



The Cleaning Edge™

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XT3-21



XT3-27

**XT3
BATTERY POWERED
FLOOR BURNISHER**

TABLE OF CONTENTS

COVER PAGE	1
BLANK	2
TABLE OF CONTENTS	3
SAFETY INSTRUCTIONS	4 - 5
SPECIFICATIONS	5
PROCEDURES FOR LOADING, TRANSPORTING, AND UNLOADING	6
OPERATING INSTRUCTIONS	7
BATTERY CHARGING	8
BATTERY MAINTENANCE	9
BATTERY CHARGER OPERATION	10
CHARGER SETTINGS FOR DIFFERENT BATTERIES	11
BATTERY DISCHARGE INDICATOR AND HOUR METER INFORMATION	12
PAD CHANGING INSTRUCTIONS	13
BALANCING INSTRUCTIONS	14
SERIAL NUMBER LOCATION AND SHIPPING EYEBOLT REPLACEMENT	15
ELECTRICAL LAYOUT	16
WIRING LADDER DIAGRAM	17
WIRING HARNESS	18
XT3-21 PARTS AND INFORMATION SECTION	19
XT3-21 SPECIFICATIONS	20
XT3-21 BELT TENSIONING INSTRUCTIONS	21
XT3-21 COVER AND HANDLE	22 - 23
XT3-21 DECK, FRAME, AND WHEELS	24 - 25
XT3-21 MOTOR, PULLEYS, AND BELT	26 - 27
XT3-21 PAD DRIVER ASSEMBLY	28
XT3-21 ELECTRICAL AND BATTERY VIEW	29 - 31
BLANK	32
XT3-27 PARTS AND INFORMATION SECTION	33
XT3-27 SPECIFICATIONS	34
XT3-27 BELT TENSIONING INSTRUCTIONS	35
XT3-27 COVER AND HANDLE	36 - 37
XT3-27 WATERING SYSTEM INSTRUCTIONS	38 - 39
XT3-27 DECK, FRAME, AND WHEELS	39 - 40
XT3-27 MOTOR, PULLEYS, AND BELT	42 - 43
XT3-27 PAD DRIVER ASSEMBLY	44
XT3-27 ELECTRICAL AND BATTERY VIEW	45 - 47
XT3-27 BATTERY CONNECTIONS AND WATERING CONNECTIONS	48 - 49
TROUBLE SHOOTING	50
WARRENTY	51

SAFETY INSTRUCTIONS

<u>Hazard Level</u>	<u>Explanation or Description of Hazard Level</u>
	Failure to follow safety instructions labeled  could result in severe injury or death to the machine operator or others.
	 could result in injury to the machine operator or others. Also, machine or property damage could occur.
	Failure to follow safety instructions labeled  could result in damage to the machine or other property.



This manual contains important information about your machine. Read and understand all instructions before operating the machine. Failure to read and follow the instructions could result in injury to the person operating the machine or injury to others. Damage to the machine or other property could occur if instructions are not followed.



Do not operate this machine around any solvents, thinners, or other flammable liquids or materials. Electrical sparks can cause a fire or even an explosion.



Do not smoke around the machine. Also, keep all sparks and flames away from the batteries. The batteries generate gases that can cause an explosion.



Special care needs to be used when working on or near the batteries. Wear eye protection. Do not lay tools on batteries, as they may short out battery terminals. Do not wear metal jewelry, as it may short out battery terminals.



Charging batteries can be dangerous. Be aware that the battery charger may have a relatively low voltage output, but the current output is very high and therefore dangerous. Do not operate the charger if any parts of the charger or charger cords are damaged. Do not stand on a wet floor when connecting or disconnecting charger to the power outlet or to the machine.

Safety Instructions are continued on the next page ➡➡➡

SAFETY INSTRUCTIONS



Battery acid is dangerous. Wear eye and face protection, hand protection, and body protection when working on and around batteries. If you get acid on your skin, wash off immediately. If you get acid on your clothing, remove clothing and wash any skin that was in contact with the clothing. Baking soda mixed with water will help to neutralize the acid on your skin.



The machine is very heavy, so be very careful when loading, transporting, and unloading the machine.



Keep all body parts, clothing, and objects away from moving parts.

Operate machine from the rear, not from the side.



Disconnect a wire to the batteries before working on the machine.



Do not operate machine with charger plugged in.



Do not operate machine with any parts damaged or missing.



Do not operate close to stairs, loading docks, or other drop-offs. Do not park machine in such a manner that it could roll, forward or backward, off a drop-off.



Authorized personnel must perform maintenance and repairs. Do not alter or modify the machine, unless authorized by the manufacturer.



Do not expose the electrical components to water or excessive moisture.



Always put caution signs around the areas that are being cleaned.



Do not use machine as a "ladder". Do not use machine as a "forklift" to push stuff around. Do not ride or let anyone ride on the machine.



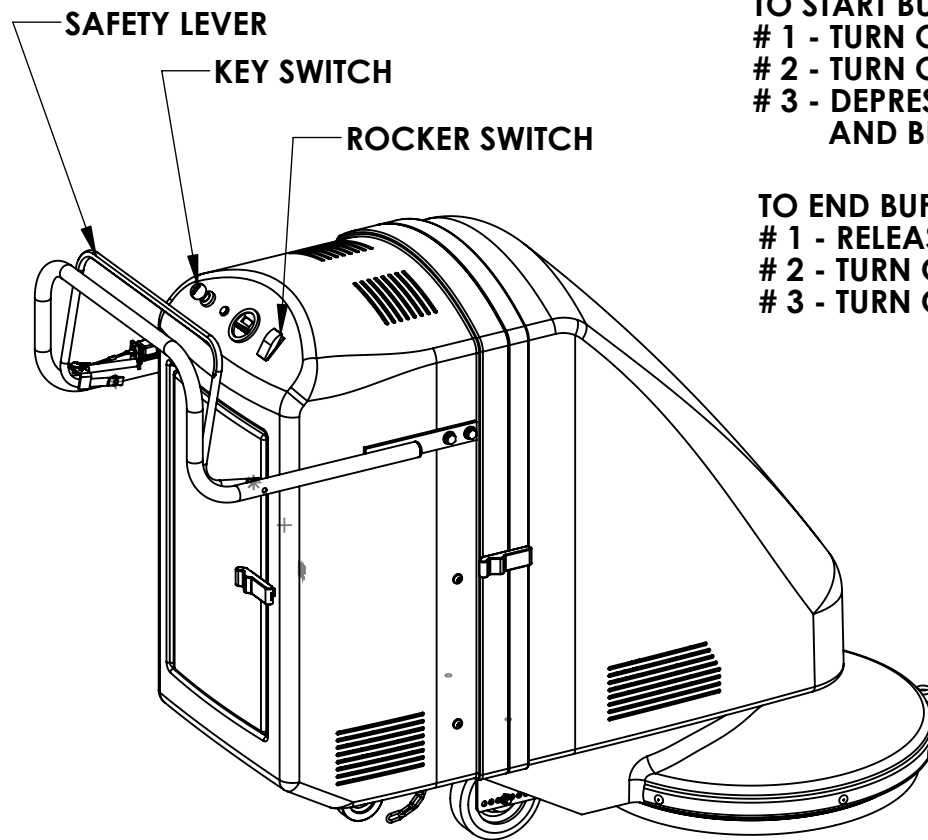
Your machine warranty may be voided if parts other than PowerBuff parts are used.

