


safety precautions:


 Improper use of the tractor and loader can result in injury. To reduce this possibility, give complete and undivided attention to the job at hand, and follow these safety precautions.

PREPARATION

Know your controls. Read this operator's manual and the manual provided with your tractor. Learn how to stop the tractor, the engine, and the loader quickly in an emergency.

Do not allow children to operate the tractor or the loader. Do not allow adults to operate this equipment without proper instruction.

Keep children and pets a safe distance from the operation.

 **CAUTION** - DISCONNECT the rear attachment powershaft from the tractor PTO shaft, when using the loader, if the rear PTO driven attachment is mounted on the tractor.

Always wear snug fitting and belted clothing when operating the tractor and loader. Loose jackets, shirts, sleeves, or other loose clothing should not be worn because of the danger of it catching in moving parts or in the controls.

Do not allow anyone other than the operator on tractor when it is in operation.

Always be sure the area is clear of people, pets, and debris before operating the tractor and loader.

Do not let anyone ride in the bucket or the ballast box of the tractor.

Do not exceed a ground speed of three miles per hour when transporting a load.

Carry the bucket low at all times except when loading or unloading.

Never use the loader as a battering ram.

Drive the tractor at a slow ground speed when operating the loader over rough terrain, especially when operating at, or near, maximum lift height.

Always remain at the controls when operating the loader. Lower the bucket to the ground when it is unattended.

Take extra precautions when working in areas where wheel clearance or lift clearance is limited. Drive slowly through narrow gate and doorways.

Never operate the loader without the minimum recommended rear ballast.

Read and follow the instructions shown on the decals attached to the loader.



CAUTION

1. Add recommended wheel ballast or rear weight for stability.
2. Move wheels to widest recommended settings to increase stability.
3. Move and turn tractor at low speeds.
4. In transport carry the working unit low.
5. Lower loader arms when parked.
6. Before servicing or adjusting equipment:
 - a. Lower working unit to the ground.
 - b. Shut off engine.
7. Relieve hydraulic pressure before disconnecting oil lines.
8. Observe safety recommendations in loader operator's manual.

KUBOTA TRACTOR
B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
Figure: 2 - SAFETY PRECAUTIONS/TO THE PURCHASER/OPERATION

Safety Precautions - continued

Check hydraulic system before each use. Escaping hydraulic fluid, under pressure, can have sufficient force to penetrate the skin and cause serious injury.

MAINTENANCE AND STORAGE

Prevent accidental operation of the tractor or loader. Always lower the loader to the ground, stop the tractor engine and remove the ignition key, when dismounting from the tractor or, before making adjustments to the tractor or the loader.

Never touch the engine parts after operating the tractor, or engine, until the parts have had sufficient time to cool.


Always keep the positive battery post covered with rubber boot on the end of the cable.

Never operate the tractor engine in a closed building where carbon monoxide fumes can collect.

Always maintain the tractor and loader properly. Check all fasteners, guards, hoses, and other parts frequently. Built-in safety features are effective only if maintained.

To the Purchaser:

Read this operator's manual before using the loader. You will be able to do a safer, better job.

 This safety alert symbol identifies important safety messages in this manual. When you see this symbol be alert to the possibility of injury and carefully read the message that follows it.

Right-hand (RH) and left-hand (LH) references are determined by standing at the rear of the tractor and loader and facing the direction of forward travel. After you have read this manual thoroughly, keep it handy for ready reference. When in need of parts and major service, see your authorized loader dealer. For prompt, efficient service give your dealer both the tractor and loader serial numbers.

Record the loader model number, serial number, and the date of purchase below.

Model _____ Serial _____ Date _____

Operation:

PREPARING THE TRACTOR:

Position the rear tractor wheels in the wide tread position. **IMPORTANT** - Rear tractor wheels must be set in the wide position for maximum stability.

Have your tractor dealer fill each rear tire 75% full of a calcium chloride and water solution. This will add approximately 100 pounds of weight per tire.

Mount a Ballast Box to the rear of the tractor and add 150 to 200 pounds of weight needed to counter-weight the tractor when using the loader. Increase or decrease the ballast so that the weight on the tractor rear axle, with the loader bucket raised to a three foot height, does not exceed the tractor recommended load rating on the rear axle or add the equivalent amount of counter-balance. See your tractor dealer for tractor specifications.


IMPORTANT - Damage to the tractor may occur if this weight is exceeded.

PRE-STARTING INSPECTION:

IMPORTANT - Before using the loader the first time, make sure it has been properly installed on the tractor. See the Assembly instructions. Make sure the loader has been properly installed if it has been removed to use the tractor for other work.

1. Check the loader hydraulic reservoir oil level, see Maintenance. Because the loader hydraulic system is independent from the tractor hydraulic system, damage could occur if the loader pump is operated before the loader is completely assembled or installed and the loader hydraulic reservoir is filled.

2. Check the loader hydraulic system for leaks.

 **CAUTION** - Escaping fluid, under pressure, can have sufficient force to penetrate the skin causing serious injury. Before disconnecting the lines be sure to relieve all pressure. Before applying pressure to the system, be sure all connections are tight and that the lines, pipes, and hoses, are not damaged. Fluid escaping from a very small hole can be almost invisible. Use a piece of

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B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
Figure: 3 - OPERATION/OPERATING THE LOADER

Operation - continued

cardboard or wood, rather than hands, to search for suspected leaks.

⚠ CAUTION - DISCONNECT the rear attachment powershaft from the tractor PTO shaft, when using the loader, if the rear PTO driven attachment is mounted on the tractor.

3. Refer to the tractor operator's manual and perform all the "Before Starting The Engine" checks.

4. Read and understand this operator's manual and the safety instructions it contains before operating the tractor and loader.

IMPORTANT - Never operate the loader unless the tractor engine is running and the loader hydraulic pump is operating. If the tractor engine has been stopped with the bucket in the raised position, start the tractor engine before attempting to lower the bucket to the surface. If the bucket is lowered without the loader hydraulic pump operating, the hydraulic oil lines will fill with air. This will cause jerky loader operation and oil will be forced out of the hydraulic reservoir breather.

⚠ CAUTION - Operate the loader only when sitting on the tractor seat; never while standing beside the loader. Before operating the loader, be sure no one is standing near it.

Start the tractor engine and allow it to warm up as instructed in the tractor operator's manual.

Operating The Loader:

THROTTLE LEVER (ENGINE SPEED)

Position the tractor throttle lever to operate the engine at half to full throttle. If the tractor engine is operated at less than half speed, the loader hydraulic pump will not displace oil fast enough. This will cause oil to be forced out of the breather on top of the hydraulic oil reservoir.

BOOM CONTROL LEVER

Move the inside boom control lever rearward to raise the boom, or forward to lower the boom to the desired height. The further the lever is moved, the faster the boom moves. The lever will return to "neutral" position when released.

