



Rotary Rake Model HRS15

Operator's Manual



THIS MANUAL MUST BE READ AND UNDERSTOOD BEFORE ANYONE OPERATES THIS MACHINE!

Manual# 990033
Revised 04/2012

To the Owner;

Thank-You for choosing a quality product from Pequea. We strive to give you the best equipment and the best level of service of any company. With a little care and maintenance this machine will do your work for you for many years. In this manual, we make an effort to get you better acquainted with the machine so you can achieve maximum performance. We design and build all of our equipment with the end user in mind so we welcome any suggestions or ideas for improvement. Please note that it is within our rights to make changes or improvements to our equipment without updating the equipment that was manufactured before the change took place.

Please take a few minutes to fill out the area below. This information will be valuable to you when ordering parts or requesting service from your dealer.

Dealer Name:_____

Dealer Phone Number:_____

Service Manager/Technician:_____

Model# and Description:_____

Serial Number:_____

Date of Purchase:_____

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INTRODUCTION

Thank-You for choosing a Pequea Rotary Rake. Your rake is the result of years of research and development work. This Operator's Manual will familiarize the operator with the safety and operation of the machine. Included are complete instructions for assembly, operation, lubrication, and maintenance procedures. Understanding and following these procedures will result in years of maximum performance from your Pequea Rake.

Read entire manual before operating. Failure to follow the instructions outlined in this manual may result in personal injury and/or damaged equipment, and could void the warranty.

Rake Serial Number

The rake's serial number can be found near the front on the main frame of the rake. Please use this number when requesting service, seeking information, or ordering parts. For the operator's convenience, space to record the serial number, model number, purchase date, and dealer has been provided inside the front cover of this manual.












All pictures and instructions in this manual assume that the right and left side of the machine are that of someone standing behind the rake facing forward.

Specifications








Specifications	HRS15	HR1140	HR930
Working Width	15' (4.6m)	13' (4.3m)	10' 8" (3.2m)
Raking Width	13' (4m)	11' (3.3m)	9' (2.7m)
Transport Width	8' 2" (2.5m)	59" (1.5m)	9' 4" (2.8m)
Gear Box	Sealed/Greasable	Enclosed Oil Bath	
Gear Reduction	9.7 to 1		
Tine Arms	13	11	9
Double Tines per Arm	4	4	3
PTO/HP Required	40 HP - 540 RPM	40 HP - 540 RPM	30 HP - 540 RPM
Direction of Raking Action	Left		
Hydraulic Requirement	1400 psi	1200 psi	
Weight	2100 lbs.	1550 lbs.	1050 lbs.
Tandem Axle Beam	Standard		
Tires	18.5 x 8 Flotation Tires on 4-Bolt Painted Wheels		

SAFETY

-  ***This symbol precedes specific safety instructions throughout this manual. When reading the manual pay close attention to the information that follows this symbol.***
-  FAILURE TO FOLLOW INSTRUCTIONS IN THIS MANUAL COULD RESULT IN PERSONAL INJURY OR DEATH. READ ENTIRE MANUAL BEFORE OPERATING ROTARY RAKE.
-  Keep hands, feet and clothing away from the machine's input power take-off (PTO) and any other moving parts until the machine has been shut down and the power source has been locked out. (Refer to Power Source Safety)
-  Do not attempt to adjust, unclog, lubricate, or service the machine until it has been shut down and the power source has been locked out. (Refer to Power Source Safety)
-  Do not lubricate or adjust the machine while it is in motion.
-  Support the rake securely while working under it.
-  Do not stand between the tractor and the rake while attaching or detaching the rake unless the tractor engine is shut off and the parking brake has been set.
-  Be certain all bystanders and animals are a safe distance away from the rake before raising or lowering it. Never allow anyone to ride on the rake or the tractor.
-  When transporting, never exceed a speed of 20 MPH and avoid sudden turns which may compromise the operator's control of the tractor.
-  Be constantly aware of the location of the ends of the rake to avoid collision with other objects.
-  When moving the machine on public roads use the proper reflectors, lights, and slow moving vehicle signs required by local government agencies.