Procedures for Loading, Transporting, and Unloading Battery Burnisher



The machine is very heavy, so be very careful when loading, transporting, and unloading the machine. Use at least two people to load or unload the machine.

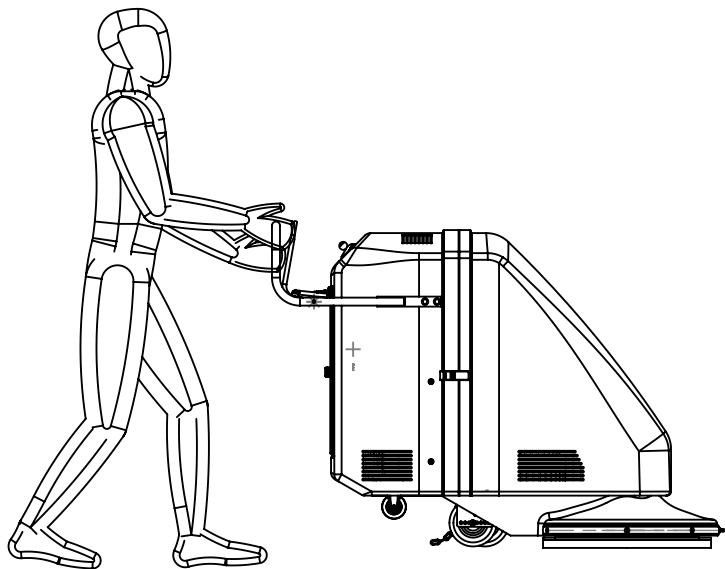
- Loading Procedure Using a Ramp
 - o It is not recommended that the battery burnisher be loaded using a ramp with an incline of more than 7 degrees. The machine is not self-propelled and therefore it is not able to assist itself up a ramp. It is too heavy to manually push up a steep incline.
 - o If you must load with a ramp, the incline must be no more than 7 degrees. (This would permit a height of no more than one foot for an 8-foot ramp).
 - o Ramp must be secured to vehicle, and be clean and dry.
 - o Machine must be pushed or pulled straight up the ramp and never at an angle.
- Loading Procedure Using a Lift Gate
 - o Lift gate must have ample capacity to lift the burnisher.
 - o Wheels must be firmly chocked to prevent burnisher from rolling off the lift gate.
- Securing Battery Burnisher
 - o Burnisher must be secured, so that it will not roll or turn over. Use chocks and tie downs to secure.
 - o Please be aware that the battery burnisher is very heavy, and that a metal bulkhead in a van may not contain equipment in the event of an accident. The equipment in a van can be more dangerous than the accident itself.
- Unloading Procedure Using a Ramp
 - o Ramp must be long enough so that removal can be controlled. Use same ramp incline restrictions as used for loading burnisher.
 - o Ramp must be secured to vehicle, and be clean and dry.
 - o Machine must be taken straight down the ramp and never at an angle.
 - o Do not let machine run over you or anyone else as it comes off ramp.

**TO START BUFFING:**

- # 1 - TURN ON KEY SWITCH
- # 2 - TURN ON ROCKER SWITCH
- # 3 - DEPRESS SAFETY HANDLE AND BEGIN BUFFING

TO END BUFFING:

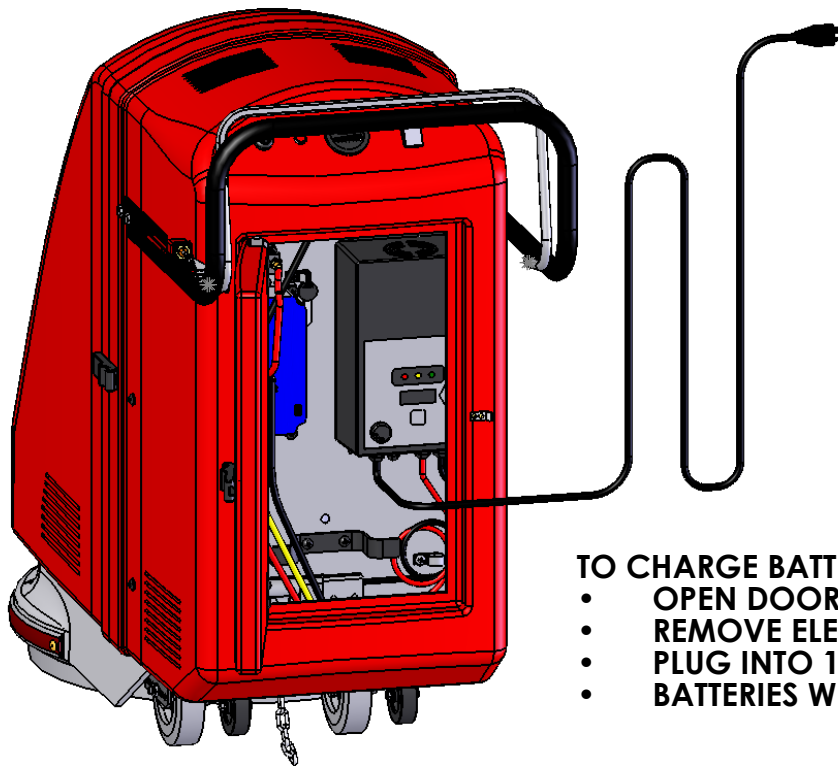
- # 1 - RELEASE SAFETY HANDLE
- # 2 - TURN OFF ROCKER SWITCH
- # 3 - TURN OFF KEY SWITCH



**AFTER EACH USE:
PLUG CHARGER CORD
INTO 110 VOLT WALL OUTLET**

**REFER TO NEXT THREE PAGES FOR
BATTERY CHARGER OPERATION
AND BATTERY MAINTENANCE**

- Become familiar with and follow the instructions issued by the charger manufacturer.
- Batteries should be charged after each period of use. Lead acid batteries do not develop a memory and need not be fully discharged before recharging.
- The charger is factory set to properly charge the size and type batteries that were supplied with your machine.
- Charge only in well-ventilated area. Keep sparks or flames away from a charging battery.
- Do not get the charger wet.
- Do not remove battery caps, the caps are vented. Caps on standard wet cell batteries. No caps on AGM batteries.
- Do not charge machine in a wet area.
- Do not stand in a wet area when plugging in charger to the 110 volt receptacle.
- Plug in the charger to a properly grounded 110 volt receptacle.
- Lights will indicate the charging status.
- Charger will shut off automatically when batteries are fully charged.