FLOAT POSITION

Moving the inside boom control lever past the "lower" position allows the bucket to float. This is helpful when leveling or cleaning. The lever must be manually returned to neutral.

BUCKET CONTROL LEVER

Move the outside bucket control lever forward to dump the bucket; move the lever rearward to retract the bucket. Hold the lever until the bucket reaches the desired position. The lever will return to "neutral" position when released.

IMPORTANT - To assure smooth operation, especially in cold weather, operate the boom and bucket control levers simultaneously (to raise the boom and tilt the bucket) several times to warm the oil in the loader hydraulic system. The tractor engine must be running at half throttle or more, and the PTO clutch control lever must be engaged.

Do not operate the tractor at high ground travel speeds. The tractor ground travel speed should never exceed three miles per hour when carrying a load.

⚠ CAUTION - Always operate the tractor and loader at a slow ground travel speed when crossing rough terrain or when passing through narrow gates and doorways. This is especially true when operating the loader at, or near, the maximum lift height capacity.

Lower the loader into digging position by moving the boom control lever forward. Level the bucket with the bucket control lever.

Observe the position of the bucket level indicator rod. The indicator rod is used to determine if the bucket is level when the boom is in the lowered position.

When the bucket is level, the indicator rod should be flush with the top of the indicator tube.

For most effective digging, drive the tractor straight into the pile.

For easier filling, force the bucket into the pile. Raise the bucket about six inches, then drop the bucket and drive forward. Repeat this procedure until the bucket is filled.

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B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
Figure: 4 - OPERATING THE LOADER/MAINTENANCE

Operating The Loader - continued

When moving large piles, remove the top levels first.

When using the loader on a sloping area; approach the load moving uphill, then back slowly away down the slope.

⚠ CAUTION - Operating across the slope with a loader could result in the tractor and loader tipping over.

TRANSPORTING AND DUMPING LOADS

Raise the boom while approaching the dumping area by moving the boom control lever rearward.

When the bucket is high enough so that it will not strike objects around the dumping site, move the bucket control lever forward to dump the bucket.

Keep the bucket as level as possible when operating at, or near maximum height. This will prevent spilling material from the bucket onto the tractor.

Lower a heavy load slowly. Stopping a heavy load suddenly, after it has gained downward momentum, may result in damage to the loader or the tractor.

STOPPING THE TRACTOR AND LOADER

Park the tractor. Always lower the boom and bucket to the surface. Disengage the PTO clutch control lever, shut off the tractor engine and remove the ignition key before dismounting from the tractor to prevent unauthorized operation.

⚠ CAUTION - Always lower the boom and bucket to the ground before dismounting from the tractor. Remove the ignition key.

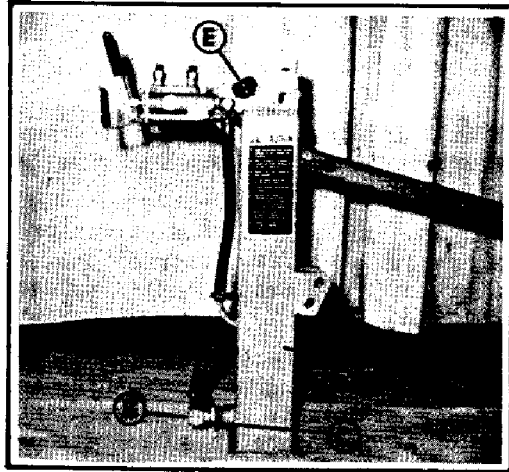
Maintenance:

⚠ CAUTION - Before adjusting, lubricating or servicing the loader, lower the boom and bucket to the ground. Disengage the PTO clutch control lever, shut off the tractor engine, set the parking brake and remove the ignition key.

BOLTS

For maximum life and optimum performance, check the loader mounting bolts periodically. Through constant operation, bolts can loosen causing excessive wear and premature failure of parts. Keep bolts tight.

CHANGING HYDRAULIC RESERVOIR OIL AND CLEANING THE OIL STRAINER



A - Low Pressure Hose D - Reservoir
B - Fitting E - Breather
C - Screen Strainer

After the first two hours of operation, and every 200 hours thereafter, remove low pressure hose (A), fittings (B), and screen strainer (C) from reservoir (D). Drain oil from reservoir (D) into a container and discard.

Flush reservoir and clean screen. Reassemble screen, fittings, and hose.

Remove breather (E), and fill reservoir (D) with a good quality 10W30 MS engine oil or an equivalent Type "F" Automotive Automatic Transmission Fluid.

Oil level should be approximately four inches below breather hole in reservoir, with all cylinders retracted (loader and bucket in lowered position).

The hydraulic reservoir capacity is approximately five U.S. quarts.

CHECKING HYDRAULIC RESERVOIR OIL LEVEL

Once a month or every 50 hours of operation, check the hydraulic reservoir (D) oil level.

Remove breather (E) on top of reservoir (D) to check oil level. Oil level should be approximately four inches below the breather hole in the reservoir, with all cylinders retracted (loader and bucket in lowered position).

KUBOTA TRACTOR
B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
Figure: 5 - MAINTENANCE/TROUBLE SHOOTING/REMOVING THE LOADER

Maintenance - continued

If hydraulic oil is required, use a good quality 10W30 MS engine oil or an equivalent Type "F" Transmission Fluid.

LUBRICATING GREASE FITTINGS

Once a month or every 50 hours of operation, whichever comes first, lubricate the eight grease fittings; four on each side of the loader.

| Quantity | Location of Grease Fittings |
|----------|-----------------------------|
| 4 | Loader Boom Frame Bushings |
| 2 | Boom Frame Cylinders |
| 2 | Tilt Cylinders |

Use a SAE multi-purpose type grease.

HYDRAULIC CYLINDERS

Hydraulic cylinder service normally consists of replacing O-rings and packings to stop leakage. If service is required, see your loader dealer. Special tools are required to service the cylinders.

HYDRAULIC PUMP AND CONTROL VALVE

Special tools are required to service the hydraulic pump and control valve. If trouble indicates pump or valve failure, do not attempt repairs. Ask your loader dealer to inspect and service the hydraulic system.

Trouble Shooting:

LOADER OPERATES ERRATICALLY

Hydraulic oil level low. Check oil level, see Maintenance.

Obstructions in hydraulic oil lines, hoses, and screen strainer. Service screen strainer and change hydraulic oil at prescribed service intervals. See Maintenance.

Vee belt driving loader pump slipping, tighten belt.

Hydraulic oil leakage. Check to be sure hydraulic hoses and fittings are tight and not leaking oil. See Safety Precaution on Page 2, for the proper way to check for leakage.

Tractor engine RPM too low. Always operate tractor engine at half to full throttle.

Hydraulic pump, valve, or cylinder seals need servicing. See your loader dealer.

LOADER WILL NOT OPERATE

Bucket is over-loaded, maximum 500 lbs.

Hydraulic oil level low. Check oil level, see Maintenance.


Hydraulic hoses assembled incorrectly, see Assembly.