Power Source Safety

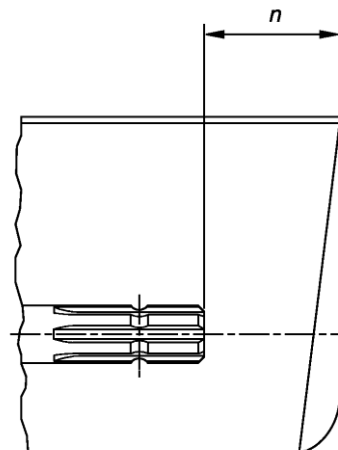
-  Do not use a rake power take-off (PTO) shaft without a rotating shield in good working order. Make sure drive system safety shields are in place for both the power source and the rake.
-  The rake input PTO must be securely attached to both the power source and the input shaft.
-  Do not overextend the input PTO shaft.
-  Make sure PTO is disengaged before starting power source.
-  PTO shield chains must be attached to the tractor and the rake to keep the shield from rotating.

SAFETY

Stay Clear of Rotating Drivelines



TS1644-UN-22AUG95



H96219-UN-29APR10

Entanglement in rotating driveline can cause serious injury or death.

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

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

Do not install any adapter device between the tractor and the primary implement PTO drive shaft that will allow a 1000 rpm tractor shaft to power a 540 rpm implement at speeds higher than 540 rpm.

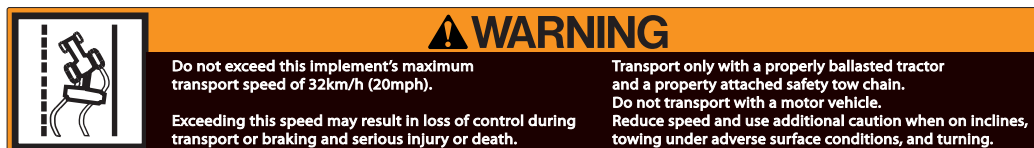
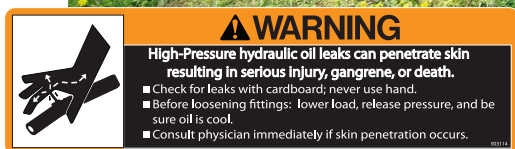
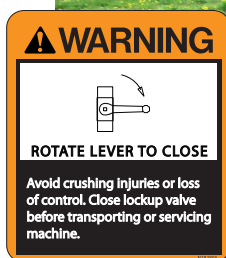
Do not install any adapter device that results in a portion of the rotating implement shaft, tractor shaft, or the adapter to be unguarded. The tractor master shield shall overlap the end of the splined shaft and the added adaptor device as outlined in the table.

PTO Type	Diameter	Splines	$n \pm 5 \text{ mm (0.20 in.)}$
1	35 mm (1.378 in.)	6	85 mm (3.35 in.)
2	35 mm (1.378 in.)	21	85 mm (3.35 in.)
3	45 mm (1.772 in.)	20	100 mm (4.00 in.)

SAFETY

Safety Decals and Reflectors

Decals and reflectors are for the protection of yourself and others. If they are missing, faded, or not readable, get replacements from your dealer immediately.



SETUP



When working under the rake, make sure it is properly and securely supported.

Tine Arms



Figure 1

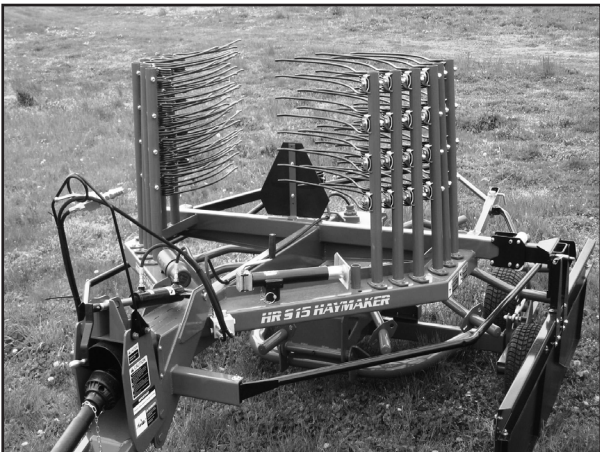


Figure 2 (arms in storage position)