**TO CHARGE BATTERIES:**

- OPEN DOOR
- REMOVE ELECTRICAL CORD
- PLUG INTO 110 VOLT OUTLET
- BATTERIES WILL BEGIN CHARGING

BATTERY MAINTENANCE

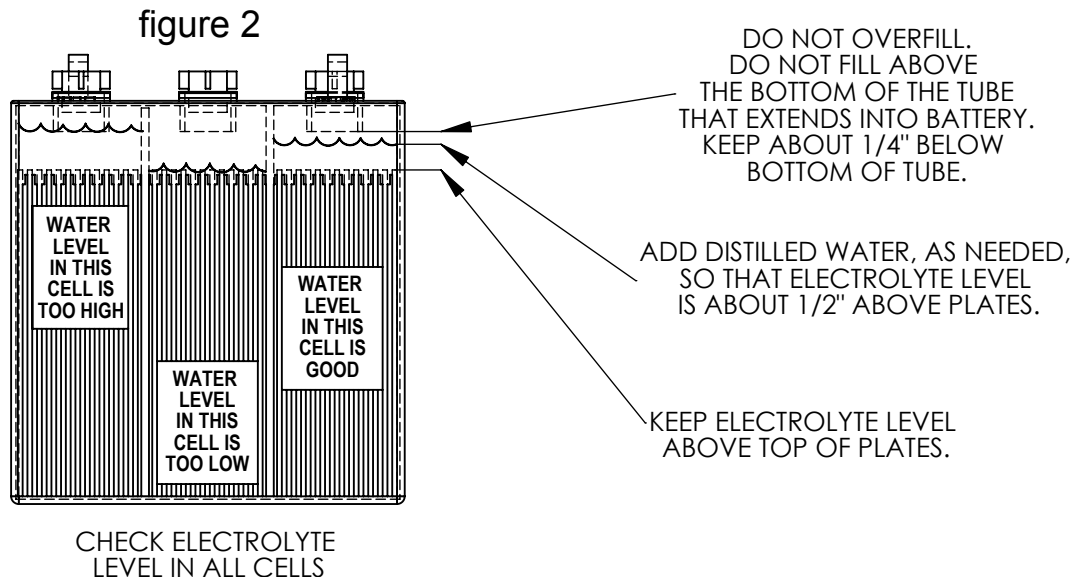
IMPORTANT!!! READ ALL SAFETY INSTRUCTIONS ON PAGES 4 AND 5

FOR ALL BATTERIES - STANDARD WET CELL AND AGM (ABSORBED GLASS MAT)

- Batteries should be charged as soon as possible after each period of use. The batteries in this machine do not develop a memory and do not need to be fully discharged before recharging. Do not allow batteries to remain in a discharged state.
- Be aware that a discharged battery will freeze easily.
- Make sure battery connections are tight and free from corrosion. A baking soda and water solution and a wire brush are helpful when cleaning battery connections. Keep caps on when cleaning batteries, so that electrolyte is not contaminated.

FOR WET CELL BATTERIES

- Check the electrolyte level weekly. Top off with distilled water as shown in figure 2. Do not overfill. Make sure that all plugs are tight.
- Water should always be added after fully charging the battery, although prior to charging, there should be enough water to cover the plates. This also applies if the batteries have a watering system.



!!! BATTERIES ARE DANGEROUS !!!
READ THE SAFETY INSTRUCTIONS
IN THE FRONT OF THIS MANUAL
FOR SPECIFIC WARNINGS

IF YOU WOULD LIKE TO LEARN MORE ABOUT BATTERIES

THERE IS A VERY INFORMATIVE PUBLICATION AVAILABLE. IT COVERS SUBJECTS SUCH AS BATTERY TERMS AND HOW A BATTERY WORKS TO SPECIFIC GRAVITY TESTING WITH A HYDROMETER AND DIAGNOSIS OF BATTERY PROBLEMS.

YOU CAN OBTAIN A COPY OF THE **"BATTERY SERVICE MANUAL"** FROM

BATTERY COUNCIL INTERNATIONAL
 401 N. MICHIGAN AVENUE
 CHICAGO, IL 60611
 PHONE 312-644-6610

BATTERY CHARGER OPERATION

OPERATION

- **JUST PLUG THE CORD FROM THE CHARGER INTO A 110 VOLT OUTLET**
 - Batteries should now start charging.
- A test is run on the battery voltage to decide if the charging process should be started or not. If the battery is not connected to the battery charger, the display will show the word "bat". The word will stay on, even if the test is failed (for instance, reversed polarities or incorrect battery connection). If the test is passed, the display will show the battery voltage for approximately 5 seconds and the battery will begin to be charged. The charging cycle progress will be shown by red, yellow, and green LED indicators. At the end of the charge, when the green indicator is on, unplug the cord from the socket and operate the machine.
- **NOTE: THE MACHINE WILL NOT POWER ON IF THE CHARGER IS STILL PLUGGED IN TO THE 110 VOLT OUTLET.**

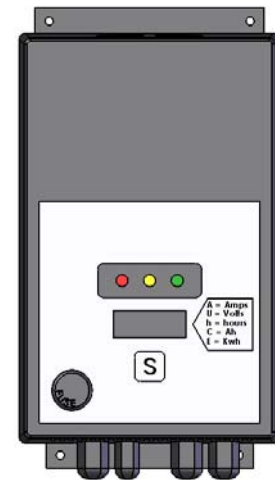
INDICATOR LIGHTS

- Red indicator shows that the charging cycle has started.
- Yellow indicator shows that the final phase of the charging cycle has started.
- Green indicator shows that the charging cycle has finished.

DISPLAY

Press button "S" (for Selection) to display:

- A = the charging current,
- U = the battery voltage,
- h = the charging time,
- C = the charging ampere-hours [Ah],
- E = the energy used [KWh].



CAUTION - CHARGER SETTINGS MUST BE CHANGED IF BATTERY TYPE IS CHANGED (SEE NEXT PAGE FOR SETTINGS)

THIS BATTERY CHARGER IS FACTORY SET FOR THE TYPE OF BATTERIES THAT CAME WITH YOUR MACHINE. IF YOU SWITCH BATTERY TYPES (FOR EXAMPLE GO FROM AGM TYPE BATTERIES TO STANDARD WET CELL BATTERIES), THEN THE BATTERY CHARGER MUST BE REPROGRAMMED. SEE NEXT PAGE "HOW TO SET THE CHARGER FOR DIFFERENT SIZES AND TYPES OF BATTERIES" FOR INSTRUCTION.

GENERAL INFORMATION AND WARNINGS

- **READ SAFETY INSTRUCTIONS ON PAGES 4 AND 5**
- This is a state-of-the-art electronic high frequency automatic battery charger with microprocessor.
- It is suitable for any battery type, if the charger has the proper settings. (Call manufacturer of machine on how to set the charger for different batteries than were supplied with your machine)..
- Never disconnect the battery while charging, since this could cause sparks.
- Never use the equipment in the rain, in areas used for washing, or in wet or damp areas.
- Use battery chargers only in well ventilated areas.

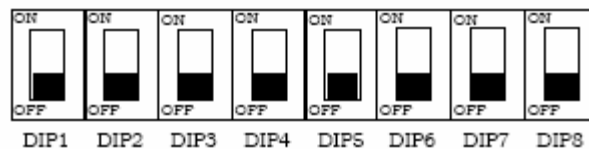
FOR LEAD ACID BATTERIES:

- Control the water level after each charging process. (See "Battery Maintenance" page).
- Refill with distilled water only.
- Caution! The gases generated during charging are explosive. Do not smoke in the vicinity of the batteries. When working with cables and electrical equipment, avoid open flames and sparks.
- Attention: Use protective glasses and gloves during battery maintenance. Battery acid causes injuries. In case of contact with battery acid, wash the affected parts with a lot of fresh water and consult a doctor if necessary.

HOW TO SET THE CHARGER FOR DIFFERENT SIZES AND TYPES OF BATTERIES



THE INFORMATION THAT FOLLOWS IS PROVIDED SHOULD YOU EVER CHANGE THE TYPE OR SIZE OF BATTERIES IN YOUR MACHINE. CONSULT WITH THE EQUIPMENT MANUFACTURER BEFORE YOU MAKE ANY CHANGES TO THE CHARGER SETTINGS. DAMAGE COULD OCCUR TO THE BATTERIES AND MORE SERIOUS, IF THE BATTERIES ARE CHARGED TO THE INCORRECT AMPERAGE OR VOLTAGE, THE BATTERIES COULD EXPLODE.



