guarded.

WARNING: Indicates a potentially hazardous situation that, if not avoided could result in death or serious injury, and includes hazards that are exposed when guards are removed. It may also be used to alert against unsafe practices.

CAUTION: Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices



FOLLOW SAFETY INSTRUCTIONS

Carefully read all safety messages in this manual and on your machine safety signs. Keep safety signs in good condition. Replace missing or damaged safety signs. Be sure new equipment components and repair parts include the current safety signs. Replacement safety signs are available from your P F M dealer.

Learn how to operate the machine and how to use controls properly. Do not let anyone operate without instruction.

Keep your machine in proper working condition. Unauthorized modifications to the machine may impair the function and/or safety and affect machine life.

If you do not understand any part of this manual and need assistance, contact your P F M dealer.



Safety Cont.

OPERATE SAFELY

To avoid bodily injury, keep all power drive safety shields in place.

Operate ditcher with 1000 rpm tractor.

Should excessive vibration occur, disengage tractor PTO shaft immediately.

Be sure rotor has stopped completely before checking blades.

Always replace broken, worn or missing blades.

Never ride, or permit others to ride, on the drawbar of the tractor or on the ditcher.

STAY CLEAR OF ROTATING DRIVE LINES

Entanglement in rotating drive line can cause serious injury or death.

Keep tractor master shield and drive line shields in place at all times. Make sure rotating shields turn freely.

Wear close fitting clothing. Stop the engine and be sure PTO drive line is stopped before making adjustments, connections, or cleaning out PTO driven equipment.



LUBRICATE THE DITCHER SAFELY

Do not clean, lubricate, or adjust the ditcher while it is in motion.

Before servicing or adjusting the ditcher, or removing material from it, always:

1. Disengage the power.
2. Shut off the engine.
3. Wait until ditcher rotor has stopped rotating.

Operating

BREAK-IN

Before starting the ditcher, lubricate the machine. See Lubrication and Maintenance Section.

CAUTION: Never operate the ditcher until the power shaft and other safety shields are in place and secured, Tighten all nuts and check cotter pins to see they are properly installed.



FIELD OPERATION

IMPORTANT: The constant striking of rotor blades and sudden impacts may cause excessive shear pin breakage. Reduce ditch depth or tractor speed.

Under most conditions, the tractor can be operated at 5 to 11 km/h (3 to 7 mph) without causing undue wear on the ditcher. Avoid excessive speeds. Reasonable speeds result in higher productivity. Various ditching conditions require different ground speeds. Best results will be obtained by running the tractor at the travel speed that will meet field conditions or the speed where the smoothest ditching action results.

IMPORTANT: When operating the ditcher always check the cutting depth so rotor will spread soil evenly and consistent.

IMPORTANT: Always operate the ditcher with the tractor at recommended speed to obtain 1000 rpm on the tractor PTO shaft.

Operating the tractor at less than recommended PTO rpm will reduce the blade rotor speed and result in improper ditching. Where difficult conditions make it necessary to slow down the ground speed of the tractor, shift to a lower gear, thus keeping the engine at its rated speed.

Reduce tractor RPM and disengage PTO when raising tractor 3 point hitch. PTO angle should never exceed 20 degrees while engaged.

IMPORTANT: Do not engage PTO with engine running at high speed. Doing so may cause undue wear or possible drive line and/or belt damage.

MAINTAINING ROTOR BALANCE

The rotor on your power ditcher is dynamically balanced and must be maintained in balance throughout the life of the machine.

CAUTION: Should excessive vibration occur, disengage the tractor PTO shaft immediately ! Shut off the tractor and determine the cause of problem. Correct the problem before operating again. See Service Section.



Lubrication and Maintenance

SYMBOLS



Lubricate with Multi-Purpose lubricant or an equivalent SAE multipurpose type grease at hourly intervals indicated by the symbols.

CAUTION: Do not clean, lubricate, or adjust your machine while it is in motion.



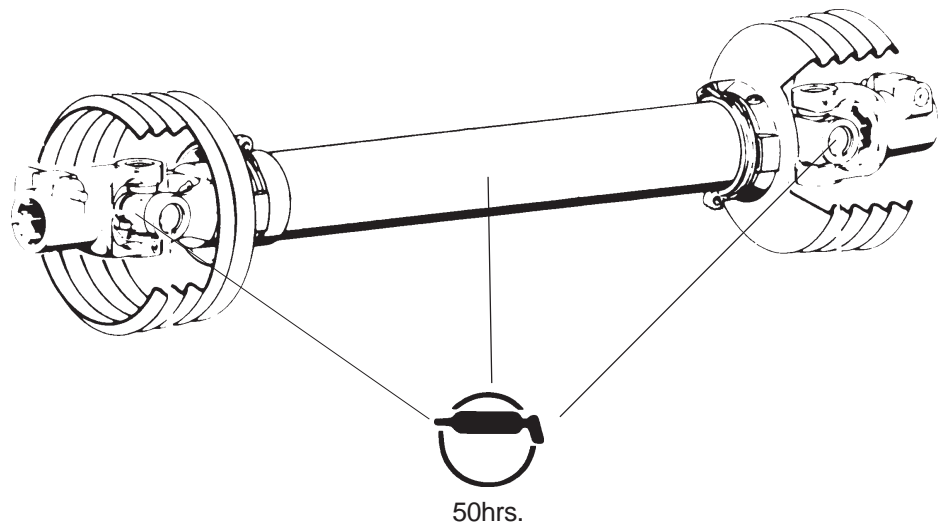
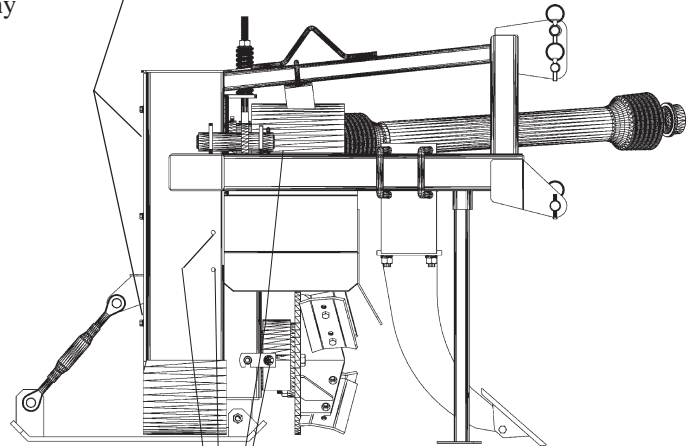
Clean grease fittings before using grease gun. Replace any lost or broken fittings immediately.