Vee belt driving loader pump slipping, tighten belt.

Key on hydraulic pump shaft missing, see Assembly.

Obstructions in hydraulic oil lines, hoses, and screen strainer. Service screen strainer and change hydraulic oil at prescribed service intervals, see Maintenance.

Removing The Loader:

 **CAUTION** - Before attempting to remove the loader from the tractor; lower loader to the ground, disengage PTO clutch control lever, stop tractor engine, set parking brake, and remove ignition key.


1. Relieve pressure in hydraulic lines by actuating loader valve controls several times with the loader lowered to the ground and the tractor engine stopped.

2. Disconnect both the pressure and return hydraulic hoses at the control valve.

IMPORTANT - Plug both valve ports and cap both hoses to keep clean during storage.

3. Remove the upright without the valve installed.

4. Remove the upright with the valve installed and the lift frame as one unit. This will allow the removal and reassembly without disconnecting the hydraulic oil lines each time.

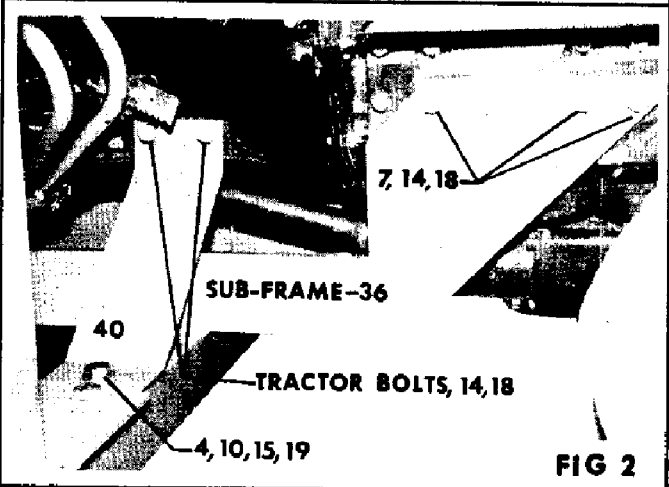
 **CAUTION** - Since the loader is heavy use a lifting device such as a hydraulic or electric hoist to remove the loader frame, with boom and bucket, from the tractor.

5. Remove the pump mount assembly.

6. Remove all remaining loader components from the tractor.

Assembly:

1. Rear Frame Installation, Fig 1 and 2:



A. Remove three M12 x 1.75 x 50 bolts from each side of the tractor rear axle housing and three M10 x 1.25 x 20 bolts from each side of the tractor frame to facilitate mounting the loader sub-frame (36).

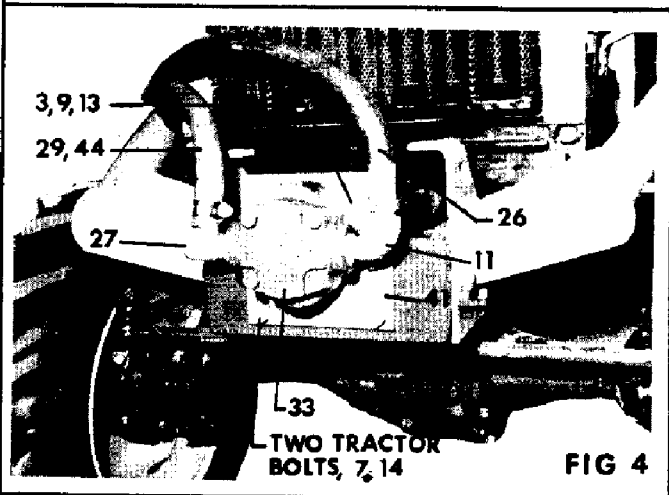
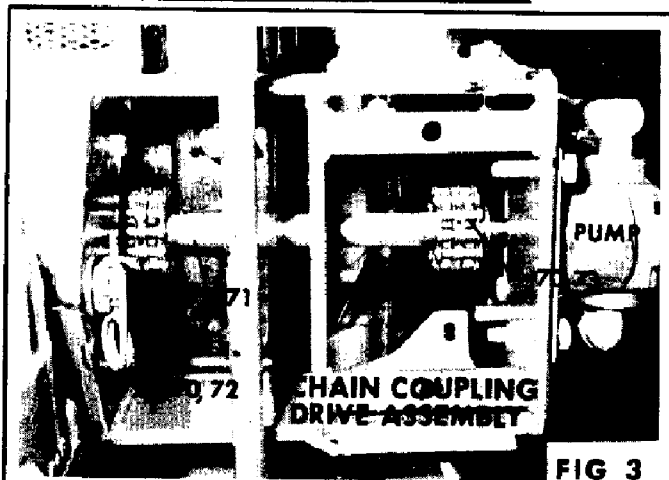
B. Install the loader sub-frame (36) to the rear axle housing using six M12 x 1.75 x 60 bolts and six 1/2 lockwashers (6, 15).

C. Install the loader sub-frame to the tractor side frame using six M10 x 1.25 x 35 bolts, six 7/16 lockwashers and flat washers (7, 14, 18).

D. Install the loader side reinforcing plates (40) to the side of the tractor using four M10 x 1.25 x 20 tractor bolts (removed in step 1), four 7/16 lockwashers, and flat washers (14, 18).

Secure the reinforcing plates to the loader cross angle using two 1/2 NC x 1-1/4 bolts, nuts, lockwashers, and flat washers (4, 10, 15, 19).

2. Pump Installation, Fig 3 and 4:



A. Loosen the two bolts that retain the tractor radiator so that the radiator can be raised slightly.

B. Slide the chain coupling drive assembly onto the tractor PTO shaft as shown.

C. Install the pump mount plate (41) to the tractor front bumper using the remaining two M10 x 1.25 x 20 tractor bolts (removed in step 1), two M10 x 1.25 x 35 bolts supplied with the loader, and four 7/16 lockwashers (7, 14).

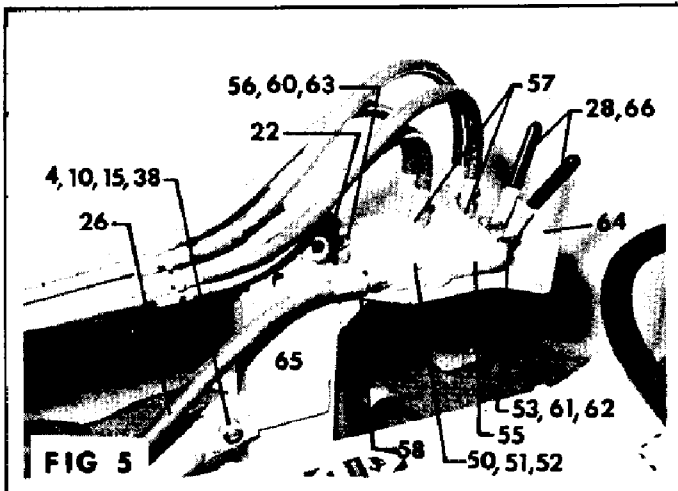
D. Slide the pump shaft, with the key, into the chain coupling sprocket and secure the pump (33) to the pump plate using two 3/8 NC x 1-1/4 carriage bolts, nuts, and lockwashers (3, 9, 13).