UP IS ON

DOWN IS OFF

DIP SWITCHES ARE LOCATED UNDER LABEL

DIP 1, DIP 2, DIP 3, AND DIP 4 ARE FOR SELECTING THE CHARGING CURVE

DIP 1	DIP 2	DIP 3	DIP 4	CHARGING CURVE
OFF	ON	ON	ON	WET BATTERIES
OFF	ON	OFF	ON	AGM BATTERIES
PLEASE CONSULT EQUIPMENT MANUFACTURER BEFORE CHANGING				

DIP 5 AND DIP 6 ARE CONTROL THE CHARGING CURRENT

DIP 5	DIP 6	AMPERAGE
ON	ON	15 A
OFF	ON	20 A
ON	OFF	25 A
OFF	OFF	30 A

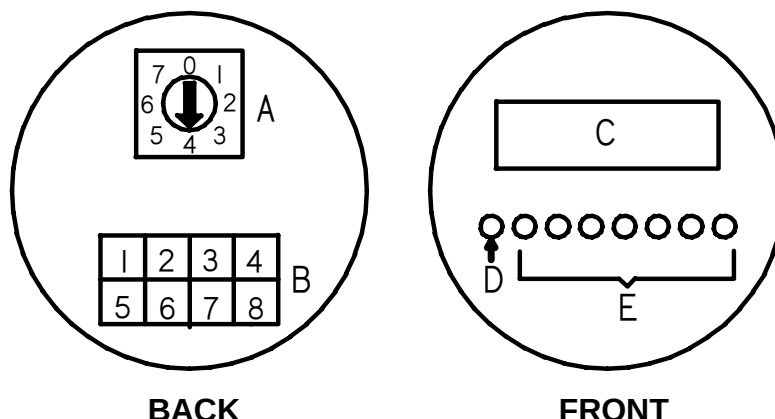
DIP 7 AND DIP 8 CONTROL THE BATTERY CHARGING VOLTAGE

DIP 7	DIP 8	VOLTAGE
ON	ON	12 V
OFF	ON	24 V
ON	OFF	36 V
OFF	OFF	48 V

XT3 BATTERY DISCHARGE INDICATOR (BDI) AND HOUR METER XT3

Connector pin configuration (B)

- 1: hour meter input -
- 2: key +
- 3: relay +
- 4: relay -
- 5: battery -
- 6: not used
- 7: not used
- 8: battery +



- A. Shutoff voltage rotary dipswitch. Factory set to 4 (32.76 volts). This is the voltage at which the batteries are 80% discharged. Do not set below this voltage or battery life will be shortened.
- B. Connections to meter (molex connector)
- C. Hour meter (display is always on, but only counts time when negative voltage is applied to pin 1)
- D. Low voltage shutoff LED
- E. Battery condition LED's. (1 through 7 with 7 being fully charged batteries)

POSITION	0	1	2	3	4	5	6	7
VOLTS PER CELL	1.63	1.68	1.73	1.76	1.82	1.84	1.86	1.89
TOTAL VOLTS	29.34	30.24	31.14	31.68	32.76	33.12	33.48	34.02

BDI DISPLAY

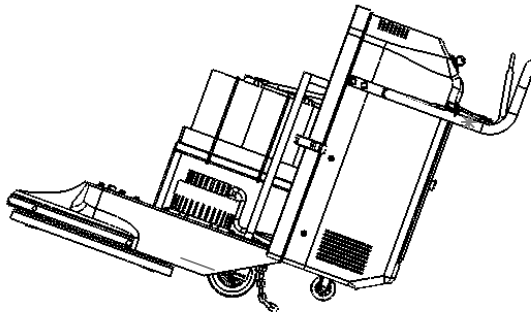
When the machine is turned on, the battery level indicator is switched on and the LED (D or E) corresponding to the position currently held by the rotary dipswitch will turn on. Position 0 (zero) corresponds to the red LED (D), position 1 corresponds to the first yellow LED (row of 7 LED's (D), and so on. After that, all the LED's turn on for a few seconds (lamp test) and then ordinary operation is started. The battery level indicator features two voltage thresholds: the stopping threshold and the resetting threshold. The stopping threshold corresponds to the value of the voltage at the end of discharge and depends on the position of the rotary dipswitch (A) located at the back side of the indicator. The resetting threshold corresponds to the reset-point threshold of the device (this value varies along with the discharging current selected by the dipswitch (A) and is close to the battery nominal value). When the voltage value corresponding to the stopping threshold is reached, the last yellow LED will flash for 15 seconds, then the red LED will turn on, and the blocking relay will open. To reset, switch off the battery level indicator, charge the batteries, and then switch on the machine.

BDI OPERATION

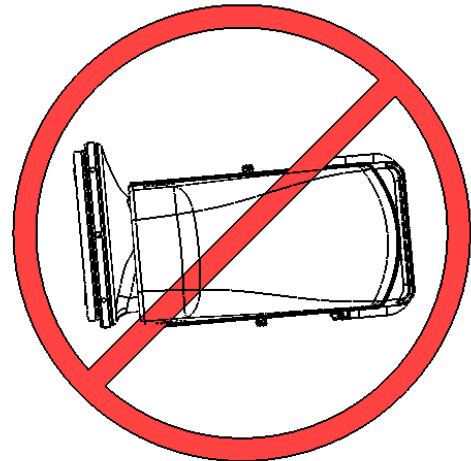
When the battery level indicator is switched on, the battery voltage is measured, and:

- If the voltage is below the stopping voltage, the machine will not run.
- If the voltage is higher than the resetting threshold, all the LED's will turn on again and the battery level indicator will reset and the machine will run.
- If the voltage ranges between the stopping voltage and the resetting voltage, the LED's will turn on rapidly according to the condition prior to the switching off. If the previous condition was a stop, the last yellow LED will flash.

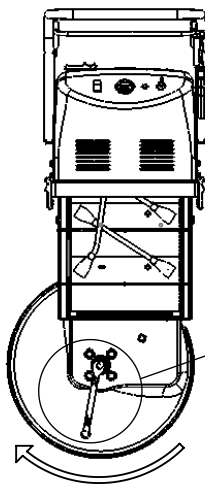
PAD CHANGING INSTRUCTIONS



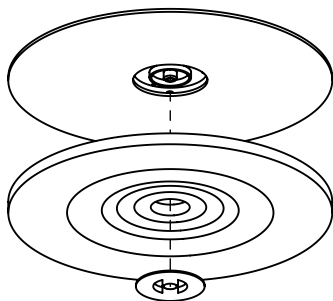
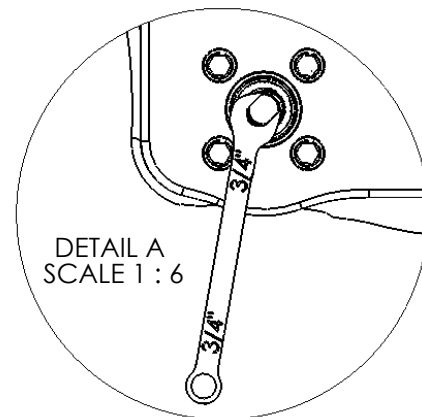
**TILT MACHINE BACK AND
REMOVE FRONT COVER**