The application of grease in bearing area is very critical. Grease approximately four pumps every 50 hours. **DO NOT OVER GREASE**

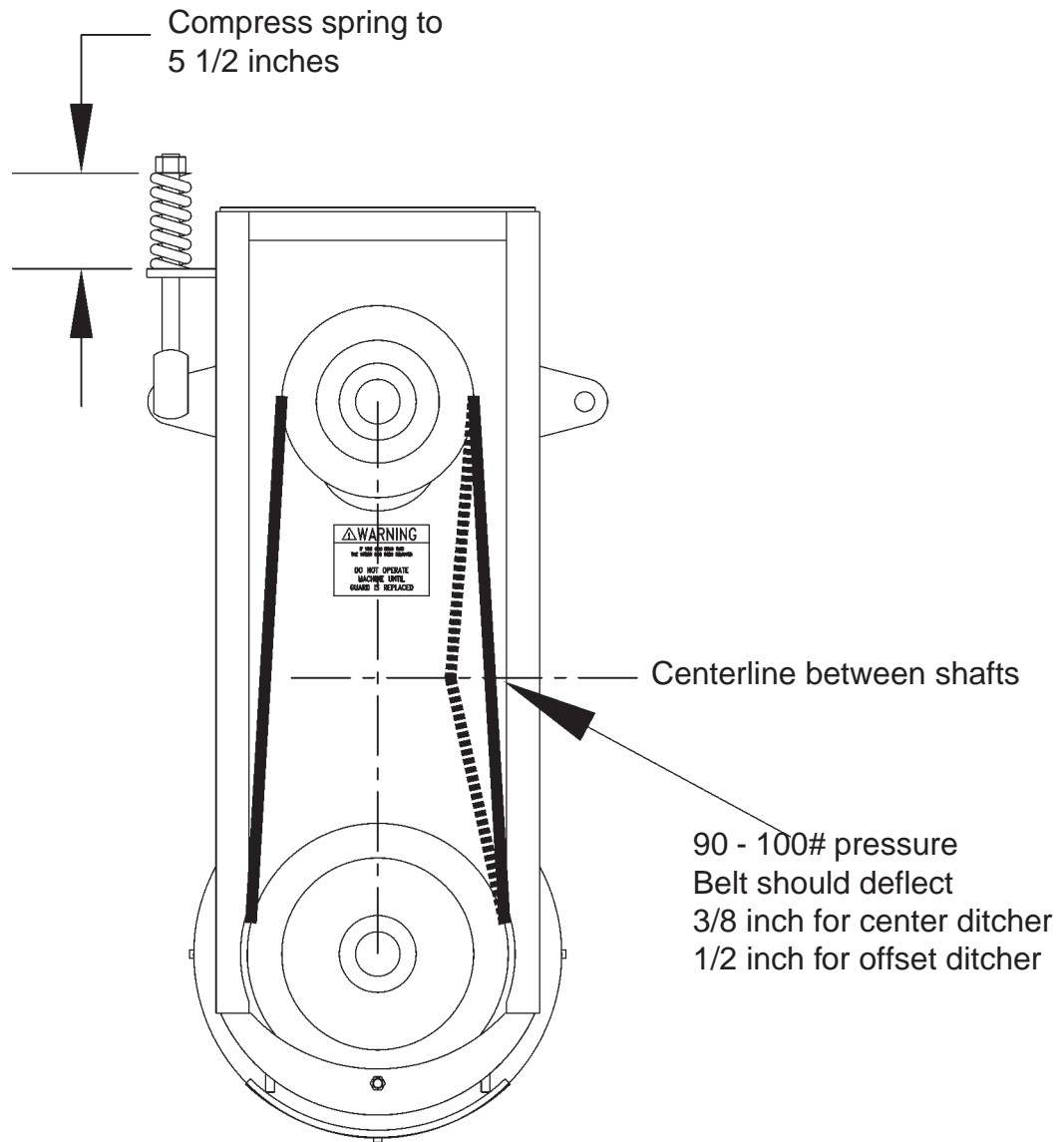
Grease telescoping shaft and universal joints every 50 hours.

