

Form No.
909860
Revision B

1640

Forage Box



PARTS MANUAL

GEHL® AGRICULTURE

Introduction

When ordering service parts, specify the correct part number, full description, quantity required, the unit model number and serial number.

The model number and serial number for this unit are on a decal located on the left side of the box frame just forward of the chain reduction drives. “Right” and “left” are determined from a position standing at the rear of the unit and looking toward the direction of travel.

GEHL Company reserves the right to make changes or improvements in the design or construction of any part of the unit without incurring the obligation to install such changes on any previously delivered units.

Refer to the abbreviations table located on this page for the various fastener descriptions. Standard attaching hardware torque values are also provided on the inside back cover.

In the exploded view parts list, Reference Numbers may have additional information following the Reference Number.

Also, a number inside a hexagon will be the torque value required, in foot pounds, on the associated Reference Number. Items shown in the parts list that do not have Reference Numbers are shown for reference purposes only and are NOT available for purchase.

Unless otherwise specified, all cap screws or bolts are Grade 5, cadmium plated; hexagon nuts for Grade 5 screws or bolts are Grade B; hexagon nuts for other screws or bolts are Grade A.

NOTE: *The following abbreviations may be used herein:*

A/R	- As Required
ASSD	- Assembled
ASSY	- Assembly
CB	- Carriage Bolt
CCW	- Counterclockwise
CP	- Cotter Pin
CS	- Cap Screw (Hexagon Head)
CTR	- Center
CW	- Clockwise
DEG	- Degree
DIA	- Diameter
FCS	- Flanged Cap Screw
FHMS	- Flat Head Machine Screw
FL	- Flanged
FLN	- Flanged Lock Nut (Hexagon)
FLS	- Flanged Lock Screw (Hexagon)
FW	- Flat Washer
GA	- Gauge
GR	- Grade
HD	- Hard or Head
HN	- Hex Nut
INCL	- Includes
JT	- Joint
LG	- Large
LN	- Lock Nut
LW	- Lock Washer
LT	- Left
M	- Metric
MM/mm	- Millimeter
NF	- National Fine
PB	- Plow Bolt
PTO	- Power Take Off
RHMS	- Round Head Machine Screw
RPM	- Revolutions Per Minute
RT	- Right
SERR	- Serrated
SHCS	- Socket Head Cap Screw
SHSS	- Socket Head Set Screw
SN	- Serial Number or Slotted Nut
SQ	- Square
T	- Tooth or Teeth
TFS	- Thread Forming Screw
THMS	- Truss Head Machine Screw
THRD	- Thread
WLDMT	- Weldment
#	- Number
	- Torque required in foot pounds

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CHAPTER 1

DECAL LOCATIONS

GENERAL INFORMATION

Decal location information is provided to assist in the proper selection and application of new decals, in the event the original decals become damaged or the machine is repainted. Refer to the listing for the illustration reference number, part number, description and quantity of each decal provided in the kit. Refer to the appropriate illustrations for replacement locations.

NOTE: Refer to the SAFETY chapter of the Operator's Manual for the specific information provided on the various safety decals furnished in the decal kits.

To ensure proper selection of the correct replacement decals, compare the various location photographs to your machine before starting to refinish the unit. Then circle each pictured decal (applicable to your machine) while checking off its part number in the listing. After you have verified all the decals needed for replacement, place any unneeded decals aside for disposal.

NEW DECAL APPLICATION

Surfaces MUST be free from dirt, dust, grease and other foreign material before applying the new decal. To apply, remove the smaller portion of the decal backing paper and apply this part of the exposed adhesive backing to the clean surface while maintaining proper position and alignment. Peel the other portion of the backing paper off slowly while applying hand pressure to smooth out decal surface.



CAUTION

ALWAYS observe safety precautions on decals. If decals become damaged, or if the unit is repainted, replace the decals. If repainting, BE SURE that ALL decals from the kits that apply to your machine are affixed to your unit.