DO NOT TILT MACHINE ON ITS SIDE

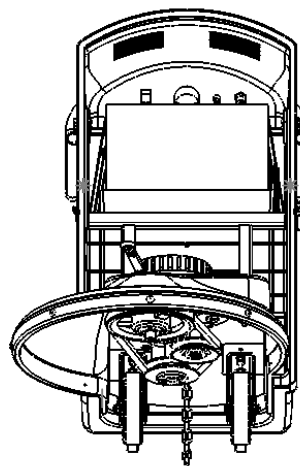


**USE 3/4" OPEN END
WRENCH TO SECURE
SHAFT AND SPIN
PAD DRIVER OFF
SHAFT BY HAND**

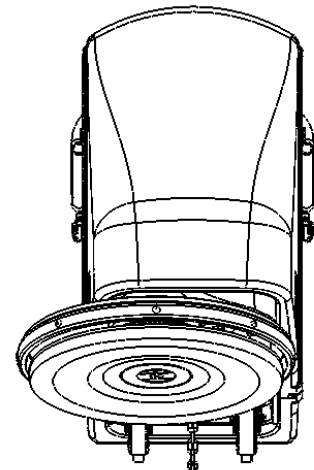


**CENTER THE PAD ON PAD HOLDER
AND TIGHTEN CENTER LOCK**

**USE THE HI-SHINE LIGHT BURNISH PAD
21" IS PART NUMBER F084621 (5 PER CASE)
27" IS PART NUMBER F084627 (5 PER CASE)**

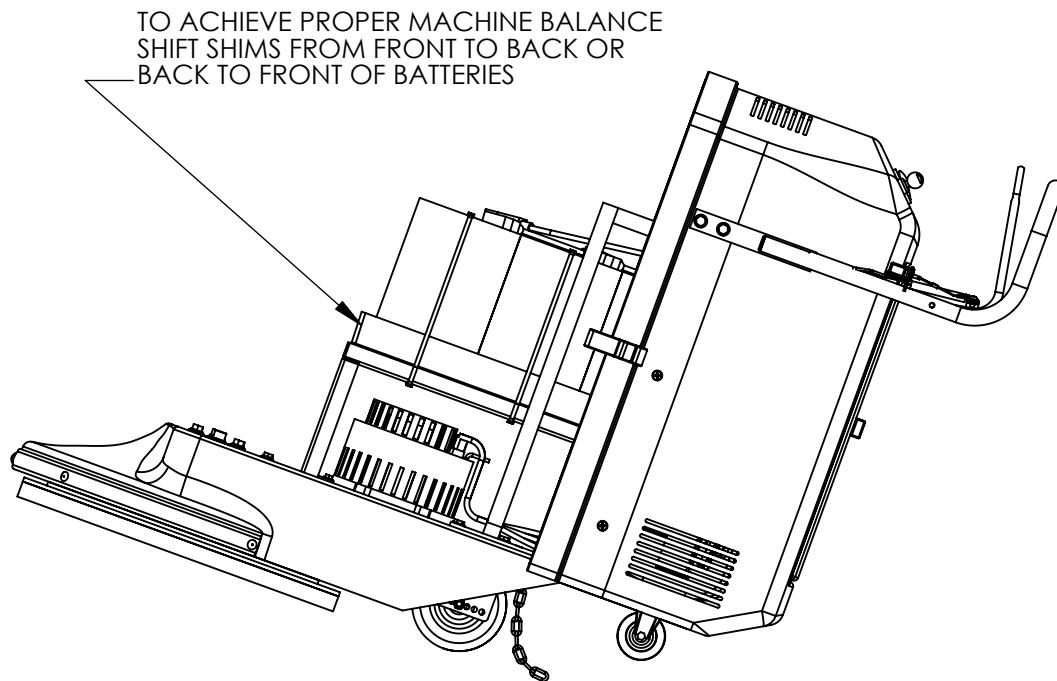


**SPIN PAD DRIVER BACK ONTO SHAFT
AND REPLACE COVER**



**NOTE: PAD CAN BE CHANGED ON THE MACHINE WITHOUT REMOVING PAD DRIVER,
BUT YOU MUST GET ON THE FLOOR AND BE SURE THAT PAD IS CENTERED ON PAD DRIVER.**

BALANCING INSTRUCTIONS



For best operation and maximum battery life, the XTG3 battery burnisher must have the correct pad pressure. The following setup may not seem to be enough pressure, but during operation, much more pad pressure is created by a vacuum which is created under the spinning pad.

The burnisher should require only minor adjustments to the balance. Only the battery shims should be adjusted. The wheel axels should be in the proper locations in the wheel brackets.

Tilt the burnisher back. Remove front cover.
Tilt burnisher to upright position.

With a new pad, the burnisher should hesitate and then barely fall back.
With a worn pad, the burnisher should barely sit upright.

If burnisher falls back easily, then the batteries need to be moved forward.

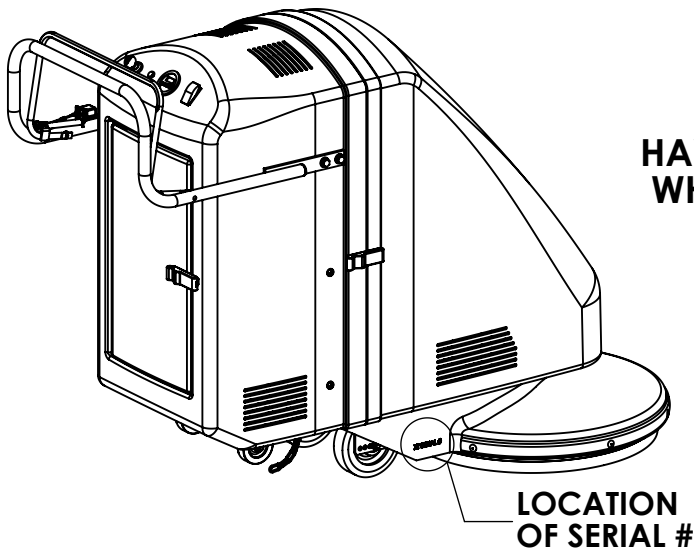
- Remove several battery spacers from front of batteries
- Slide batteries forward
- Add spacer(s) to rear of batteries
- Slide batteries tight against rear spacers (can be done by tilting machine back quickly)
- Replace remaining spacers in front of batteries (batteries should now be "locked" into position)

If burnisher sits upright easily, then the batteries need to be moved back.