Q-D "E" BUSHING TORQUE

Tighten bushing bolts to 60 ft. lbs.



Belt Tension Setting














Troubleshooting

Symptom	Problem	Solution
Ditch too shallow	Adjustment	Lower 3 pt on tractor Retract 3 rd link on tractor 3 point Adjust slide shoe up
Ditch too deep	Adjustment	Raise 3 pt on tractor Extend 3 rd link on tractor 3 point Adjust slide shoe down
Non uniform ditching	Improper tractor speed or PTO RPM	Reduce tractor ground speed Run PTO at proper RPM
Discharging material not consistent	Dirt buildup on discharge spout Ditching too deep in one pass	Clean spout Adjust machine and make two passes
Leaving ridge on discharge side of blade rotor	Improper tractor ground speed Ditching too deep	Operate tractor at proper ground speed Adjust machine and make two passes
Excessive vibration	Loss of rotor knife Rotor deformation Rotor bearing worn out	Install new knife Straighten the rotor or replace it Replace bearing
Belt breakage	Incorrect tension Misalignment between sheaves Residue in the rotor drive	Adjust belt for proper tension Align sheaves Clean and replace shield
Belt slippage	Incorrect tension Improper ground speed Ditching too deep in one pass	Adjust belt for proper tension Reduce ground speed Make two passes

Torque Values

UNIFIED INCH BOLT AND CAP SCREW TORQUE VALUES

SAE Grade and Head Markings	1 or 2 ^b 	5 	5.1 	5.2 	8 	8.2 
SAE Grade and Nut Markings	2 	5 			8 	

Size	Grade 1				Grade 2 ^b				Grade 5, 5.1, or 5.2				Grade 8 or 8.2			
	Lubricated ^a		Dry ^a		Lubricated ^a		Dry ^a		Lubricated ^a		Dry ^a		Lubricated ^a		Dry ^a	
	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft	N.m	lb-ft
1/4	3.7	2.8	4.7	3.5	6	4.5	7.5	5.5	9.5	7	12	9	13.5	10	17	12.5
5/16	7.7	5.5	10	7	12	9	15	11	20	15	25	18	28	21	35	26
3/8	14	10	17	13	22	16	27	20	35	26	44	33	50	36	63	46
7/16	22	16	28	20	35	26	44	32	55	41	70	52	80	58	100	75
1/2	33	25	42	31	53	39	67	50	85	63	110	80	120	90	150	115
9/16	48	36	60	45	75	56	95	70	125	90	155	115	175	130	225	160
5/8	67	50	85	62	105	78	135	100	170	125	215	160	215	160	300	225
3/4	120	87	150	110	190	140	240	175	300	225	375	280	425	310	550	400
7/8	190	140	240	175	190	140	240	175	490	355	625	450	700	500	875	650
1	290	210	360	270	290	210	360	270	725	540	925	675	1050	750	1300	975
1-1/8	470	300	510	375	470	300	510	375	900	675	1150	850	1450	1075	1850	1350
1-1/4	570	425	725	530	570	425	725	530	1300	950	1650	1200	2050	1500	2600	1950

DO NOT use these values if a different torque value or tightening procedure is given for a specific application. Torque values listed are for general use only. Check tightness of fasteners periodically.

Shear bolts are designed to fail under predetermined loads. Always replace shear bolts with identical grade.

Fasteners should be replaced with the same or higher grade. If higher grade fasteners are used, these should only be tightened to the strength of the original.

Make sure fasteners threads are clean and that you properly start thread engagement. This will prevent them from failing when tightening.

Tighten plastic insert or crimped steel-type lock nut to approximately 50 percent of the dry torque shown in the chart, applied to the nut, not to the bolt head. Tighten toothed or serrated-type lock nuts to the full torque value.

^a "Lubricated" means coated with a lubricant such as engine oil, or fasteners with phosphate and oil coatings. "Dry" means plain or zinc plated without any lubrication.

^b Grade 2 applies for hex cap screws (not hex bolts) up to 152 mm (6-in.) long. Grade 1 applies for hex cap screws over 152 mm (6-in.) long, and for all other types of bolts and screws of any length.