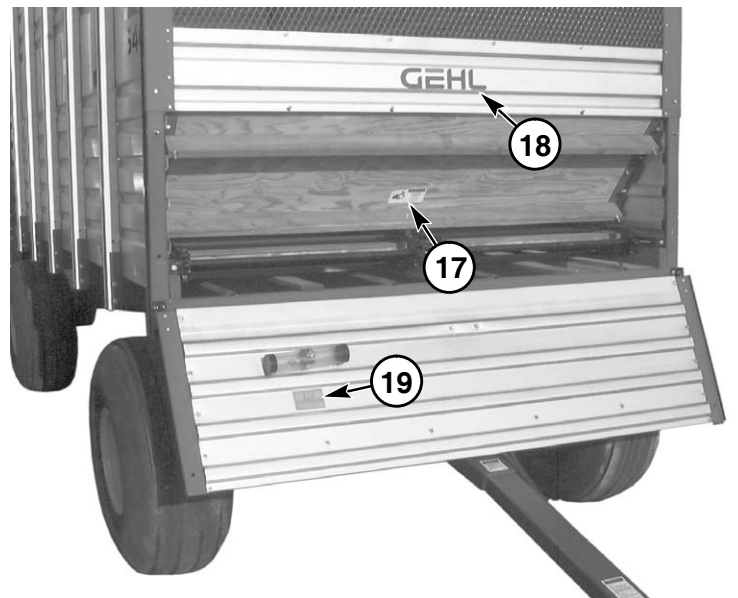
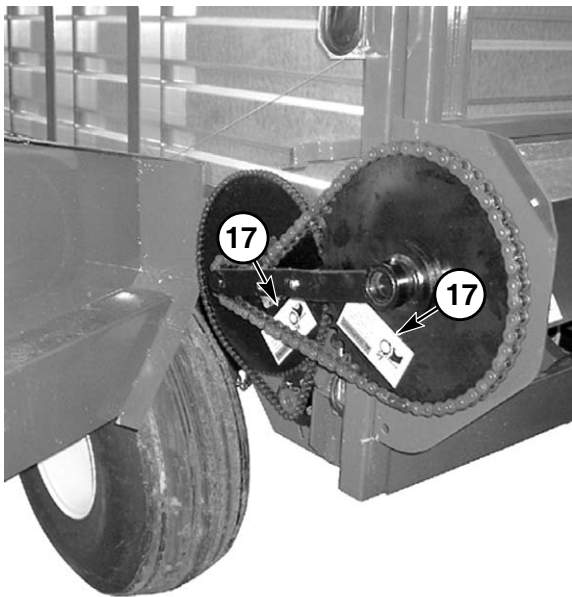
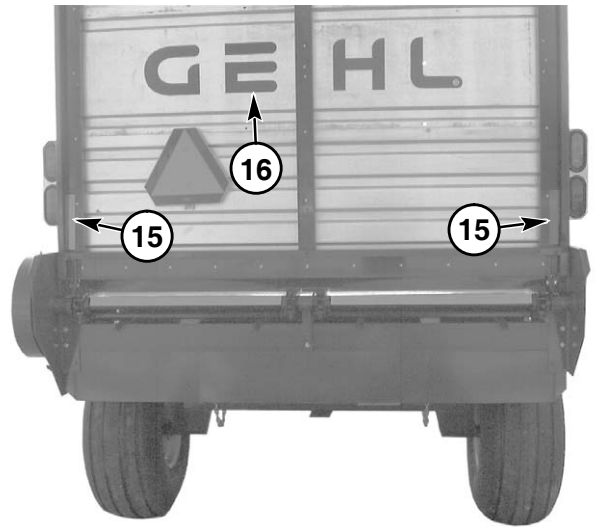
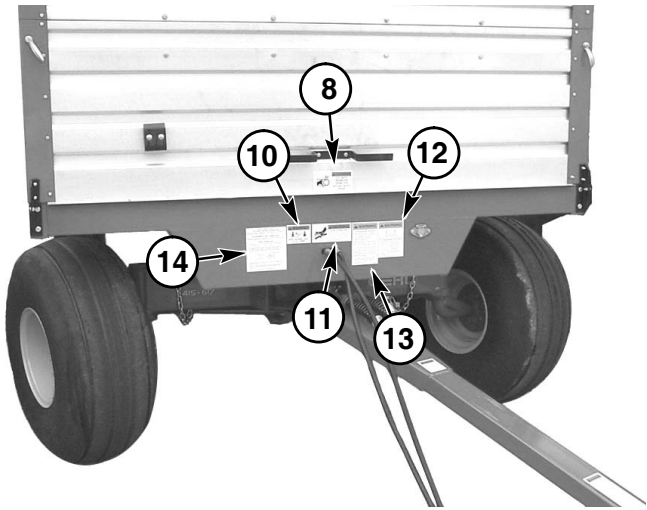
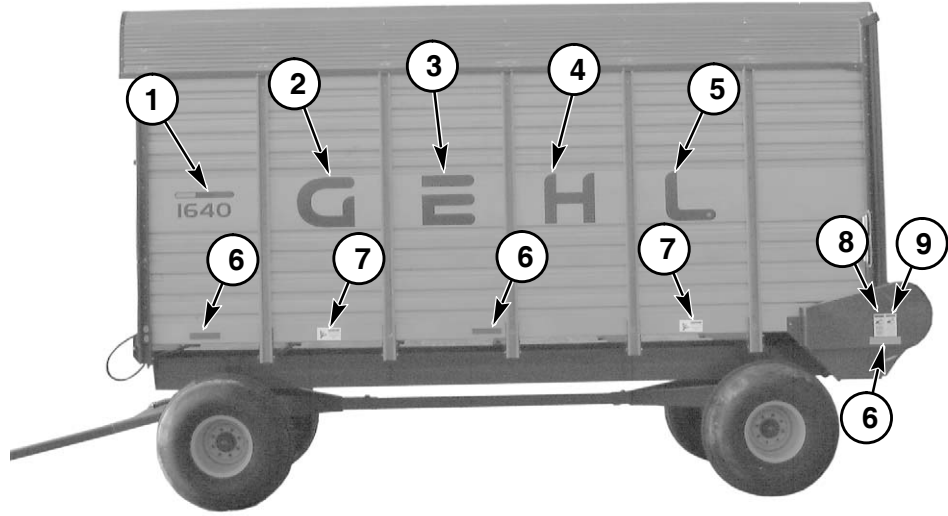
PAINT NOTICE