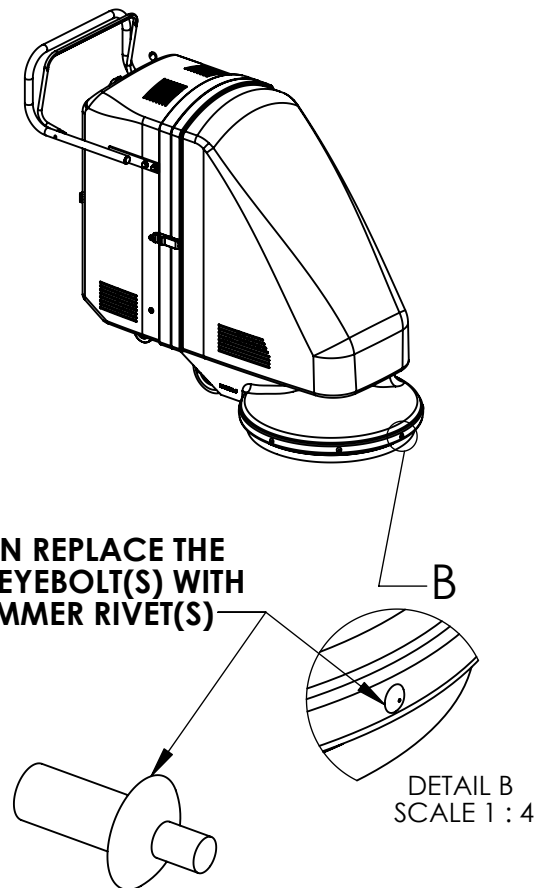
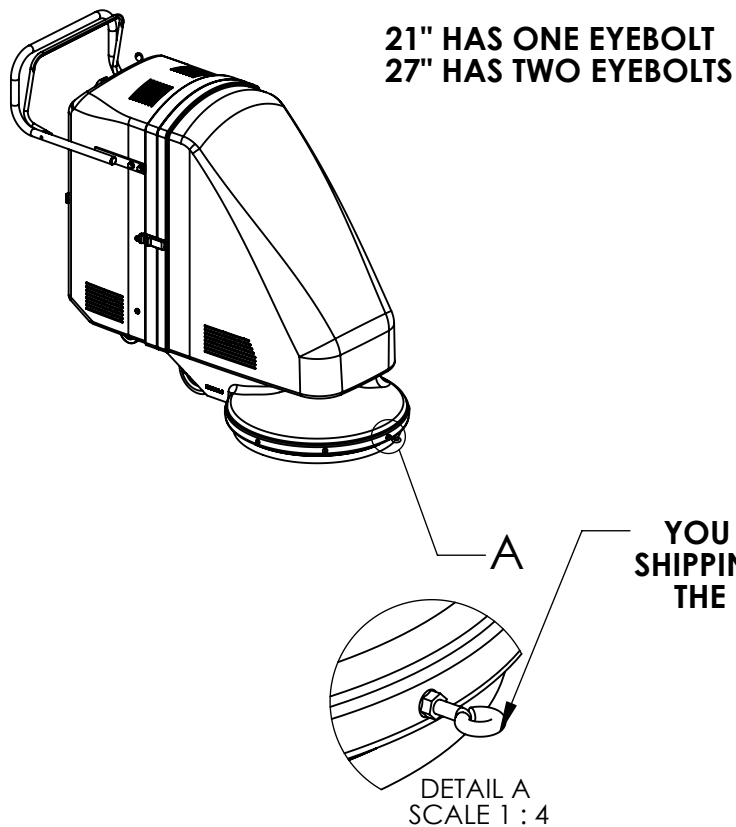
- Remove some battery spacer(s) from rear of batteries
- Slide batteries back
- Replace remaining spacers in front of batteries (batteries should now be "locked" into position)

If batteries are moved as far as possible and proper balance cannot be achieved, then one of the wheels may be moved to achieve balance. The burnisher is factory balanced, so this is usually not necessary unless different batteries are installed by the customer. Most of the time, only one wheel needs to be moved. Any stagger of the wheels should have the left wheel in front (to the front of the machine) of the right wheel.