KUBOTA TRACTOR
B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
Figure: 7 - ASSEMBLY

Assembly - continued

IMPORTANT - Do NOT run the tractor engine with the pump installed until the loader has been completely installed and the hydraulic reservoir filled with fluid or serious damage could occur to the pump.

3. Loader Upright Installation, Fig 5, 6, and 7:



Do not tighten upright mount bolts until loader lift frame has been installed.

A. Fig 7, install both the RH and LH uprights (37, 65) to the loader cross angle using six 1/2 NC x 1-1/4 bolts, nuts, and lockwashers (4, 10, 15).

B. Fig 5 and 6, install both the RH and LH forward braces (38, 39) to the tractor using six M12 x 1.25 x 30 bolts and six 1/2 lockwashers (5, 15). Install the opposite end of the braces to the loader upright lugs using two 1/2 NC x 1-1/4 bolts, nuts, and lockwashers (4, 10, 15).

C. Fig 5, install one handle grip (28) onto each control valve handle.

4. Lift Frame Installation, Fig 7:

A. Install the lift frame assembly to the loader uprights using two 3/4 Dia. L pins and hair pin clips (21, 35).

B. Attach the boom lift cylinder to the loader uprights using two 5/8 Dia. L pins and hair pin clips (21, 34).

5. Hydraulic Hook-Up, Fig 4, 5, and 8:

A. Install one 3/8 NPT x 90° street elbow (11) into the OUT port of the pump and one 1/2 NPT x 1/2 HB x 90° insert adapter (27) into the IN port of the pump.

B. Install one 3/8 NPT x 52" pressure hose (26) from the pump to the IN port of the control valve.

C. Install one 1/2 ID x 56" return hose (44) from the pump to the reservoir using two hose clamps (29) to retain the hose.

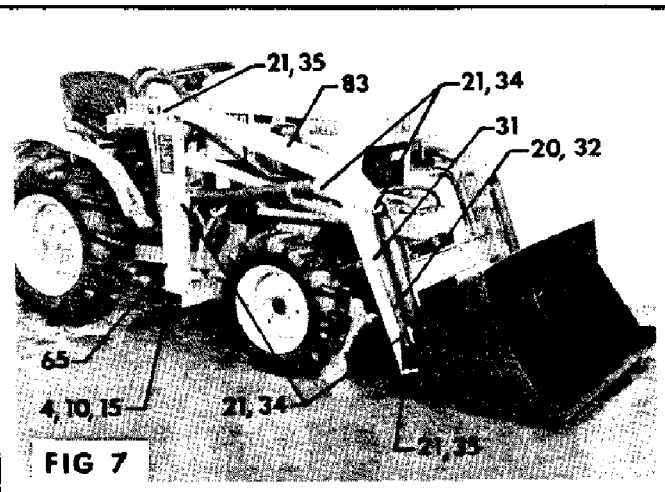
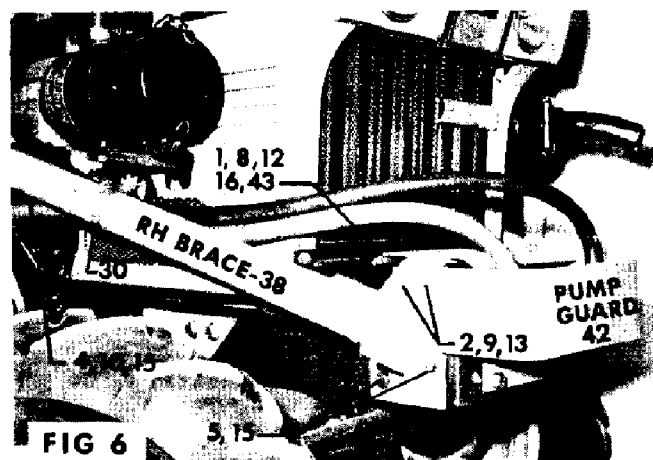
D. Secure hoses to forward brace pipes using one large hose clamp (30).

E. Install four 1/4 NPT x 13-1/2 hydraulic hoses (23) as follows:

1. From lift frame oil line C to each tilt cylinder base end.
2. From lift frame oil line D to each tilt cylinder rod end.

F. Install four 1/4 NPT x 16" hydraulic hoses (24) as follows:

1. From lift frame oil line A to each lift cylinder rod end.
2. From lift frame oil line B to each lift cylinder base end.



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 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 8 - ASSEMBLY/ PARTS LIST, FIG 1 - 8

Assembly - continued

G. Ports are marked on valve casting. Install two 1/4 NPT x 16" hydraulic hoses (24) from valve to frame oil lines as follows:

1. From port B to frame oil line B.
2. From port D to frame oil line D.

H. Ports are marked on valve casting. Install two 1/4 NPT x 20" hydraulic hoses (25) from valve to frame oil lines as follows:

1. From port A to frame oil line A.
2. From port C to frame oil line C.

I. Referring to Fig 5, remove the 1/2 NPT plastic pipe plug from the top of the reservoir and discard. Fill the reservoir with hydraulic fluid (four to five quarts). Refer to Pages 1 - 5 for

Safety Precautions, Operation, and Hydraulic Fluid Specifications.

Install breather (22) in the top of the reservoir in place of the pipe plug.