Use this list to order paint for refinishing:
906315 One Gal. AG Red
902872 One Qt. Light Grey
906316 6 (12 oz. Spray Cans) AG Red
902874 6 (12 oz. Spray Cans) Light Grey

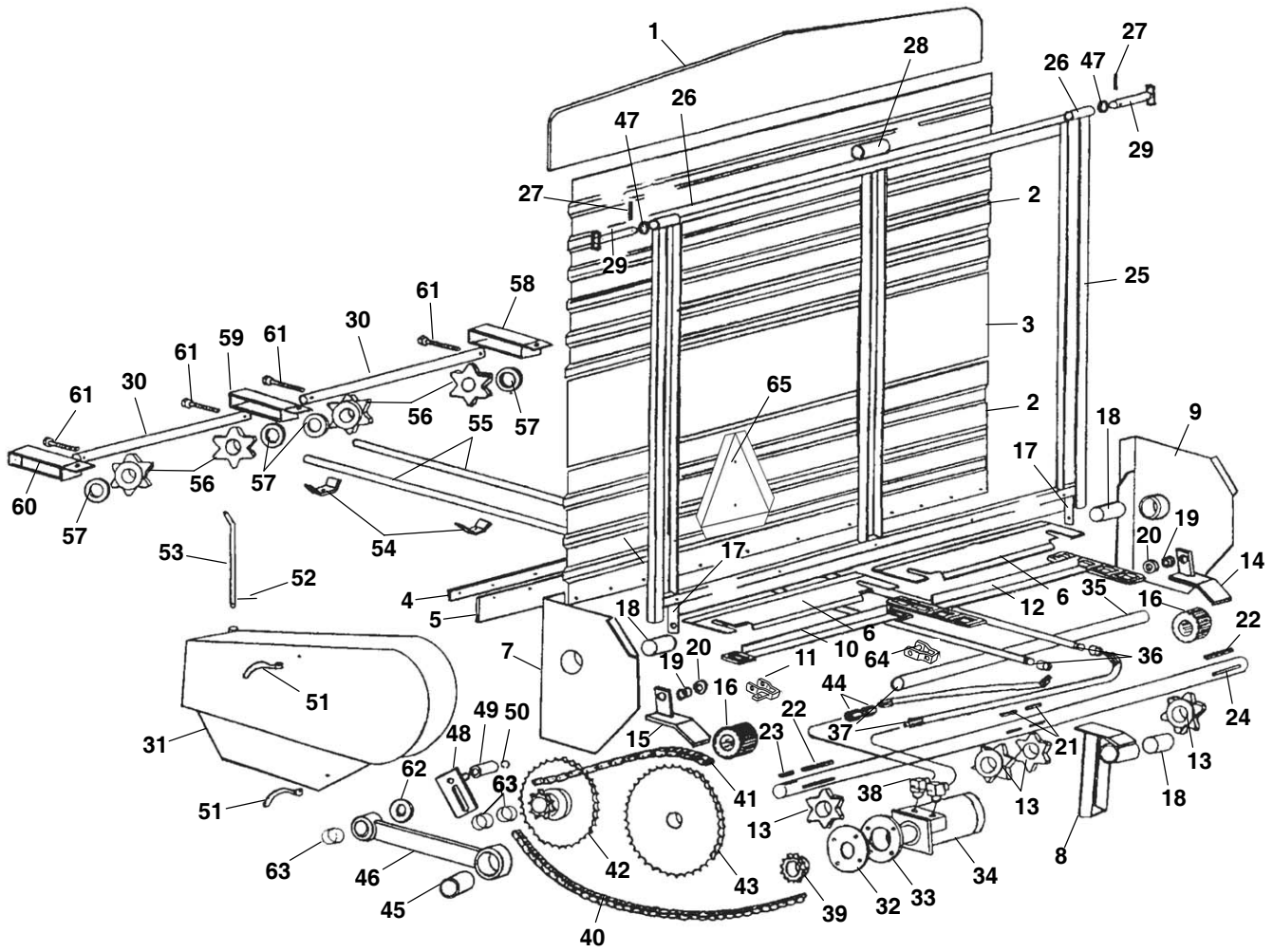
The decal set number for the 1640 Forage Box is 170506. The set includes the following:

Ref. Part

No.	No.	Description and Quantity
1	170317	1640 Label (2 Places)
2	094920	Decal - "G" (2 Places)
3	094921	Decal - "E" (2 Places)
4	094922	Decal - "H" (2 Places)
5	094923	Decal - "L" (2 Places)
6	145217	Amber Reflector (6 Places)
7	093444	WARNING - Moving Parts (4 Places)
8	163957	WARNING - Do Not Remove Shields (2 Places)
9	170534	WARNING - Do Not Clean
10	170531	WARNING - Keep Children Away
11	170532	WARNING - Stay Clear of Hydraulic Lines
12	093367	WARNING - Read Operator's Manual
13	093373	WARNING - Before Inspecting
14	170533	Decal - Field Operation
15	145216	Red Reflector (2 Places)
16	170357	Decal - GEHL
17	170520	WARNING - Do Not Operate (3 Places)
18	119661	Decal - GEHL
19	093366	Decal - Manual Location



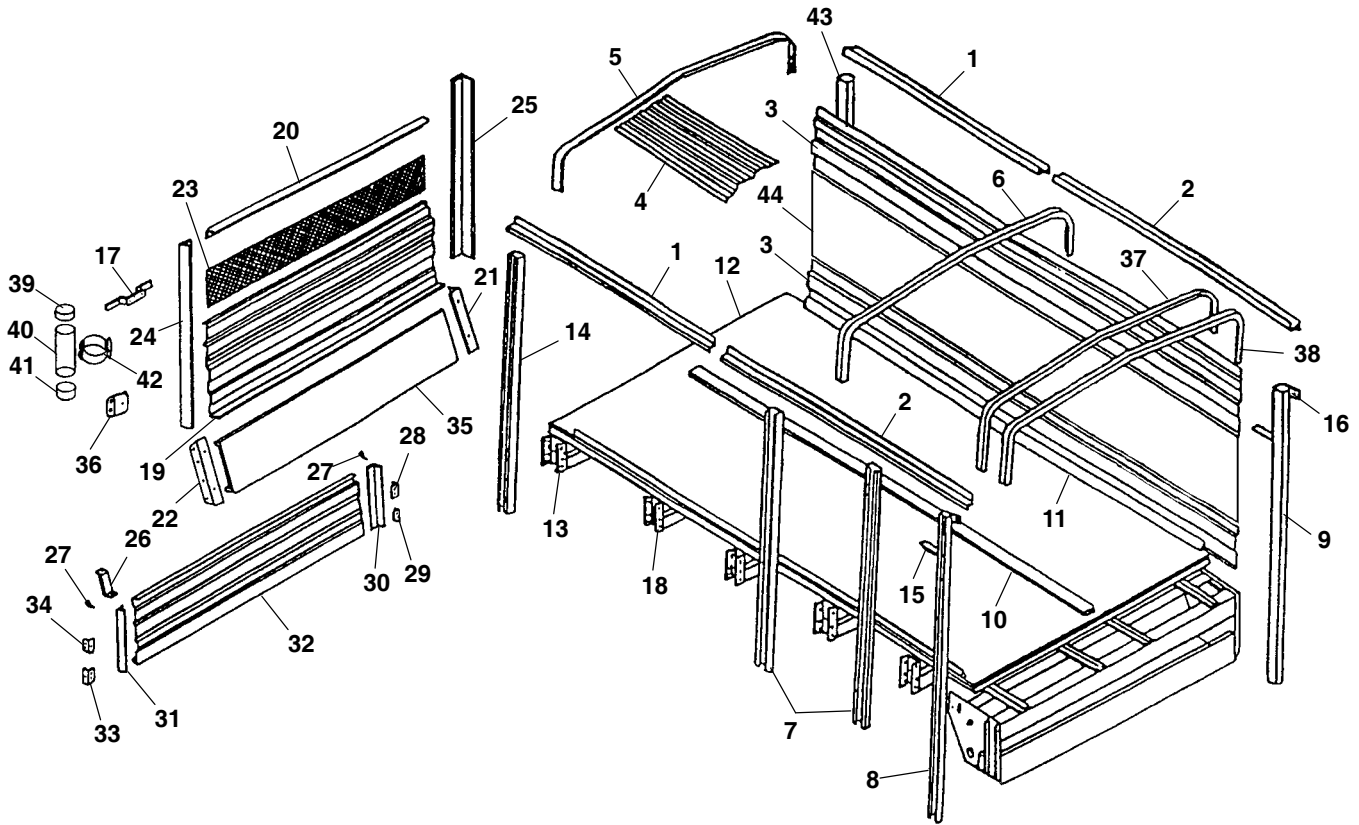
1640 - REAR UNLOAD ASSEMBLY



1640 - REAR UNLOAD ASSEMBLY

Ref. No.	Part No.	Description	Qty. Req.	Ref. No.	Part No.	Description	Qty. Req.
1	166388	TOP PANEL	1	32	166400	HYDRAULIC MOTOR MOUNT	1
2	166372	BACK DOOR STEEL	2	33	166399	HYDRCLC MOTOR MOUNT SPACER ...	1
3	166373	BACK DOOR CENTER (FLAT) STEEL ..	1	34	049073	HYDRAULIC MOTOR	1
4	166703	STRAP	1	35	166326	IDLER SHAFT	1
5	166376	RUBBER SEAL	1	36	660027	1/2 PIPE COUPLER	2
6	166390	DRIVE SHAFT PANEL	2	37	166109	1/2 HOSE X 60	2
7	166392	LH DRIVE SHAFT MOUNT	1	38	058654	1/2 STREET ELBOW	2
8	166393	CENTER BEARING MOUNT	1	39	166082	13T SPROCKET	1
9	166394	RH DRIVE SHAFT MOUNT	1	40	074879	ROLLER CHAIN #50 X 90 LINKS	1