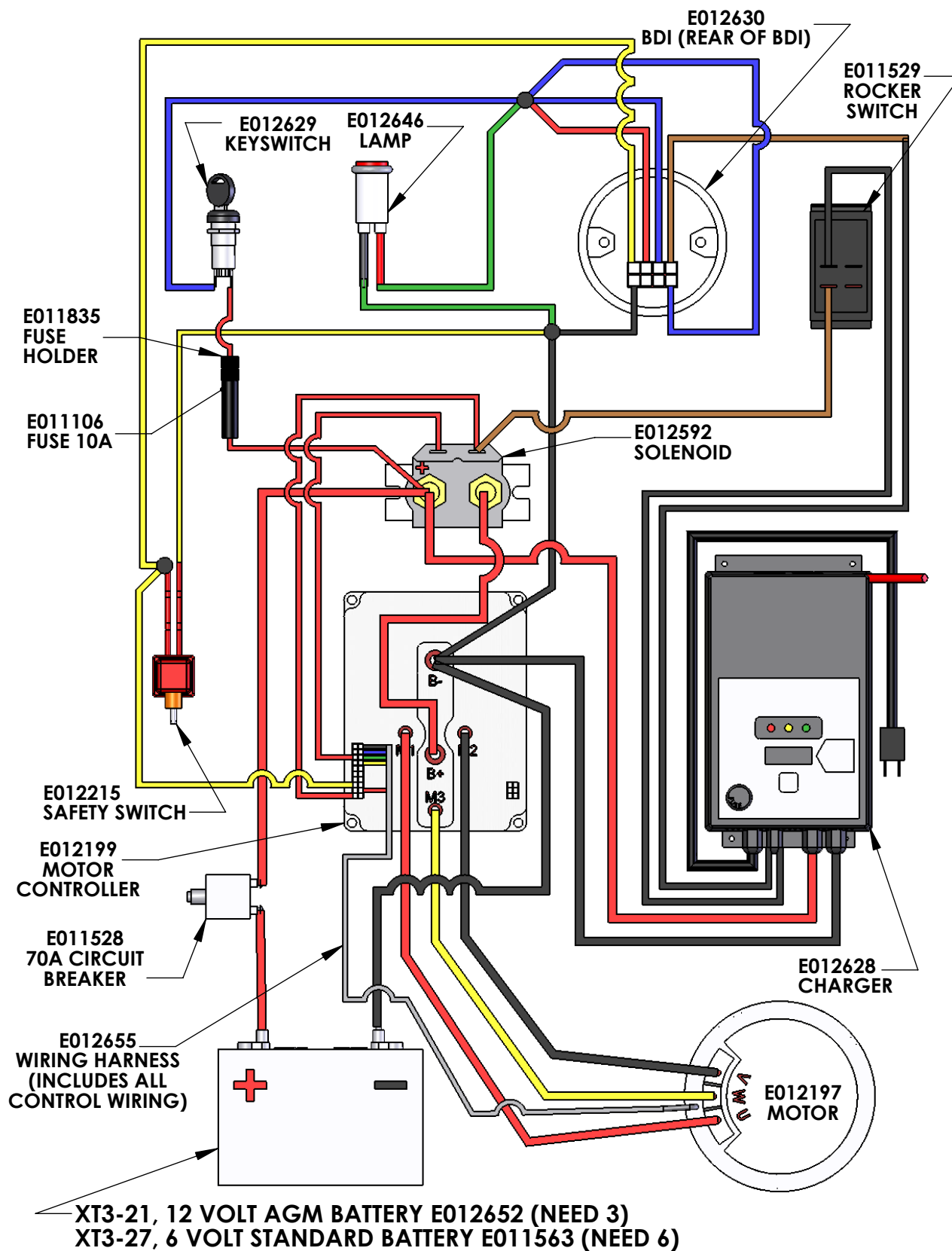
SERIAL NUMBER LOCATION AND SHIPPING EYEBOLT REPLACEMENT



**HAVE SERIAL NUMBER AVAILABLE
WHEN CALLING SERVICE CENTER
FOR PARTS OR SERVICE**



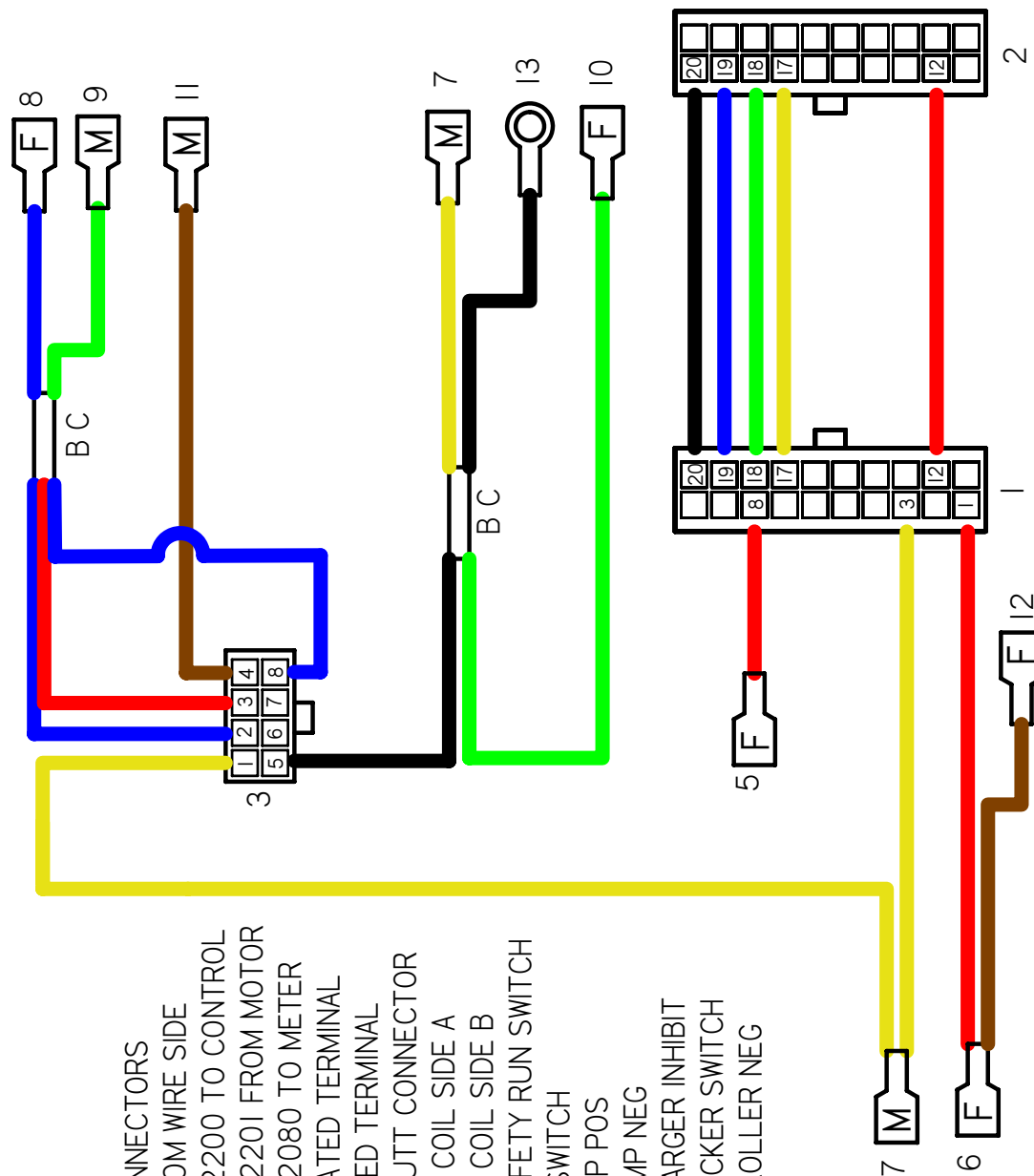
ELECTRICAL LAYOUT



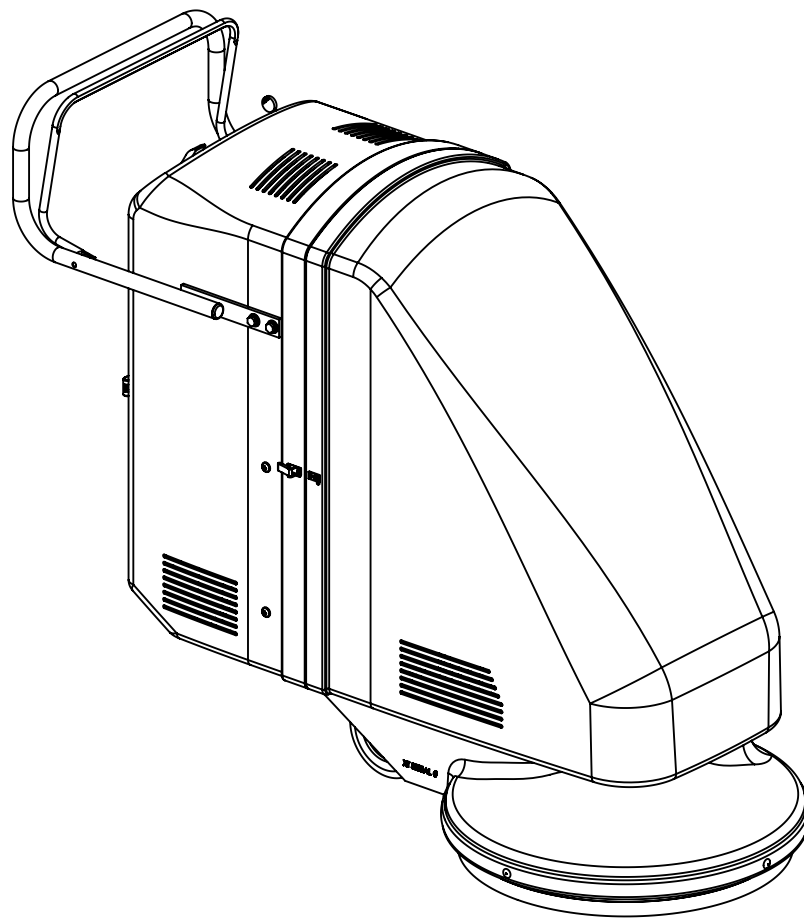
ALSO SEE OTHER PAGES FOR:

- K - KEY SWITCH
R - ROCKER SWITCH
S - SAFETY RUN SWITCH
CB - CIRCUIT BREAKER
F - FUSE
- ELECTRICAL AND BATTERY VIEW
- ELECTRICAL LAYOUT
- WIRING HARNESS
- BATTERY DISCHARGE AND HOUR METER INFORMATION