Remove rubber caps from gearbox stub shaft. Remove tine arms from storage position and slide onto gearbox stub shaft (Figure 1). Insert tab on tine arm into slot and insert locking pin. Rotate gearbox installing tine arms until complete. Do not operate unless all the arms have been properly installed and secured. The stub shafts are greased at the factory with an anti-sieze lubricant. You will need to regrease periodically to keep the surface from getting rusty. Surface rust will make it nearly impossible to remove the arms. The rake must never be stored with the arms installed on the stub shafts or they will seize up and will be nearly impossible to remove. ***Always store the rake with all arms in the transport position!!***

Guards



Figure 3

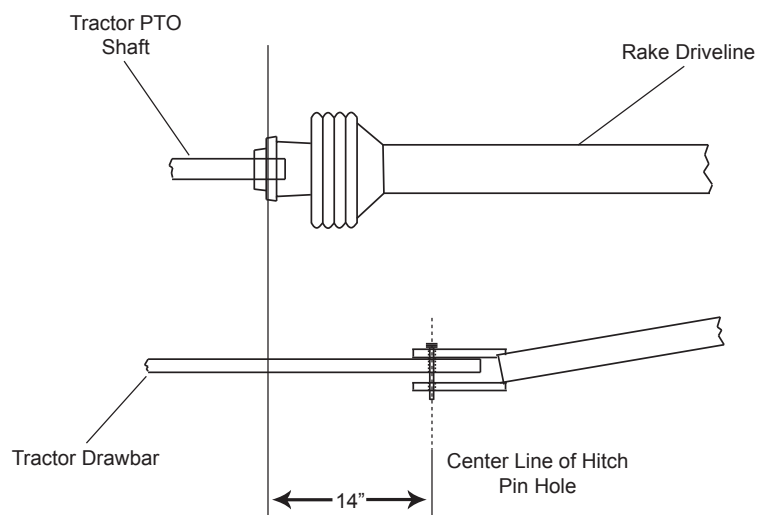
Pull the guards out into the raking position and lock them into place with the 1/2" lock pin (Figure 3)

HITCHING

Tractor Requirements

The Pequea Rake is designed to be used with a tractor having a 540 RPM PTO. The hitch pin hole on the tractor should be 14" (35cm) from the groove in the PTO output shaft. (See illustration below)

NOTE: If the hitch pin hole is located well behind the tractor tires there is the potential of making a sharp enough turn to damage the rake PTO shaft.



Hitching

Align the hole in the tractor draw bar with the hole in the rake tongue and insert an approved hitch pin. Lock hitch pin with a safety clip to insure that it cannot work its way out.



Figure 4

HITCHING

With PTO shaft connected to the rake, slide shaft safety collar back and slide the tractor side of the PTO shaft onto the tractor drive shaft. Release the shaft safety collar. Insure that the PTO shaft is securely locked onto the tractor drive shaft. Fold the PTO stand down onto the frame to avoid damaging the PTO shaft shielding. (Figure 5)

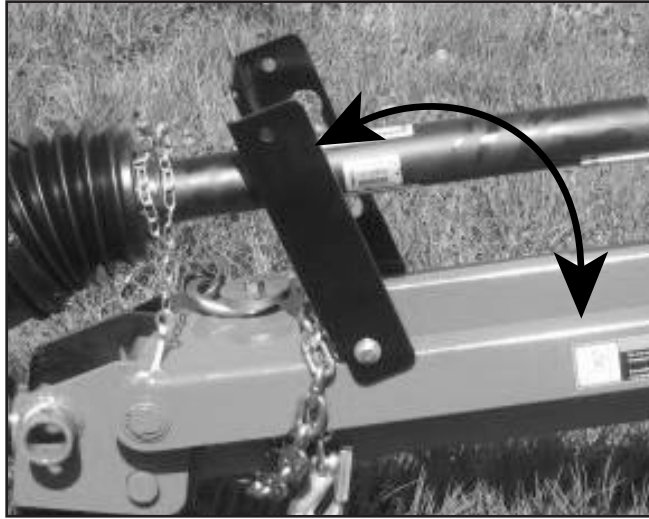


Figure 5

Connect the rake hydraulic line to the tractor implement hydraulic output.

Plug the electrical harness into the tractor to operate the lights (If applicable).