6. Pump Guard Installation, Fig 6:

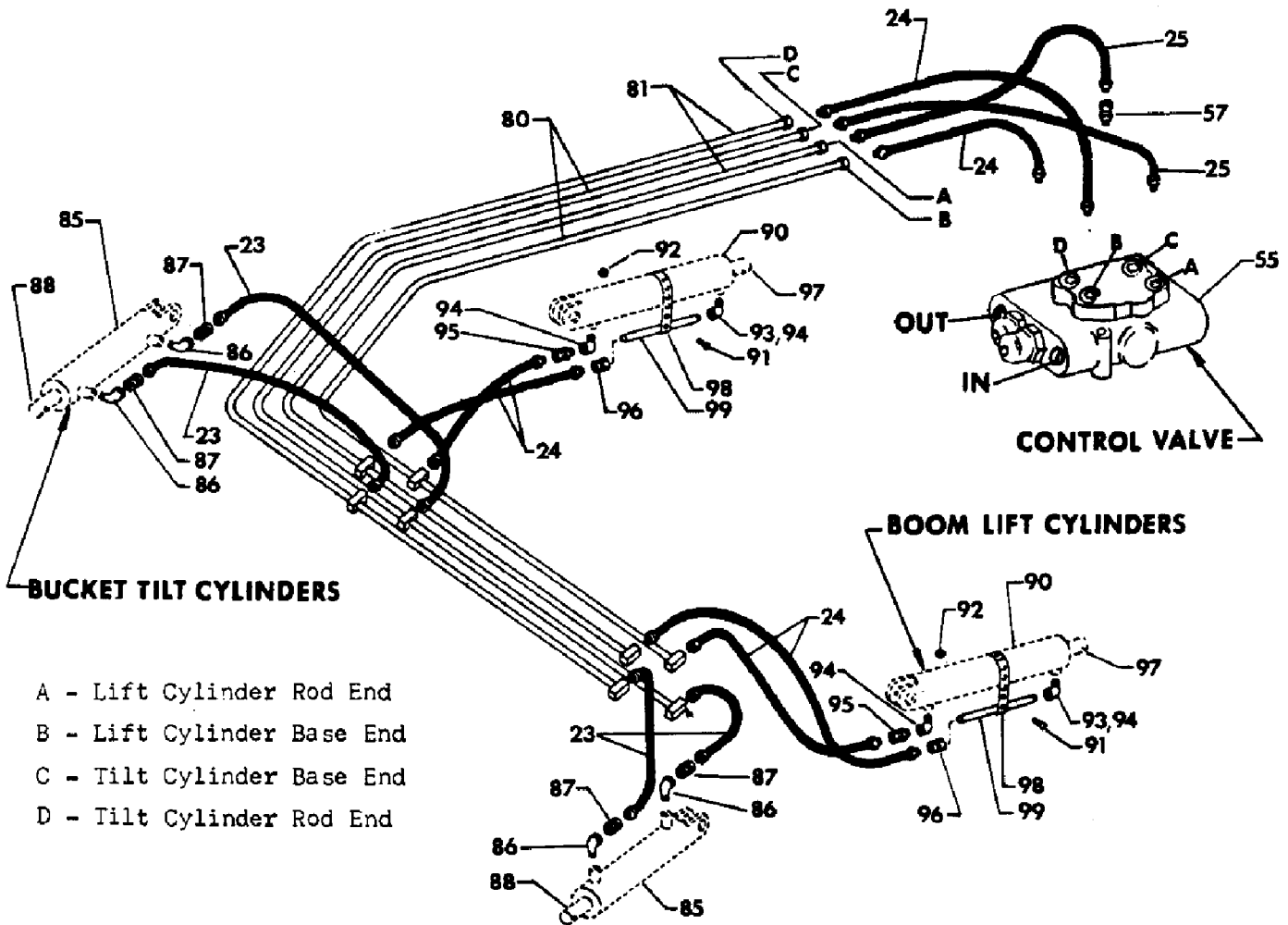


CAUTION - KEEP ALL GUARDS IN PLACE.

Built-in safety features are only effective when they are properly maintained.

A. Install pump guard (42) to the forward brace side pads using four 3/8 NC x 1" bolts, nuts, and lockwashers (2, 9, 13).

B. Install the chain coupling guard (43) to the forward braces using two 5/16 NC x 1" carriage bolts, nuts, lockwashers, and flat washers (1, 8, 12, 16).



KUBOTA TRACTOR
 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 8 - ASSEMBLY/ PARTS LIST, FIG 1 - 8

| Ref | Part Number | Qty Description |
|-----|-------------|--|
| 1 | O/L | Carr. Bolt, 5/16 NC x 1" |
| 2 | O/L | Bolt, 3/8 NC x 1" |
| 3 | O/L | Carr. Bolt, 3/8 NC x 1 - 1/4 |
| 4 | O/L | Bolt, 1/2 NC x 1 - 1/4 |
| 5 | 70050-00011 | Bolt, M12 x 1.25 x 30 |
| 6 | 70050-00012 | Bolt, M12 x 1/75 x 60 |
| 7 | 70050-00013 | Bolt, M10 x 1.25 x 35 |
| 8 | O/L | Nut, 5/16 NC |
| 9 | O/L | Nut, 3/8 NC |
| 10 | O/L | Nut, 1/2 NC |
| 11 | O/L | St. Elbow, 3/8 NPT x 90 Deg. |
| 12 | O/L | Lockwasher, 5/16 |
| 13 | O/L | Lockwasher, 3/8 |
| 14 | O/L | Lockwasher, 7/16 |
| 15 | O/L | Lockwasher, 1/2 |
| 16 | O/L | Flatwasher, 5/16 |
| 18 | O/L | Flatwasher, 7/16 |
| 19 | O/L | Flatwasher, 1/2 |
| 20 | 70050-00037 | Hair Pin Clip, #3 |
| 21 | 70050-00038 | Hair Pin Clip, #10 |
| 22 | 70050-00041 | Breather |
| 23 | 70050-00046 | Hyd. Hose, 1/4 NPT x 13 - 1/2 |
| 24 | 70050-00047 | Hyd. Hose, 1/4 NPT x 16" |
| 25 | 70050-00048 | Hyd. Hose, 1/4 NPT x 20" |
| 26 | 70010-00016 | Hyd. Hose, 3/8 NPT x 52" |
| 27 | 70050-00053 | Insert Barb, 1/2 NPT x 1/2 HB x 90 Deg. |
| 28 | 70050-00062 | Handle Grip |
| 29 | 70050-00063 | Hose Clamp |
| 30 | 70010-00295 | Hose Clamp |
| 31 | 70050-00068 | Indicator Tube Weld |
| 32 | 70050-00081 | Indicator Rod |
| 33 | 70050-00082 | CCW Pump |
| 34 | 70050-00102 | Cyl. Lock Pin, 5/8 Dia. |
| 35 | 70050-00103 | Boom Lock Pin, 3/4 Dia. |
| 36 | 70050-00105 | Sub - Frame Weld |
| 37 | 70050-00106 | LH Upright |
| 38 | 70050-00108 | RH Front Mount |
| 39 | 70050-00109 | LH Front Mount |
| 40 | 70050-00113 | Reinforcing Plate |
| 41 | 70050-00114 | Pump Mount |
| 42 | 70050-00115 | Pump Guard |
| 43 | 70050-00116 | Chain Coupling Guard |
| 44 | 70050-00117 | Return Hose, 1/2 ID x 56" ***** |
| | | RH UPRIGHT RESERVOIR ASSEMBLY ***** |
| 50 | O/L | Bolt, 1/4 MC X 2" |
| 51 | O/L | Nut, 1/4 NC |
| 52 | O/L | Lockwasher, 1/4 |
| 53 | 70050-00036 | Rivet, 3/16 x 1 - 1/2 |
| 54 | 70050-00039 | Strainer |
| 55 | 70050-00072 | Valve, 2 - Spool, 800 PSI |