10	166189	SLAT W/667H PINTLE ATT. LINKS AR (18' BOX: 20 PER APRON, 40 TOTAL) (20' BOX: 22 PER APRON, 44 TOTAL)		41	082023	ROLLER CHAIN #80 X 73 LINKS	1
				42	166120	84 TOOTH SPROCKET (50A84)	1
				43	166119	52 TOOTH SPROCKET (80B52)	1
11	058620	LINK/ATTACHMENT	AR	44	067457	1/2 CHECK VALVE	1
12	166178	667H COMPLETE APRON 18'	2	45	166880	BUSHING	1
		(190 LINKS PER STRAND)		46	166401	DRIVE SHAFT BRACE	1
	166391	667H COMPLETE APRON 20'	2	47	166336	COLLAR	2
		(211 LINKS PER STRAND)		48	166200	CHAIN TIGHTENER BRACKET	1
13	166068	DRIVE SHAFT SPROCKETS	4	49	166203	ROLLER CHAIN TIGHTENER	1
14	166377	LATCH BRACKET-R.H.	1	50	166059	RING/SNAP	1
15	166378	LATCH BRACKET-L.H.	1	51	166650	HANDLE NUTS	2
16	166116	LATCH SPROCKET	2	52	651160	CP EPSC 5/32X1-1/2	1
17	166379	LATCH PLATE	2	53	166320	HINGE PIN	1
18	166201	DRIVE SHAFT BUSHING	3	54	166073	HOSE HOLDER	4
19	166380	LATCH PIVOT	2	55	166360	HYDRAULIC PIPE	2
20	166217	LATCH WASHER	2	55	166322	HYDRAULIC PIPE 18'	2
21	056230	KEY 3/8 SQUARE X 2 LONG	2	56	166885	REAR IDLER SPROCKET	4
22	166100	KEY 3/8 SQ. X 4-3/8	2	57	166886	IDLER SHAFT SPACER	4
23	166111	KEY 3/8 X 2-1/4	1	58	166810	LH REAR IDLER BRACKET	1
24	166367	REAR DRIVE SHAFT (STRESSPROOF)	1	59	166812	CENTER IDLER BRACKET	1
25	166389	BACK DOOR FRAME WORK	1	60	166813	RH REAR IDLER BRACKET	1
26	166381	HINGE PIPE	2	61	166084	CS 1/2-13 X 9-1/2	4
27	116353	SPIRAL PIN	2	62	166342	WASHER	1
28	166382	GUARD	1	63	166099	BUSHING 1-1/2 OD X 1-1/4 ID	1
29	166335	HINGE PIN	2	64	058621	LINK/PINTLE CHAIN	AR
30	166811	REAR IDLER SHAFT	2	65	145235	SMV MARKER/MOUNTED	1
31	166402	REAR DRIVE SHIELD	1				