Storage

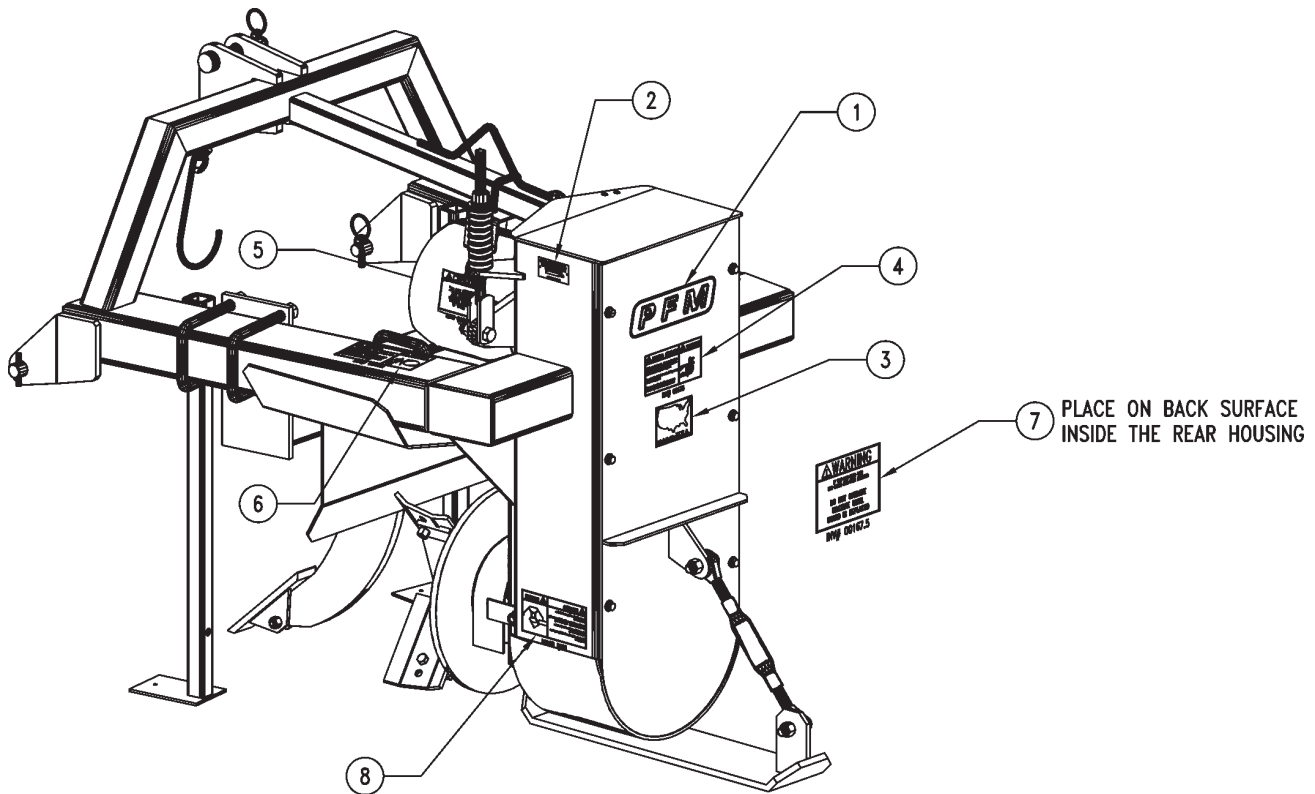
END OF SEASON

1. Shelter the power ditcher in a dry place.
2. Clean the power ditcher thoroughly inside and out.
Trash and dirt will draw moisture and cause rust.
3. Thoroughly lubricate the machine according to the Lubrication Section.
4. Paint all parts from which the paint has been worn.
5. List the replacement parts that will be needed and order them early. The dealer at this time can expedite delivery of parts and install them during slack periods avoiding delays next season.

BEGINNING OF SEASON

1. Lubricate complete machine; this will force any collected moisture out of the bearings (see Lubrication Section).
2. Tighten all loose bolts, nuts and set screws.
3. Replace blades if worn.
4. Check belt adjustment.
5. Review your operator's manual.