KUBOTA TRACTOR
 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 8 - ASSEMBLY/ PARTS LIST, FIG 1 - 8

| Ref | Part Number | Qty Description |
|---|-------------|---|
| 56 | 70050-00045 | Hose, 1/2 ID x 15" |
| 57 | 70010-00017 | Adapter Union, 7/16 - 20 x 1/4 NPT |
| 58 | 70010-00018 | Adapter Union, 9/16 - 18 x 3/8 NPT |
| 59 | 70050-00054 | Insert Barb, 3/4 NPT x 1/2 HB x 90 Deg. |
| 60 | 70050-00055 | Insert Barb, 9/16 - 18 x 1/2 HB x 90 Deg. |
| 61 | 70050-00057 | Side Bar Only, ASA 50 |
| 62 | 70050-00058 | Connector Link, ASA 50 |
| 63 | 70050-00063 | Hose Clamp |
| 64 | 70050-00073 | Decal Mount Plate |
| 65 | 70050-00107 | RH Upright Reservoir |
| 66 | 70050-00118 | Valve Lever |
| ***** CHAIN COUPLING ASSEMBLY ***** | | |
| 70 | 70050-00056 | Roller Chain |
| 71 | 70050-00110 | Sprocket Shaft |
| 72 | 70050-00111 | Sprocket W/18 - 22 Spline |
| 73 | 70050-00112 | Sprocket W/9/16 Bore |
| ***** LIFT FRAME ASSEMBLY ***** | | |
| 80 | 70050-00144 | Oil Line, RH Long |
| 81 | 70050-00138 | Oil Line, RH Short |
| 82 | 70050-00065 | Grease Fitting |
| 83 | 70050-00104 | Lift Frame Weld |
| ***** TILT CYLINDER ASSEMBLY ***** | | |
| 85 | 70050-00003 | Hyd. Cylinder, 2" Dia. |
| 86 | 70050-00023 | St. Elbow, 1/4 NPT x 90 Deg. |
| 87 | 70050-00050 | Adapter Union, 1/4 NPT M - F |
| 88 | 70050-00065 | Grease Fitting |
| ***** LIFT CYLINDER ASSEMBLY ***** | | |
| 90 | 70050-00004 | Hyd. Cylinder, 2" Dia. |
| 91 | O/L | Mach. Screw, 1/4 NC x 1 - 1/2 |
| 92 | O/L | Nut, 1/4 NC |
| 93 | 70050-00022 | St. Elbow, 1/4 NPT x 45 Deg. |
| 94 | 70050-00023 | St. Elbow, 1/4 NPT x 90 Deg. |
| 95 | 70050-00050 | Adapter Union, 1/4 NPT M - F |
| 96 | 70050-00051 | Adapter Union, 1/4 NPT F x F |
| 97 | 70050-00065 | Grease Fitting |
| 98 | 70050-00077 | Pipe Clamp |
| 99 | 70050-00101 | Formed Nipple |

KUBOTA TRACTOR
 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 8A - ASSEMBLY/ PARTS LIST, FIG 1 - 8

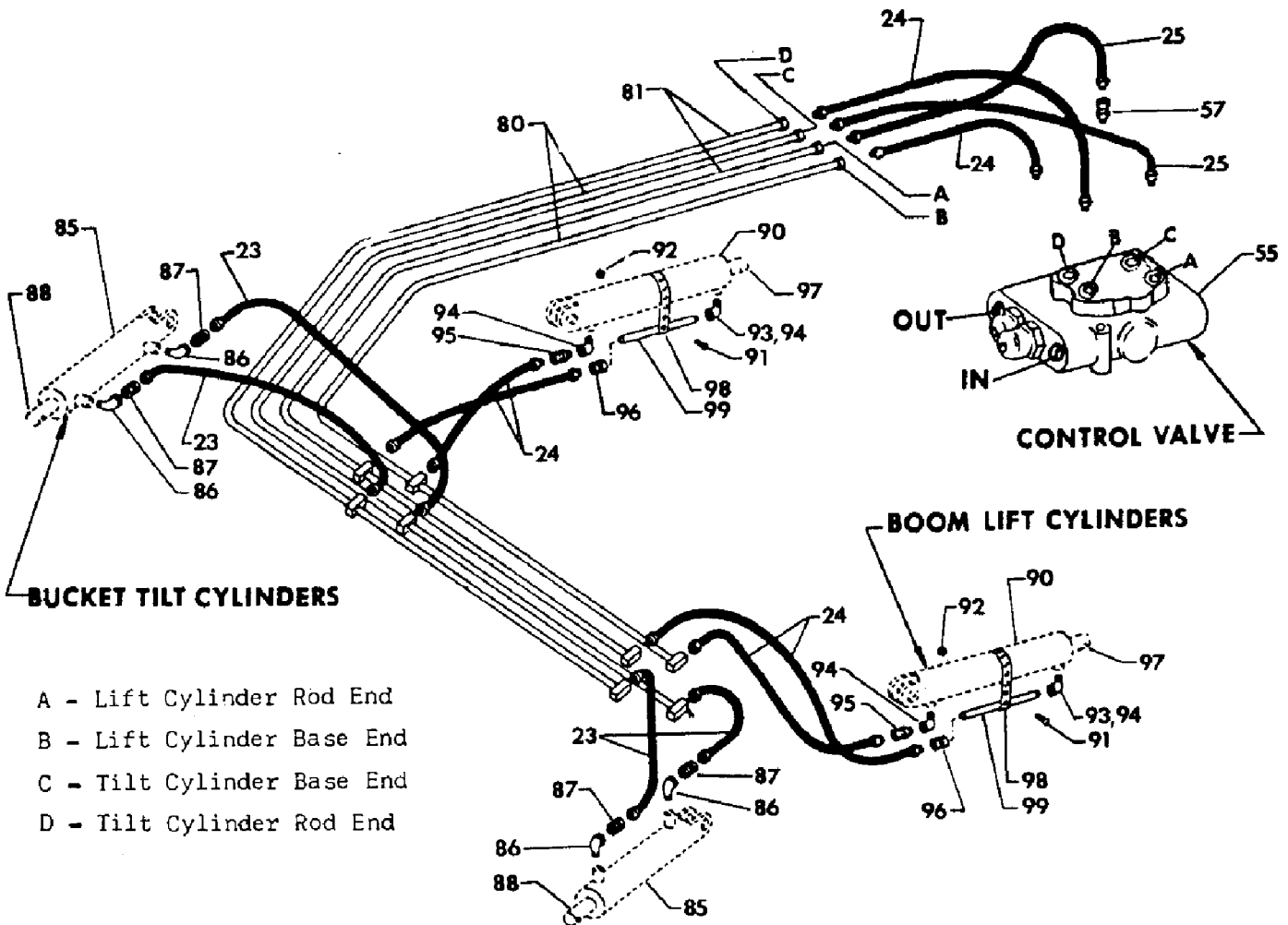
Assembly - continued

7. Bucket Installation, Fig 7:

A. Attach bucket to the loader lift frame using two 3/4 Dia. L pins and hair pin clips (21, 35).

B. Connect the bucket tilt cylinder to the bucket using two 5/8 Dia. L pins and hair pin clips (21, 34).

C. Retain the indicator tube (31) with the RH tilt cylinder L pin. Insert the indicator rod (32) into the tube and secure the hook end to the bucket with one #3 hair pin clip (20).