Crank the rake jack off the ground and remove the locking pin. Pull the jack off of the mount, place in storage position on the main frame, and reinsert locking pin. Figure 6 shows the jack in the storage position.



Figure 6

TRANSPORTING

Field Transport

Make sure that the rake is raised into the transport position.

Never allow any riders on the rake or the tractor.

Avoid tight turns to reduce the possibility of loss of control or PTO shaft damage.

Remain fully aware of the width of the rake in relation to the objects you are passing, either stationary or moving.

Never travel at speeds over 10 MPH (16km/hr.) in the field.

Road Transport

Adhere to all suggestions for transport in the field listed above.

Collapse the guards to reduce the overall width of the rake.

Remove the tine arms from the gearbox stubs and secure them in the storage position on top of the rake.

Rotate the hydraulic lock-out valve on the hydraulic hoses that connect to the tractor. This will prevent the rake from drifting down into the raking position.

Follow all local regulations for moving agricultural equipment on public roads, especially those related to reflectors, SMV (slow moving vehicle) symbols and safety markers.

Never travel at speeds over 20 MPH (32km/hr.) on the road.

FIELD ADJUSTMENTS

⚠ Never attempt to make any adjustments while the rake or the tractor is running. All power sources must be completely shut off and parking brakes applied.

Height Adjustment

Correct tine clearance cannot be stressed enough as it is essential to minimize crop loss, prevent premature wear of tines, and decrease crop contamination which can result in premature wear of your processing equipment. Fine tuning is easy with the turnbuckle height/leveling system. Simply rotate the handle until you reach the desired height. As a rule, one inch of ground clearance is a good setting. Adjustments must be made if raking on uneven ground or when raking hay that has been compacted by rain or other haying equipment. Both sides must be adjusted equally or the rake will be tilted and will not pick up the hay as well.



Figure 7

Leveling the Rake

The rake has a threaded leveling device built into the front cylinder. (Figure 8) Turn the handle clockwise to raise the front of the rake and counterclockwise to lower it. The rake should be level or slightly lower in the front for the best performance.



Figure 8

FIELD ADJUSTMENTS

Hay Curtain Adjustment

The hay curtain can be adjusted horizontally to adjust the windrow width and also to accept different crop types and volume. To adjust, disengage the locking handle (Figure 10) and leave it in the relaxed position, slide the curtain to the desired position then engage the locking handle. The curtain can be removed when raking up against an existing windrow.



Figure 10

Gearbox Pitch Adjustment

There is an adjustment lever below the gearbox (Figure 11) to rotate the center cam track. The cam track rotates each tine arm to raise and lower the tines as it revolves. Rotating the cam track several degrees will determine the position of the rising and falling of the tines and will determine the width and consistency of your windrow. Example: for a heavy crop rotate the handle to the left so the hay is released quicker.



Figure 11

OPERATION

Having made adjustments (where necessary) described in the previous sections, drive the tractor to where you will begin raking. With the tractor standing still, lower the rake to its operating position. Engage the tractor's PTO at a low RPM, (this is especially important on a tractor with an electric clutch) and without getting off the tractor seat, visually determine that the rake is properly adjusted. If further adjustments are required, disengage the PTO and stop the tractor's engine and adjust where needed.

When ready, increase PTO speed to the desired RPM and engage the tractor's forward gear. The correct ground speed/PTO speed ratio, along with the proper adjustment for height and level, will play a large role in making a clean sweep and a nice even windrow. 6 MPH (9.6 km/hr.) ground speed and 400 PTO RPMs is the ideal combination for fluffy windrows. Adhere to all safety requirements as listed previously for field operation.

Always operate the rake at the lowest RPM possible that allows you to rake cleanly at your chosen ground speed. Higher speeds result in more leaf loss and lower quality hay, especially if you are raking dry hay. Higher speeds will also cause more wear on the rake.

While operating the rake you must constantly be aware of all your surroundings. The guards are designed for human safety and will not withstand a collision with a stationary object such as a fence post or an electric pole. If such a collision does occur and you cannot stop before the tine arms hit the obstacle, the radial pin clutch on the gearbox input shaft will engage and should protect the gearbox from any serious damage. The slip clutch will not engage fast enough to protect the tine arms.