Safety Decal Locations



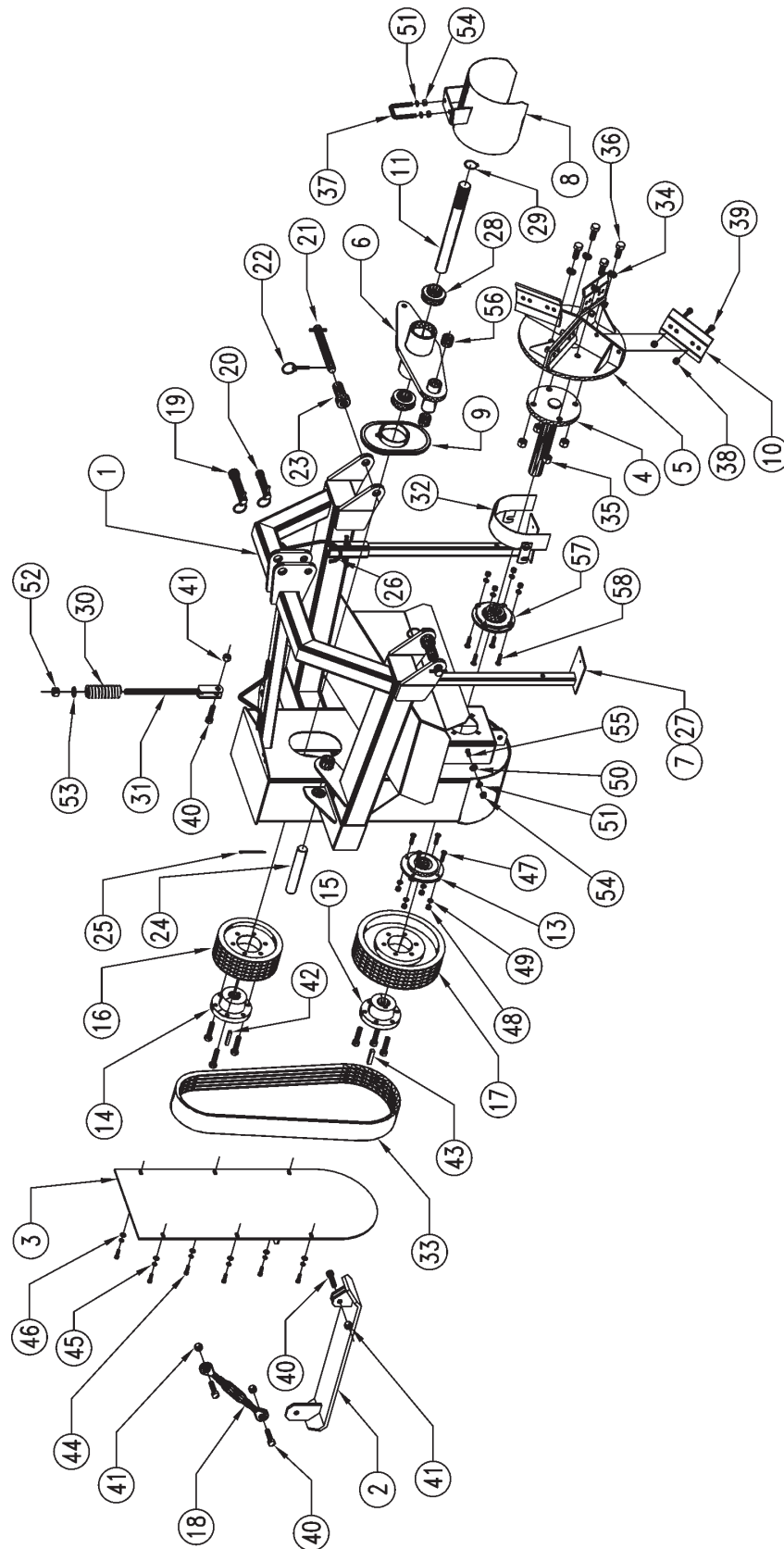
ITEM	PART#	DESCRIPTION	QTY
1	12400012	PFM DECAL- 2 3/4 X 10	1
2	12400010	SERIAL NO. PLATE	1
3	O0164	DECAL- MADE IN U.S.A.	1
4	O0175	WARNING- MOVING PARTS BELT	1
5	O0167	WARNING- DO NOT OP. W/O GUARD	1
6	O0192	DANGER- THROWN OBJ. HAZARD	1
7	O0167.5	WARNING- GUARD HAS BEEN REMOVED	1
8	O0191	DANGER- ROTATING BLADE HAZARD	2

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POWER DITCHER FRAME ASSEMBLY

MODELS 400-10, 400-20 AND 400-30

SERIAL # 400-440 -



POWER DITCHER FRAME B.O.M.