KUBOTA TRACTOR
 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 8A - ASSEMBLY/ PARTS LIST, FIG 1 - 8

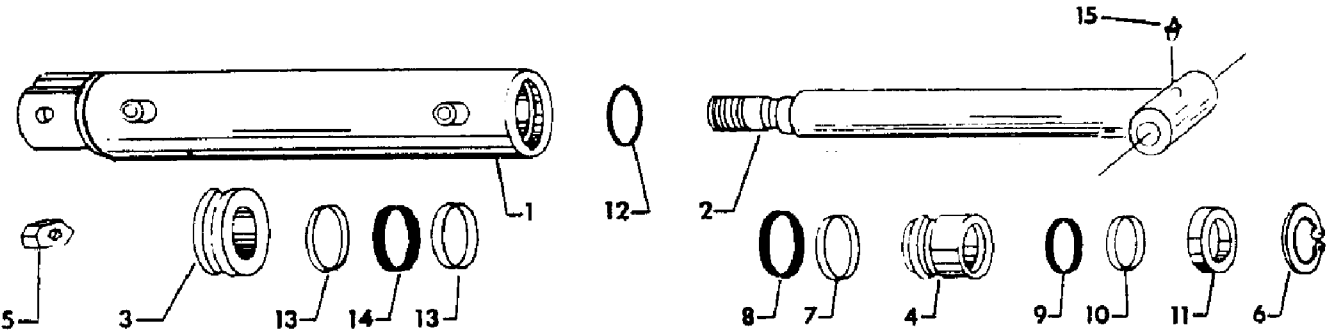
| Ref | Part Number | Qty Description |
|-----|-------------|--|
| 1 | O/L | Carr. Bolt, 5/16 NC x 1" |
| 2 | O/L | Bolt, 3/8 NC x 1" |
| 3 | O/L | Carr. Bolt, 3/8 NC x 1 - 1/4 |
| 4 | O/L | Bolt, 1/2 NC x 1 - 1/4 |
| 5 | 70050-00011 | Bolt, M12 x 1.25 x 30 |
| 6 | 70050-00012 | Bolt, M12 x 1/75 x 60 |
| 7 | 70050-00013 | Bolt, M10 x 1.25 x 35 |
| 8 | O/L | Nut, 5/16 NC |
| 9 | O/L | Nut, 3/8 NC |
| 10 | O/L | Nut, 1/2 NC |
| 11 | O/L | St. Elbow, 3/8 NPT x 90 Deg. |
| 12 | O/L | Lockwasher, 5/16 |
| 13 | O/L | Lockwasher, 3/8 |
| 14 | O/L | Lockwasher, 7/16 |
| 15 | O/L | Lockwasher, 1/2 |
| 16 | O/L | Flatwasher, 5/16 |
| 18 | O/L | Flatwasher, 7/16 |
| 19 | O/L | Flatwasher, 1/2 |
| 20 | 70050-00037 | Hair Pin Clip, #3 |
| 21 | 70050-00038 | Hair Pin Clip, #10 |
| 22 | 70050-00041 | Breather |
| 23 | 70050-00046 | Hyd. Hose, 1/4 NPT x 13 - 1/2 |
| 24 | 70050-00047 | Hyd. Hose, 1/4 NPT x 16" |
| 25 | 70050-00048 | Hyd. Hose, 1/4 NPT x 20" |
| 26 | 70010-00016 | Hyd. Hose, 3/8 NPT x 52" |
| 27 | 70050-00053 | Insert Barb, 1/2 NPT x 1/2 HB x 90 Deg. |
| 28 | 70050-00062 | Handle Grip |
| 29 | 70050-00063 | Hose Clamp |
| 30 | 70010-00295 | Hose Clamp |
| 31 | 70050-00068 | Indicator Tube Weld |
| 32 | 70050-00081 | Indicator Rod |
| 33 | 70050-00082 | CCW Pump |
| 34 | 70050-00102 | Cyl. Lock Pin, 5/8 Dia. |
| 35 | 70050-00103 | Boom Lock Pin, 3/4 Dia. |
| 36 | 70050-00105 | Sub - Frame Weld |
| 37 | 70050-00106 | LH Upright |
| 38 | 70050-00108 | RH Front Mount |
| 39 | 70050-00109 | LH Front Mount |
| 40 | 70050-00113 | Reinforcing Plate |
| 41 | 70050-00114 | Pump Mount |
| 42 | 70050-00115 | Pump Guard |
| 43 | 70050-00116 | Chain Coupling Guard |
| 44 | 70050-00117 | Return Hose, 1/2 ID x 56" ***** |
| | | RH UPRIGHT RESERVOIR ASSEMBLY ***** |
| 50 | O/L | Bolt, 1/4 MC X 2" |
| 51 | O/L | Nut, 1/4 NC |
| 52 | O/L | Lockwasher, 1/4 |
| 53 | 70050-00036 | Rivet, 3/16 x 1 - 1/2 |
| 54 | 70050-00039 | Strainer |
| 55 | 70050-00072 | Valve, 2 - Spool, 800 PSI |

KUBOTA TRACTOR
 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 8A - ASSEMBLY/ PARTS LIST, FIG 1 - 8

| Ref | Part Number | Qty Description |
|-------------------------|-------------|---|
| 56 | 70050-00045 | Hose, 1/2 ID x 15" |
| 57 | 70010-00017 | Adapter Union, 7/16 - 20 x 1/4 NPT |
| 58 | 70010-00018 | Adapter Union, 9/16 - 18 x 3/8 NPT |
| 59 | 70050-00054 | Insert Barb, 3/4 NPT x 1/2 HB x 90 Deg. |
| 60 | 70050-00055 | Insert Barb, 9/16 - 18 x 1/2 HB x 90 Deg. |
| 61 | 70050-00057 | Side Bar Only, ASA 50 |
| 62 | 70050-00058 | Connector Link, ASA 50 |
| 63 | 70050-00063 | Hose Clamp |
| 64 | 70050-00073 | Decal Mount Plate |
| 65 | 70050-00107 | RH Upright Reservoir |
| 66 | 70050-00118 | Valve Lever |
| ***** | | |
| CHAIN COUPLING ASSEMBLY | | |
| ***** | | |
| 70 | 70050-00056 | Roller Chain |
| 71 | 70050-00110 | Sprocket Shaft |
| 72 | 70050-00111 | Sprocket W/18 - 22 Spline |
| 73 | 70050-00112 | Sprocket W/9/16 Bore |
| ***** | | |
| LIFT FRAME ASSEMBLY | | |
| ***** | | |
| 80 | 70050-00144 | Oil Line, RH Long |
| 81 | 70050-00138 | Oil Line, RH Short |
| 82 | 70050-00065 | Grease Fitting |
| 83 | 70050-00104 | Lift Frame Weld |
| ***** | | |
| TILT CYLINDER ASSEMBLY | | |
| ***** | | |
| 85 | 70050-00003 | Hyd. Cylinder, 2" Dia. |
| 86 | 70050-00023 | St. Elbow, 1/4 NPT x 90 Deg. |
| 87 | 70050-00050 | Adapter Union, 1/4 NPT M - F |
| 88 | 70050-00065 | Grease Fitting |
| ***** | | |
| LIFT CYLINDER ASSEMBLY | | |
| ***** | | |
| 90 | 70050-00004 | Hyd. Cylinder, 2" Dia. |
| 91 | O/L | Mach. Screw, 1/4 NC x 1 - 1/2 |
| 92 | O/L | Nut, 1/4 NC |
| 93 | 70050-00022 | St. Elbow, 1/4 NPT x 45 Deg. |
| 94 | 70050-00023 | St. Elbow, 1/4 NPT x 90 Deg. |
| 95 | 70050-00050 | Adapter Union, 1/4 NPT M - F |
| 96 | 70050-00051 | Adapter Union, 1/4 NPT F x F |
| 97 | 70050-00065 | Grease Fitting |
| 98 | 70050-00077 | Pipe Clamp |
| 99 | 70050-00101 | Formed Nipple |