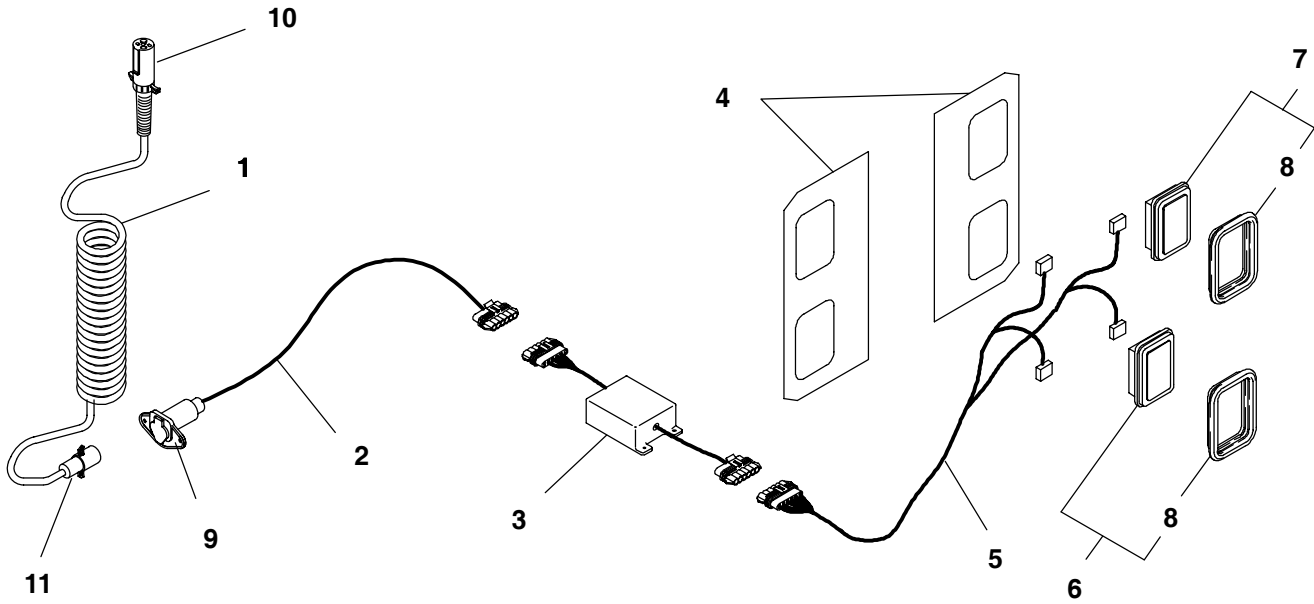
1640 - BOX COMPONENTS



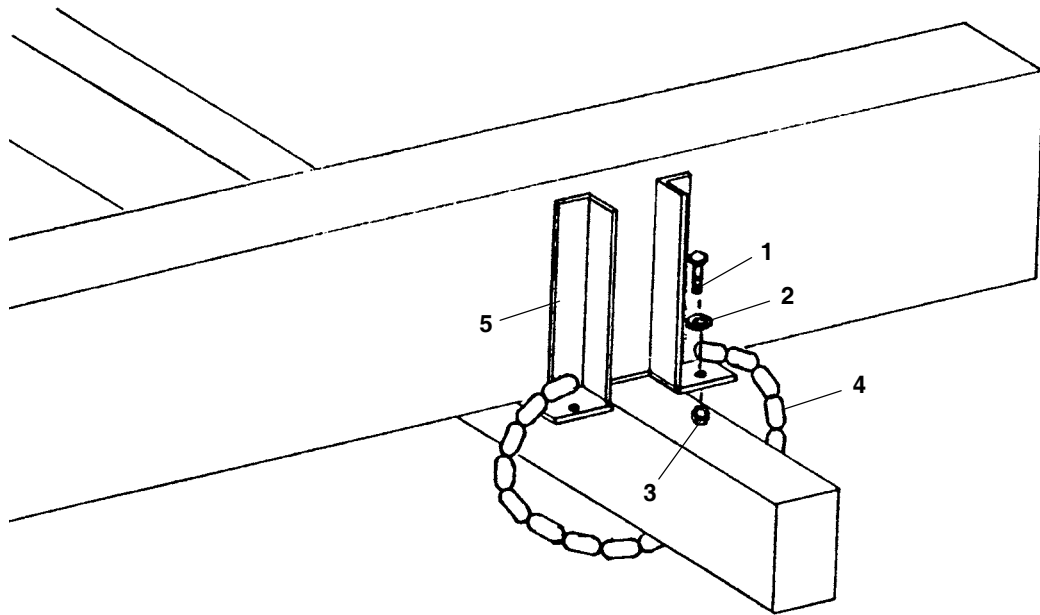
1640 - BOX COMPONENTS

Ref. No.	Part No.	Description	Qty. Req.	Ref. No.	Part No.	Description	Qty. Req.
1	166618	ROOF SILL BACK SECTION (18')	2	19	166386	FRONT DOOR BOTTOM STEEL	1
	166709	ROOF SILL BACK SECTION (20')	2	20	166375	TOP RAIL	1
2	166615	ROOF SILL FRONT SECTION (18')	2	21	166365	BARGE BOX SHELF ANGLE	1
	166710	ROOF SILL FRONT SECTION (20')	2	22	166369	BARGE BOX SHELF ANGLE	1
3	166622	SIDE STEEL 214-1/2 X (18')	4	23	166385	EXPANDED METAL	1
	166712	SIDE STEEL 238-1/2 X (20')	4	24	166337	FRONT LH SIDE PIECE	1
4	166625	ROOF STEEL (18')	6	25	166338	FRONT RH SIDE PIECE	1
	166714	ROOF STEEL (20')	6	26	166649	SLANT PANEL BRACE	1
5	166842	BRANCH GUARD (18')	1	27	166650	HANDLE NUTS	2
6	166841	ROOF SUPPORT (18')	5	28	166651	LH HINGE TOP PIECE	1
		ROOF SUPPORT (20')	6	29	166652	RH STAKE HINGE	1
7	166836	SIDE STAKE (18')	10	30	166653	TAILGATE LH SIDE PIECE	1
		SIDE STAKE (20')	12	31	166654	TAILGATE RH SIDE PIECE	1
8	166383	LH REAR STAKE	1	32	166655	TAILGATE STEEL	1
9	166384	RH REAR STAKE	1	33	166656	RH HINGE BOTTOM PIECE	1
10	166631	APRON CHAIN CENTER SPACER (18')	1	34	166657	RH HINGE TOP PIECE	1
	166715	APRON CENTER SPACER (20')	1	35	166374	FRONT SLANT PANEL	1