MODELS 400-10, 400-20 AND 400-30

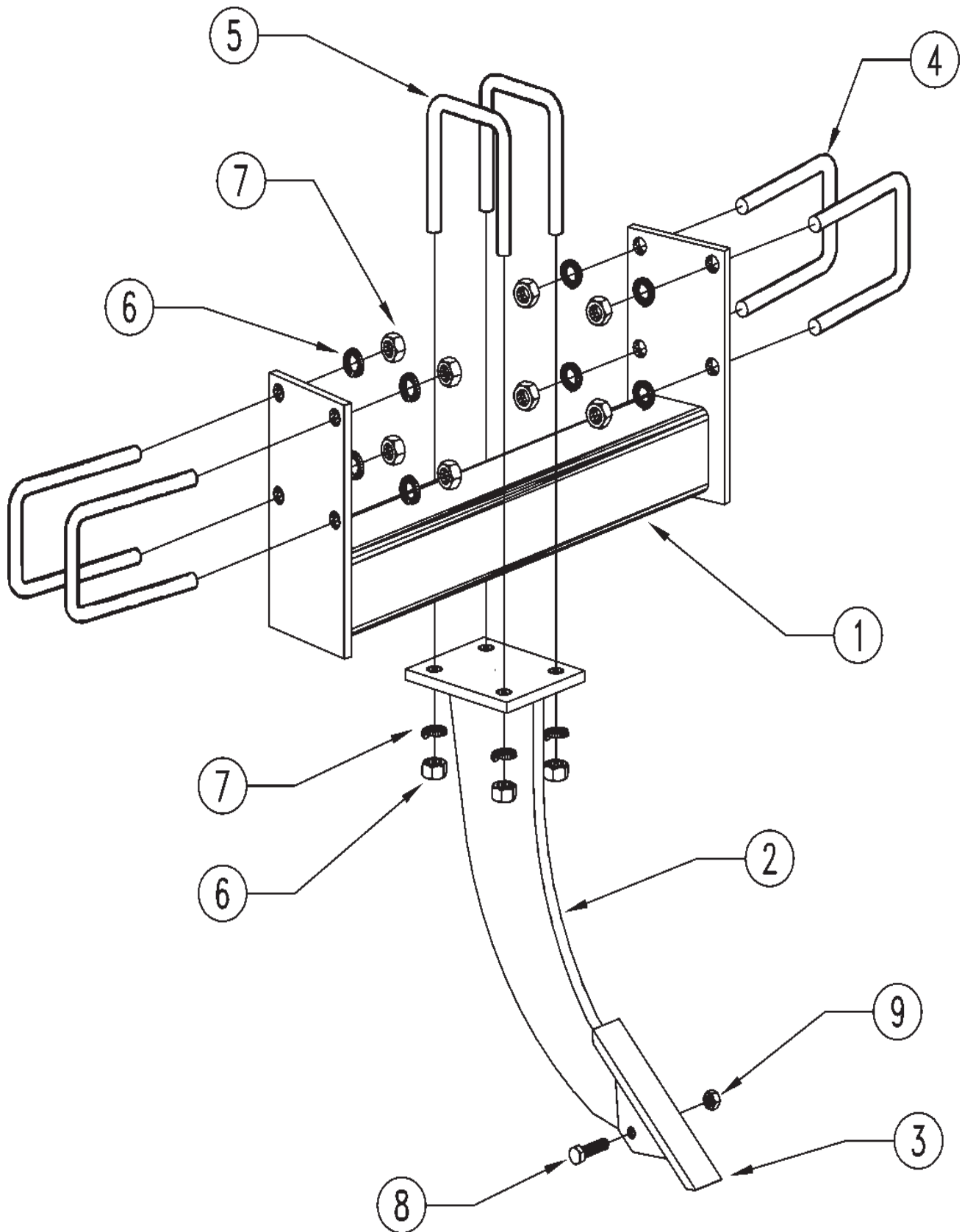
SERIAL # 400-440 -

ITEM	PART#	DESCRIPTION	QTY
1	40000117	DITCHER FRAME	1
2	40000121	SKID	1
3	40000118	DRIVE COVER	1
4	40000123	ROTOR SHAFT	1
5	40000026	KNIFE ROTOR	1
6	40000040	BEARING SHAFT SUPPORT	1
7	40000023	TUBE STAND	2
8	40000019	PTO SHIELD	1
9	40000094	SHIELD & SEAL ASSM	1
10	11600010	ROTOR BLADE	4
11	40000024	SPLINE SHAFT	1
12	40000119	COVER GASKET	1
13	10500044	BRG 1-15/16 PL FLNG	1
14	10900010	BUSHING 1-3/4 E	1
15	10900034	BUSHING 1-15/16 E	1
16	10700016	SHEAVE 5/5V0975	1
17	10700017	SHEAVE 5/5V1320	1
18	12200018	SCREW JACK	1
19	10400034	TOP LINK PIN 1-1/4 DIA	1
20	10400035	TOP LINK PIN 1 DIA	1
21	10400033	LOWER 3-POINT PIN	2
22	10400032	LYNCH PIN	4
23	10900026	ADAPTER BUSHING PAIR	1
24	40000041	PIN 1-1/2 DIA	1
25	10400121	COTTER KEY	1
26	40000083	PTO SUPPORT	1
27	10400040	HITCH PIN 1/2 X 3	2
28	10500013	BEARING INSERT 1-3/4	2
29	10400013	RETAINER RING 1-3/4	1
30	10800011	SPRING 6	1

ITEM	PART#	DESCRIPTION	QTY
31	40000124	TENSIONER BOLT	1
32	40000120	ROTOR SHIELD	1
33	11800015	5/5VX800 BANDED BELT	1
34	F0425	LOCK WASHER 3/4	4
35	10100019	HEX NUT 3/4 NC	5
36	F0172.5	HCS 3/4 NC X 2-1/2	4
37	10000201	U-BOLT 1/2 X 2 X 3	1
38	F0303.1	NYLOCK NUT 1/2 NC	8
39	F0132	HCS 1/2 NC X 1-1/4	8
40	F0157	HCS 5/8 NC X 2-1/2	4
41	10100114	NYLOCK NUT 5/8 NC	4
42	10400083	KEY 3/8 SQ X 2-1/2	1
43	10400089	KEY 1/2 SQ X 2-1/2	1
44	F0111.2	HCS 3/8 NC X 1 1/4	6
45	F0422	LOCK WASHER 3/8	6
46	F0402	FLAT WASHER 3/8	6
47	10000258.20	CRGE BOLT 7/16 X 2	4
48	F0302.7	HEX NUT 7/16 NC	8
49	F0450	STAR WASHER 7/16	8
50	F0403	FLAT WASHER 1/2	2
51	F0423	LOCK WASHER 1/2	4
52	F0306.4	HEX NYLOCK NUT 3/4	1
53	F0405	FLAT WASHER 3/4	1
54	10100016	HEX NUT 1/2 NC	4
55	10000260	CRGE BOLT 1/2 X 1 1/4	2
56	10900039	BUSHING 1-1/2 ID	2
57	10500050	BRG 1-15/16 SPH ROLLR	1
58	10000258	CRGE BOLT 7/16 X 1 1/2	4
	11100041	GREASE TUBE ASSM	2
	10100097	3/8 U-NUT	6