KUBOTA TRACTOR
B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
Figure: 10 - CYLINDER BREAKDOWN - PARTS LISTS (70050-00003, 70050-00004)

CYLINDER BREAKDOWN



KUBOTA TRACTOR

B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS

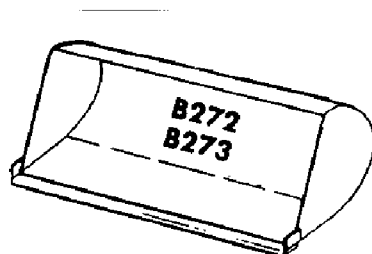
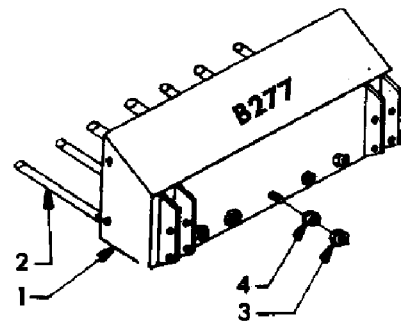
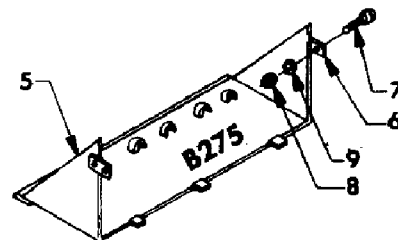
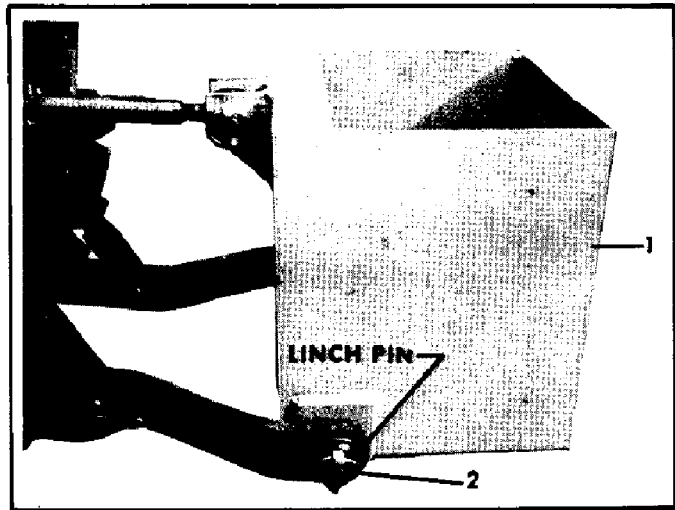
Figure: 10 - CYLINDER BREAKDOWN - PARTS LISTS (70050-00003, 70050-00004)

| Ref | Part Number | Qty Description |
|-----|-------------|-----------------------------------|
| 1 | 70050-00125 | Cylinder Tube (70050-00003) |
| 1 | 70050-00127 | Cylinder Tube (70050-00004) |
| 2 | 70050-00126 | Piston Rod (70050-00003) |
| 2 | 70050-00128 | Piston Rod (70050-00004) |
| 3 | 70010-00065 | Piston |
| 4 | 70010-00066 | Head |
| 5 | 70050-00021 | Lock Nut, 1" NF |
| 6 | 70010-00029 | Snap Ring, N5000 - 206 |
| 7 | 70010-00025 | * Back-Up Ring, 8-224 |
| 8 | 70010-00022 | * O-Ring, ARP-224, 1-3/4 x 2" |
| 9 | 70010-00021 | * O-Ring, ARP-216, 1-1/8 x 1-3/8 |
| 10 | 70010-00024 | * Leather Washer, 6246 - 21 |
| 11 | 70050-00059 | * Oil Seal, CR 11130 |
| 12 | 70010-00020 | * O-Ring, ARP-210, 3/4 x 1" (Rod) |
| 13 | 70010-00026 | * Back-Up Ring, 8-326 |
| 14 | 70010-00023 | * O-Ring, ARP-326, 1-5/8 x 2" |
| 15 | 70050-00065 | Grease Fitting |

 NOTE: All Parts Marked With An
 Asterisk (*) Are Available As One
 Complete Cylinder Repair Packing
 Kit, Part Number 70050-00123.

Optional Attachments:

Ballast Box -



KUBOTA TRACTOR
 B219 LOADER - MODEL 25 MAXIMUM PAYLOAD - 500 POUNDS
 Figure: 11 - OPTIONAL ATTACHMENTS: BALLAST BOX/BUCKETS

| Ref | Part Number | Qty | Description |
|-----------------------------------|-------------|-----|----------------------|
| ***** | | | |
| B304 PARTS LIST | | | |
| ***** | | | |
| 1 | B304 | | Ballast Box Weldment |
| 2 | 70050-00061 | | Linch Pin |
| ***** | | | |
| BUCKETS | | | |
| B272 - 38" MATERIAL BUCKET | | | |
| B273 - 48" MATERIAL BUCKET | | | |
| B277 - 36" TINE BUCKET | | | |
| ***** | | | |
| 1 | B277 | | 36" Tine Bucket |
| 2 | 70050-00078 | | Tine |
| 3 | O/L | | Nut, 1/2 NC |
| 4 | O/L | | Lockwasher, 1/2 |
| ***** | | | |
| B275 - 36" PLATE ADAPTER FOR B277 | | | |
| ***** | | | |
| 5 | B275 | | 36" Dirt Plate |
| 6 | 70050-00083 | | Tie Strap |
| 7 | O/L | | Bolt, 3/8 NC x 1" |
| 8 | O/L | | Nut, 3/8 NC |
| 9 | O/L | | Lockwasher, 3/8 |