11	166634	APRON CHAIN SIDE SPACER (18')	2	36	166093	HOSE COUPLING HOLDER	1
	166716	APRON SIDE SPACER (20')	2	37	166672	REAR ROOF SUPPORT (HIGH SIDED)	1
12	166637	FLOOR ASSEMBLY (18')	1	38	166772	REAR BRANCH GUARD	1
	166717	FLOOR ASSEMBLY (20')	1	39	166780	CAP-NO HOLE	1
13	166695	BACK STAKE POCKET	2	40	166781	CLEAR TUBE	1
14	166837	LH BACK STAKE	1	41	166783	CAP W/HOLE	1
15	166387	BRACE	2	42	166935	CLAMP	1
16	166333	DOOR HINGE	2	43	166838	RH BACK STAKE	1
17	166106	HOSE HOLDER	1	44	166936	SIDE CENTER PANEL 214-1/2 (18')	2
18	166694	STAKE POCKET (18')	10		166937	SIDE CENTER PANEL 238-1/2 (20')	2
		STAKE POCKET (20')	12				

1640 - LIGHTS



Ref. No.	Part No.	Description	Qty. Req.	Ref. No.	Part No.	Description	Qty. Req.
1	119514	RETRACTABLE CORD	1	6	166199	RED LIGHT	2
		(ACCESSORY OPTION)		7	166198	AMBER LIGHT	2
2	166965	FRONT HARNESS	1	8	166720	RUBBER LIGHT MOUNT	4
3	170670	LIGHTING MODULE	1	9	059060	4 WAY SOCKET	1
4	166329	LIGHT BRACKET	2	10	112917	PLUG/ 7-PIN W/CABLE	1
5	170673	Y CONNECT HARNESS	1	11	059070	PLUG/4 WAY TRAILER	1



Ref. No.	Part No.	Description	Qty. Req.	Ref. No.	Part No.	Description	Qty. Req.
1	650453	CS 1/2X1-1/2	8	4	166726	1/4 TIE DOWN CHAIN	4
2	651148	FW 1/2	8	5	166727	TIE DOWN BRACKET	4
3	071706	LN T 1/2	8				