This rake has been designed to tolerate a fair amount of abuse due to rough field conditions, However, this is no excuse for careless operation and it is the operator's sole responsibility to avoid conditions such as washouts, ditches, animal dens, and sink holes. These hazards can cause severe damage to the rake. Damages incurred due to carelessness will not be covered under warranty by the manufacturer.

LUBRICATION

It is extremely important to keep your rake properly lubricated at all times. Failure to do so will greatly decrease the performance and the life of the machine.

Never lubricate or perform any maintenance, adjustments or repairs with the machine running. The PTO must be disengaged and the tractor's engine must be shut off.

With a clean cloth wipe off both the grease fitting and the tip of the grease gun. This will eliminate any chance of dirt or dust particles getting inside and damaging the bearings or friction surfaces.

Do not overgrease the sealed bearings. Overgreasing could rupture the seals exposing the bearing to a lot of dust particles. Roller bearings are sealed and are generally maintenance free. The friction bearing points cannot be overgreased.

Gearbox Lubrication

There are two grease fittings on top of the rotary gearbox. The one on the very top of the gearbox (A) lubricates the pinion bearings and will need very little grease. The other one (B) lubricates the ring gear and should be greased after every 10 hours of use. There are no grease points on the horizontal gearbox arms. These arms are encased in plastic bushings and do not need to be greased.

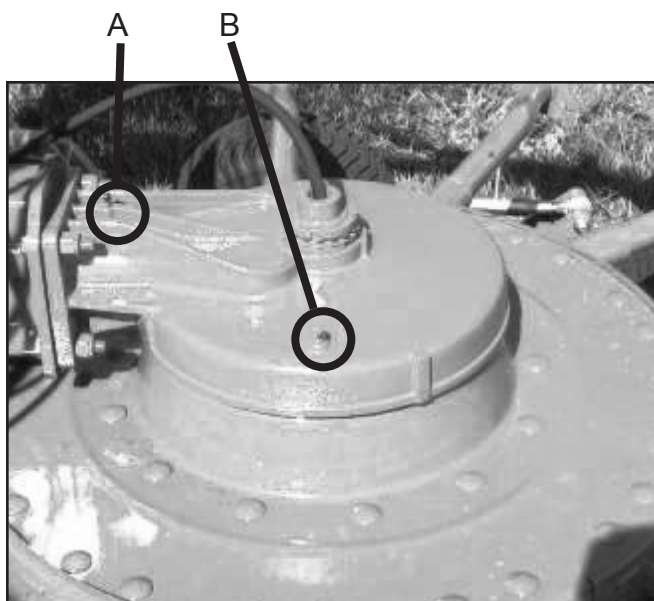


Figure 12

LUBRICATION

PTO Lubrication

There are grease fittings on both the tractor end and the rake end of the PTO shaft. Grease these after every 8 hours of operation. Use a high quality lithium grease. Also keep all the telescoping surfaces well lubricated.



Figure 17



Figure 18

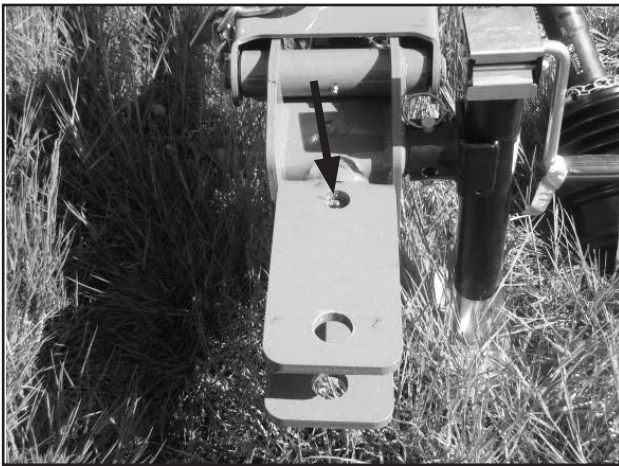
Tine Arms

The inside surface of the tine arm must be greased periodically to avoid surface rust which will make it difficult or nearly impossible to remove the arms for storage. A generous dab of heavy anti-sieze grease once a year should be sufficient for a rake that is stored indoors. If the rake is stored outside you will need to regrease more frequently.