POWER DITCHER SHANK ASSEMBLY

MODELS 400-10, 400-20 AND 400-30



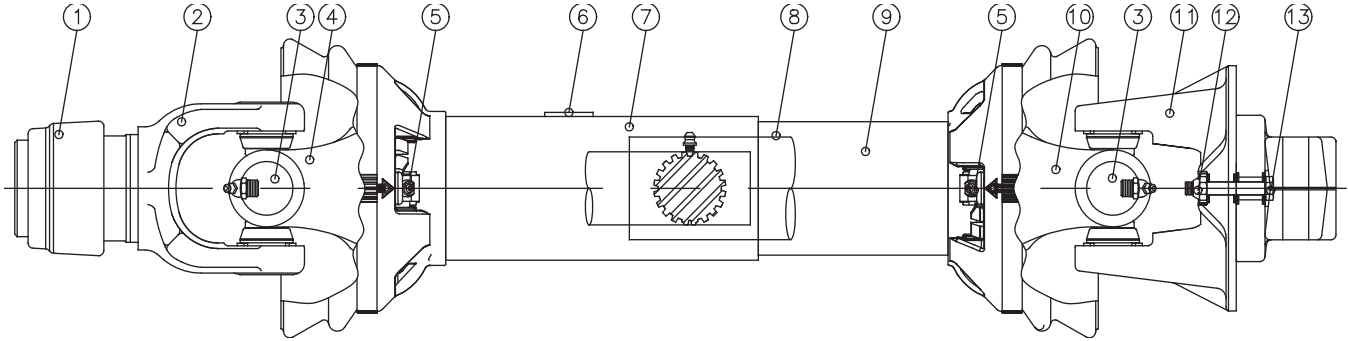
POWER DITCHER SHANK B.O.M
MODELS 400-10, 400-20 AND 400-30

ITEM	PART#	DESCRIPTION	QTY
1	40000016	TOOL BAR	1
2	40000014	SHANK WELD	1
3	40000029	RIPPER PONT	1
4	10000202	U-BOLT 3/4 NC X 4 X 7-3/4	4
5	10000203	U-BOLT 3/4 NC X 4 X 5-3/4	2
6	F0425	LOCK WASHER 3/4	12
7	10100019	HEX NUT 3/4 NC	12
8	F0137	HCS 1/2 NC X 2	1
9	F0303.1	NYLOCK NUT 1/2 NC	1

WEASLER PTO ASSEMBLY

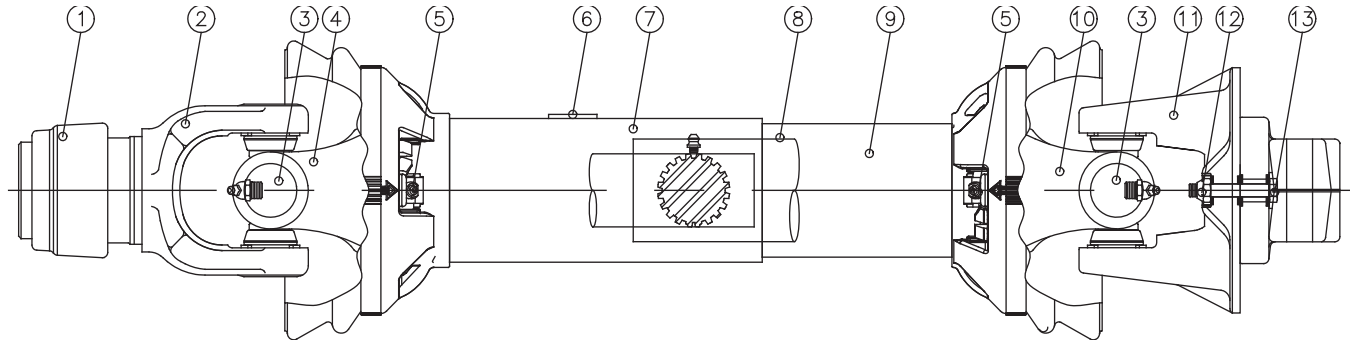
PART# 11300060

1 3/8" - 6 SPLINE 540 RPM



ITEM	PFM#	QTY	TECHNICAL DATA	DESCRIPTION
1	11300081	1	26-15120	AUTO-LOK REPAIR KIT 6 OR 21 SPLINE
2	11300065	1	44011-1006	YOKE ASSEMBLY 1-3/8 6 SPLINE
3	11300064	2	03-10089	CROSS & BEARING KIT
4	11300079	1	99-22532	YOKE & SPLINE SHAFT MALE
5	11300088	2	19-15121	GUARD LOCK REPAIR KIT
6	11300086	1	13-10021	SAFETY SIGN OUTER GUARD
7	11300084	1	97-22532	OUTER GUARD
8	11300085	1	96-22532	INNER GUARD
9	11300087	1	13-10022	SAFETY SIGN INNER GUARD
10	11300080	1	98-22532	YOKE & SPLINE TUBE FEMALE
11	11300063	1	40-20021	BALL SHEAR ASSEMBLY
12	11300069	1	11-10044	LOCK NUT
13	11300068	1	11-10470	SHEAR BOLT
14	11300083	*	90-22532	GUARD SET OUTER + INNER
15	11300071	*	93-22756	HALF SHAFT MALE W/ SHIELD
16	11300072	*	95-22756	HALF SHAFT MALE W/O SHIELD
17	11300077	*	92-22532	HALF SHAFT FEMALE W/ SHIELD
18	11300078	*	94-22532	HALF SHAFT FEMALE W/O SHIELD