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1640 - NUMERICAL INDEX







Part No.	Page No.	Ref. No.	Part No.	Page No.	Ref. No.	Part No.	Page No.	Ref. No.	Part No.	Page No.	Ref. No.
049073	05	34	166120	05	42	166387	07	15	166716	07	11
056230	05	21	166178	05	12	166388	05	01	166717	07	12
058620	05	11	166184	05	11	166389	05	25	166720	08	08
058621	05	64	166189	05	10	166390	05	06	166726	09	04
058654	05	38	166198	08	07	166391	05	12	166727	09	05
059060	08	09	166199	08	06	166392	05	07	166772	07	38
059070	08	11	166200	05	48	166393	05	08	166780	07	39
067457	05	44	166201	05	18	166394	05	09	166781	07	40
071706	09	03	166203	05	49	166399	05	33	166781	07	42
074879	05	40	166217	05	20	166400	05	32	166783	07	41
082023	05	41	166320	05	53	166401	05	46	166810	05	58
093366	02	19	166322	05	55	166402	05	31	166811	05	30
093367	02	12	166324	08	04	166615	07	02	166812	05	59
093373	02	13	166326	05	35	166618	07	01	166813	05	60
093444	02	07	166333	07	16	166622	07	03	166836	07	07
094920	02	02	166335	05	29	166625	07	04	166837	07	14
094921	02	03	166336	05	47	166631	07	10	166838	07	43
094922	02	04	166337	07	24	166634	07	11	166841	07	06
094923	02	05	166338	07	25	166637	07	12	166842	07	05
112917	08	10	166342	05	62	166649	07	26	166880	05	45
116353	05	27	166360	05	55	166650	05	51	166885	05	56
119514	08	01	166365	07	21	166650	07	27	166886	05	57
119661	02	18	166367	05	24	166651	07	28	166936	07	44
145216	02	15	166369	07	22	166652	07	29	166937	07	44
145217	02	06	166372	05	02	166652	07	29	166937	07	44
163957	02	08	166373	05	03	166653	07	30	166965	08	02
166059	05	50	166374	07	35	166654	07	31	170317	02	01
166068	05	13	166375	07	20	166655	07	32	170357	02	16
166073	05	54	166376	05	05	166656	07	33	170520	02	17
166082	05	39	166377	05	14	166657	07	34	170531	02	10
166084	05	61	166378	05	15	166672	07	37	170532	02	11
166093	07	36	166379	05	17	166694	07	18	170533	02	14
166099	05	63	166380	05	19	166695	07	13	170534	02	09
166100	05	22	166381	05	26	166703	05	04	170670	08	03
166106	07	17	166382	05	28	166709	07	01	170671	08	05
166109	05	37	166383	07	08	166710	07	02	650453	09	01
166111	05	23	166384	07	09	166712	07	03	651148	09	02
166116	05	16	166385	07	23	166714	07	04	651160	05	52
166119	05	43	166386	07	19	166715	07	10	660027	05	36

NOTES

TORQUE SPECIFICATIONS

NOTE: Use these torque values when tightening **GEHL** hardware (excluding: Locknuts and Self-tapping, Thread Forming and Sheet Metal Screws) unless specified otherwise.

**All torque values are in Lb-Ft except those marked with an * which are Lb-In
(For metric torque value Nm, multiply Lb-Ft value by 1.355 or Lb-In value by 0.113)**

Unified National Thread	Grade 2 		Grade 5 		Grade 8 	
	Dry	Lubed	Dry	Lubed	Dry	Lubed
8-32 8-36	19* 20*	14* 15*	30* 31*	22* 23*	41* 43*	31* 32*
10-24 10-32	27* 31*	21* 23*	43* 49*	32* 36*	60* 68*	45* 51*
1/4-20 1/4-28	66* 76*	50* 56*	9 10	75* 86*	12 14	9 10
5/16-18 5/16-24	11 12	9	17 19	13 14	25	18 20
3/8-16 3/8-24	20 23	15 17	30 35	23 25	45 50	35
7/16-14 7/16-20	32 36	24 27	50 55	35 40	70 80	55 60
1/2-13 1/2-20	50 55	35 40	75 90	55 65	110 120	80 90
9/16-12 9/16-18	70 80	55 60	110 120	80 90	150 170	110 130
5/8-11 5/8-18	100 110	75 85	150 180	110 130	220 240	170 180
3/4-10 3/4-16	175 200	130 150	260 300	200 220	380 420	280 320
7/8-9 7/8-14	170 180	125 140	430 470	320 360	600 660	460 500
1-8 1-14	250 270	190 210	640 710	480 530	900 1000	680 740
Metric Course Thread	Grade 8.8 		Grade 10.9 		Grade 12.9 	
	Dry	Lubed	Dry	Lubed	Dry	Lubed
M6-1	8	6	11	8	13.5	10
M8-1.25	19	14	27	20	32.5	24
M10-1.5	37.5	28	53	39	64	47
M12-1.75	65	48	91.5	67.5	111.5	82
M14-2	103.5	76.5	145.5	108	176.5	131
M16-2	158.5	117.5	223.5	165.5	271	200

GEHL®

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