General Lubrication

All other grease fittings should be lubricated after every 50 hours of operation. Use a high quality gear grease for the grease fittings on top of the gearbox. For all other bearings, joints, and pivot points, use either a lithium or a gear grease. In dry, dusty conditions it may be necessary to grease more than every 50 hours. In the following pages we show the location of the grease fittings.

LUBRICATION



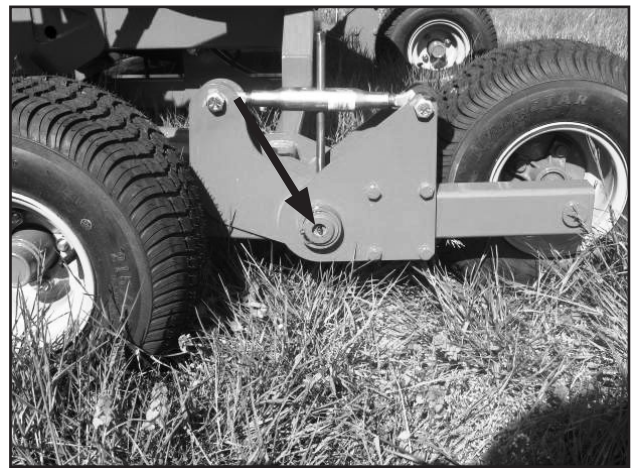
Tongue Swivel



Tongue leveling pivots, 2 front, 2 rear



Rake leveling screw



Axle tandem beams



Axle pivot



Drive shaft bearing

MAINTENANCE

Check and replace any safety decals that are damaged or missing.

After first use of the rake, we recommend a thorough inspection of all bolts and nuts. Retighten any loose hardware and check periodically thereafter.

Check the air pressure of the tires. They should be inflated to approx. 20 psi.

Inspect the tines and replace any that are missing or broken.

Visually inspect condition of the hay curtain. Replace if necessary.

Periodically pressure wash your equipment and touch up any scratches with high quality rust resistant paint.

Apply a light weight oil to all moving parts not specified in other lubrication instructions in this manual.

STORING YOUR RAKE

Before winter storage, perform all lubrication and other maintenance procedures as previously described.

Remove tine arms and secure them in their proper storage position.

Store in a dry, covered place with the rake lowered into the raking position. Storing in the raised (transport) position exposes the cylinder rod to dust and other elements that could cause it to rust.

TORQUE SPECIFICATIONS

The torque chart below lists the proper torque values for all attachment hardware on the rake unless otherwise specified in this manual.

Standard Torque Chart

BOLT SIZE	GRADE 5 BOLTS		GRADE 8 BOLTS	
	TORQUE (DRY) FT.LBS.	LUBRICATED FT.LBS.	TORQUE (DRY) FT.LBS.	LUBRICATED FT.LBS.
1/4 20	8	6	12	9
1/4 28	10	7	14	10
5/16 20	17	13	24	18
5/16 24	19	14	27	20
3/8 16	30	23	45	35
3/8 24	35	25	50	35
7/16 14	50	35	70	50
7/16 20	55	40	80	60
1/2 13	75	55	110	80
1/2 20	85	65	120	90
9/16 12	110	80	150	110
9/16 18	120	90	170	130
5/8 11	150	110	210	160
5/8 18	170	130	240	180
3/4 10	260	200	380	280
3/4 16	300	220	420	310
7/8 9	430	320	600	450
7/8 14	470	350	670	500
1-8	640	480	910	680
1-14	720	540	1,020	760