WEASLER PTO ASSEMBLY
PART# 11300061
1 3/8" - 21 SPLINE 1000 RPM

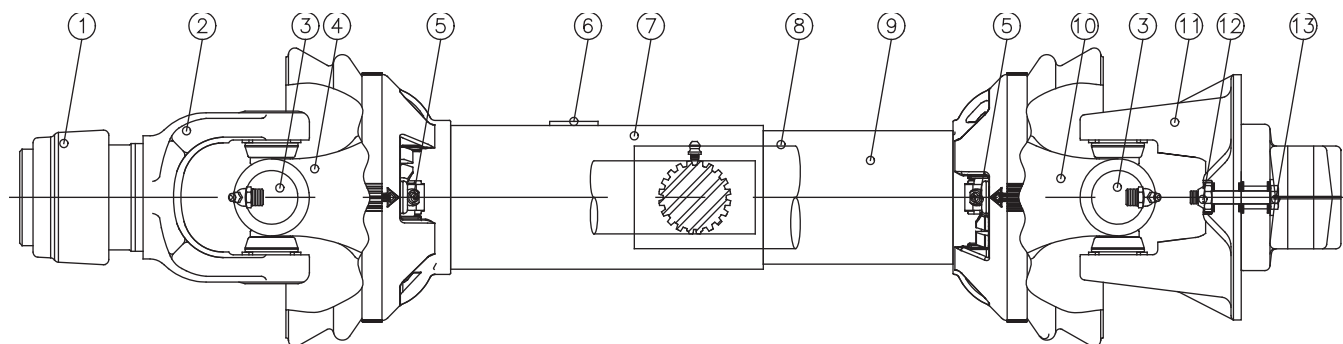


ITEM	PFM#	QTY	TECHNICAL DATA	DESCRIPTION
1	11300081	1	26-15120	AUTO-LOK REPAIR KIT 6 OR 21 SPLINE
2	11300066	1	44011-1007	YOKE ASSEMBLY 1-3/8 21 SPLINE
3	11300064	2	03-10089	CROSS & BEARING KIT
4	11300079	1	99-22532	YOKE & SPLINE SHAFT MALE
5	11300088	2	19-15121	GUARD LOCK REPAIR KIT
6	11300086	1	13-10021	SAFETY SIGN OUTER GUARD
7	11300084	1	97-22532	OUTER GUARD
8	11300085	1	96-22532	INNER GUARD
9	11300087	1	13-10022	SAFETY SIGN INNER GUARD
10	11300080	1	98-22532	YOKE & SPLINE TUBE FEMALE
11	11300063	1	40-20021	BALL SHEAR ASSEMBLY
12	11300069	1	11-10044	LOCK NUT
13	11300068	1	11-10470	SHEAR BOLT
14	11300083	*	90-22532	GUARD SET OUTER + INNER
15	11300073	*	93-22757	HALF SHAFT MALE W/ SHIELD
16	11300074	*	95-22757	HALF SHAFT MALE W/O SHIELD
17	11300077	*	92-22532	HALF SHAFT FEMALE W/ SHIELD
18	11300078	*	94-22532	HALF SHAFT FEMALE W/O SHIELD

WEASLER PTO ASSEMBLY

PART# 11300062

1 3/4" - 20 SPLINE 1000 RPM



ITEM	PFM#	QTY	TECHNICAL DATA	DESCRIPTION
1	11300082	1	26-13387	AUTO-LOK REPAIR KIT 20 SPLINE
2	11300067	1	44041-1141	YOKE ASSEMBLY 1-3/4 20 SPLINE
3	11300064	2	03-10089	CROSS & BEARING KIT
4	11300079	1	99-22532	YOKE & SPLINE SHAFT MALE
5	11300088	2	19-15121	GUARD LOCK REPAIR KIT
6	11300086	1	13-10021	SAFETY SIGN OUTER GUARD
7	11300084	1	97-22532	OUTER GUARD
8	11300085	1	96-22532	INNER GUARD
9	11300087	1	13-10022	SAFETY SIGN INNER GUARD
10	11300080	1	98-22532	YOKE & SPLINE TUBE FEMALE
11	11300063	1	40-20021	BALL SHEAR ASSEMBLY
12	11300069	1	11-10044	LOCK NUT
13	11300068	1	11-10470	SHEAR BOLT
14	11300083	*	90-22532	GUARD SET OUTER + INNER
15	11300075	*	93-22532	HALF SHAFT MALE W/ SHIELD
16	11300076	*	95-22532	HALF SHAFT MALE W/O SHIELD
17	11300077	*	92-22532	HALF SHAFT FEMALE W/ SHIELD
18	11300078	*	94-22532	HALF SHAFT FEMALE W/O SHIELD

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Registration Form – “400 Series” Power Ditchers

Please Return Promptly

Name: _____

Address: _____

City: _____ State: _____ Zip: _____

Ditcher Style ☐ Center Cut ☐ Offset Cut ☐ Disk

Model No. _____ (located on the Right-Hand side of the Drive Housing)

Serial No. _____ (located on the Right-Hand side of the Drive Housing)

PTO Style ☐ 1 3/8" Diameter – 6 Spline (540 rpm)

☐ 1 3/8" Diameter – 21 Spline (1000 rpm)

☐ 1 3/4" Diameter – 20 Spline (1000 rpm)

Options

Ripper ☐ Yes

Coulter ☐ Yes

Gage Wheel ☐ Yes

Dealer Purchased From

Name: _____

Address: _____

City: _____ State: _____ Zip: _____

Mail To:

Remlinger Mfg. Co. Inc.
P. O. Box 299
Kalida, OH 45853

Fax To:

(419) 532-2244

Email To:

agsales@remlingermfg.com

Thank you for purchasing the Remlinger Family of Products.