TORQUE SPECIFICATIONS

Metric Torque Chart

BOLT SIZE & PITCH	CLASS	NEWTON METERS (NM)		FOOT POUNDS (FT. LBS.)	
		PLATED	UNPLATED	PLATED	UNPLATED
M4 x .70	8.8	3.10	2.20	2.30	1.65
M5 x .80	8.8	6.10	5.50	4.58	4.13
M6 x 1.00	8.8	10.40	9.50	7.80	7.13
M7 x 1.00	8.8	17.00	15.50	12.75	11.63
M8 x 1.25	8.8	25.00	23.00	18.75	17.25
M8 x 1.00	8.8	27.00	24.50	20.25	18.38
M10 x 1.50	8.8	51.00	46.00	38.25	34.50
M10 x 1.25	8.8	54.00	49.00	40.50	36.75
M10 x 1.00	8.8	57.00	52.00	42.75	39.00
M12 x 1.75	8.8	87.00	79.00	65.25	59.25
M12 x 1.50	8.8	92.00	83.00	69.00	62.25
M12 x 1.25	8.8	96.00	87.00	72.00	65.25
M14 x 2.00	8.8	140.00	125.00	105.00	93.75
M14 x 1.50	8.8	150.00	135.00	112.50	101.25
M16 x 2.00	8.8	215.00	195.00	161.25	146.25
M18 x 2.50	8.8	300.00	280.00	225.00	210.00
M20 x 2.50	8.8	430.00	390.00	322.50	292.50
M22 x 2.50	8.8	580.00	530.00	435.00	397.50
M24 x 3.00	8.8	740.00	670.00	555.00	502.50
M6 x 1.00	10.9	15.50	14.00	11.63	10.50
M8 x 1.25	10.9	37.00	34.00	27.75	25.50
M10 x 1.50	10.9	75.00	68.00	56.25	51.00
M12 x 1.75	10.9	160.00	117.00	97.50	87.75
M14 x 2.00	10.9	205.00	185.00	153.75	138.75
M16 x 2.00	10.9	310.00	280.00	232.50	210.00

WARRANTY

Pequea Machine's Limited Warranty

Pequea Machine Company warrants to the original Purchaser all Machinery, Equipment, or Trailers manufactured by it, to be free from defects in material and workmanship under normal use and service. Its obligation under this Warranty shall be limited to replacement or repair of any parts thereof, free of charge to the original Purchaser, at its place of business, provided, however, that the part(s) to be replaced or repaired, shall within one (1) year after delivery to the original Purchaser, be demonstrated to be defective; which determination shall be made by the Company. The said components or parts must be returned through the Selling dealer or distributor directly to the Company with all transportation charges prepaid. Notice of defect shall be furnished in writing to the Seller and to the agent through whom the machinery was received, disclosing in full all known defects and failure in operation and use, and reasonable time shall be given to the Seller to remedy any such defects and failures. Failure to make such trial or give such notice shall be deemed an absolute acceptance by the Buyer and satisfaction in full of this Limited Warranty.

This Warranty does not cover, under any circumstances, any parts, components, or materials which, in the opinion of the Seller and Company, have been subjected to neglect, misuse, alteration, accident, or if repaired, with parts other than those manufactured by and obtained from Pequea Machine Company.

This Warranty does not cover components which are already covered by a separate Warranty provided by the supplier of said parts or components.

The Company's obligation under this Warranty is limited to repair or replacement, free of charge to the original Purchaser, of any part which in judgment of the Company is defective. This Warranty does not cover normal wear and tear.

THIS WARRANTY IS MADE EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY AND FITNESS FOR USE AND PURPOSE AND OF ALL OTHER OBLIGATIONS OR LIABILITIES ON ITS PART AND ANY IMPLIED WARRANTY. AND IT NEITHER ASSUMES NOR AUTHORIZES ANY OTHER LIABILITY IN CONNECTION WITH A SALE OF THIS MACHINE. THIS WARRANTY SHALL NOT APPLY TO THIS MACHINE OR TO ANY PART THEREOF WHICH HAS BEEN SUBJECT TO ACCIDENT, NEGLIGENCE, ALTERATION, ABUSE, OR MISUSE.

The Company makes no Warranty whatsoever in respect to accessories or parts not supplied by the Company. The term "original Purchaser" as used in this warranty, shall be deemed that person for whom the Machine, Equipment, or Trailer is originally supplied. This Warranty shall apply only within the boundaries of the continental United States.

Under this Warranty, the Company cannot guarantee that existing conditions beyond its control will not affect its ability to obtain materials or manufacture necessary replacement parts.

No one is authorized to alter, modify, or change the terms of this Warranty in any manner.

The Company warrants the Construction of the equipment sold herein and will replace at its expense for a period of (1) year from the date hereof, any parts which prove defective as determined under the terms of this Limited Warranty.

NOTES



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