WIRING HARNESS



XT3-21 PARTS AND INFORMATION SECTION

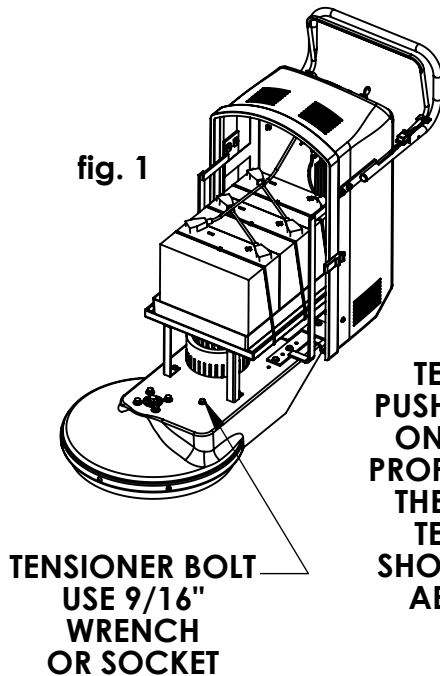


XT3-21 SPECIFICATIONS

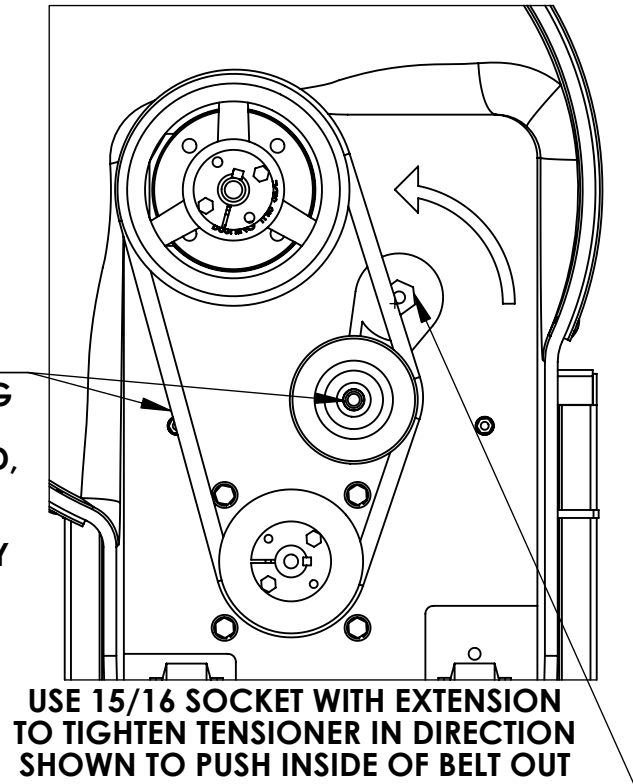
Pad size and burnish path	21"
Motor	Brushless, computer controlled, maintenance free, rated at 5hp
Motor controller	Computer keeps motor at constant speed
Pad pressure	25 lbs.
Motor speed	2000 rpm
Pad Driver	Flex Lock III
Noise level	70db (at operator)
Voltage	36 volt system
Batteries	(3 batteries) 12 volt each, Maintenance free, AGM technology, 140 amp hour,
Battery maintenance	AGM (Absorbed Glass Mat) batteries are standard. No watering. Just charge after use.
Run time	2 to 3 hours
Battery charger	On board charger. High frequency. Computer controlled
Battery gauge	BDI (Battery Discharge Indicator) Computer controlled
Hour meter	BDI also has a built in hour meter
Key switch	System power on. Heavy duty switch.
Safety switch	Spring loaded normally open switch is connected to safety run lever
Length	68"
Width	30"
Height	40.5"
Weight	484 lbs.
Productivity (3" overlap, 2.5 miles/hour)	19,800 sq.ft./hour

XT3-21 BELT TENSIONING INSTRUCTIONS

figure 2
DETAIL VIEW OF BELT AND TENSIONER



TEST TENSION BY
PUSHING OR PULLING
ON BELT. WITH BELT
PROPERLY TENSIONED,
THE PULLEY ON THE
TENSIONER ARM
SHOULD MOVE ONLY
ABOUT AN INCH.

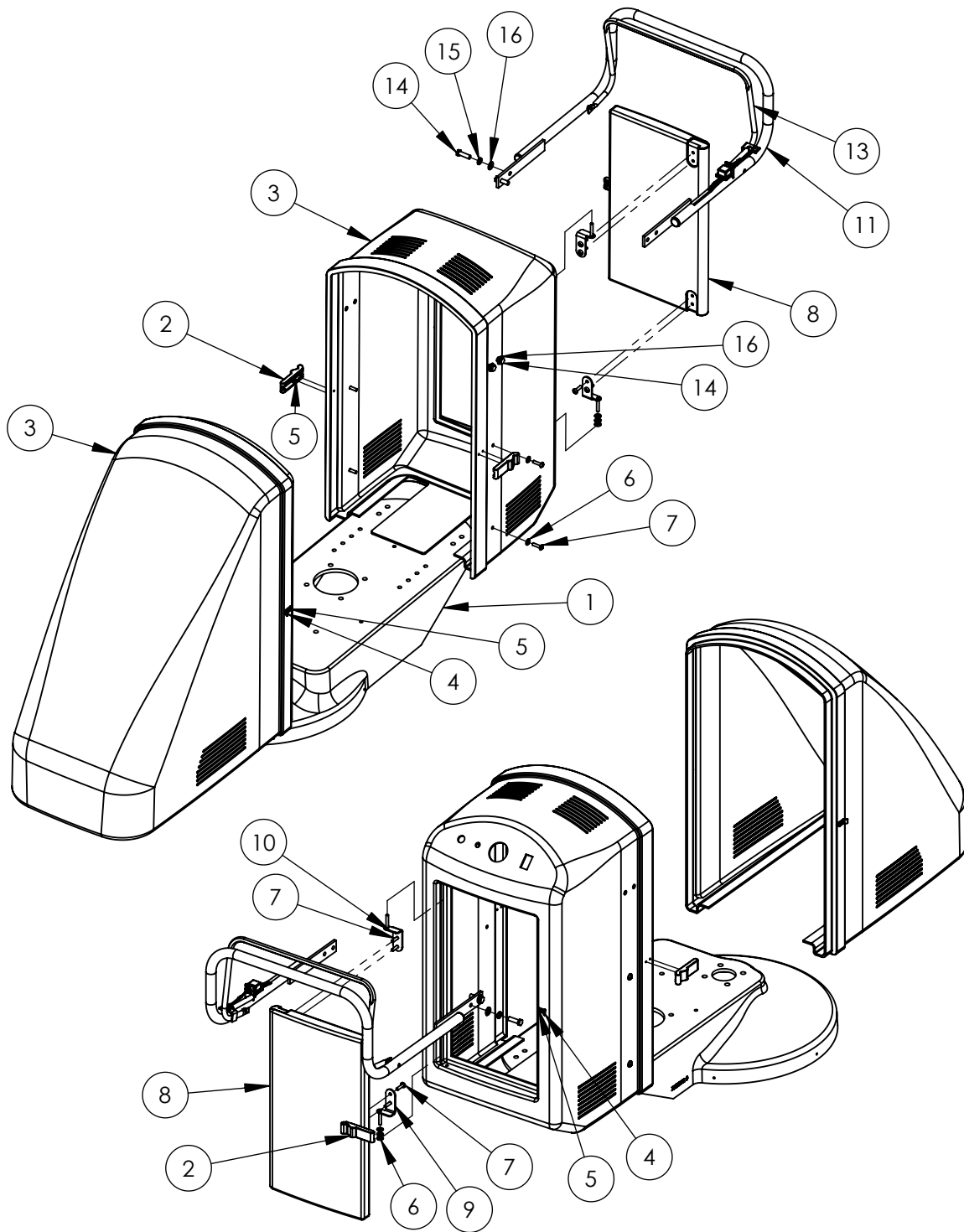


TO TIGHTEN THE BELT TENSIONER

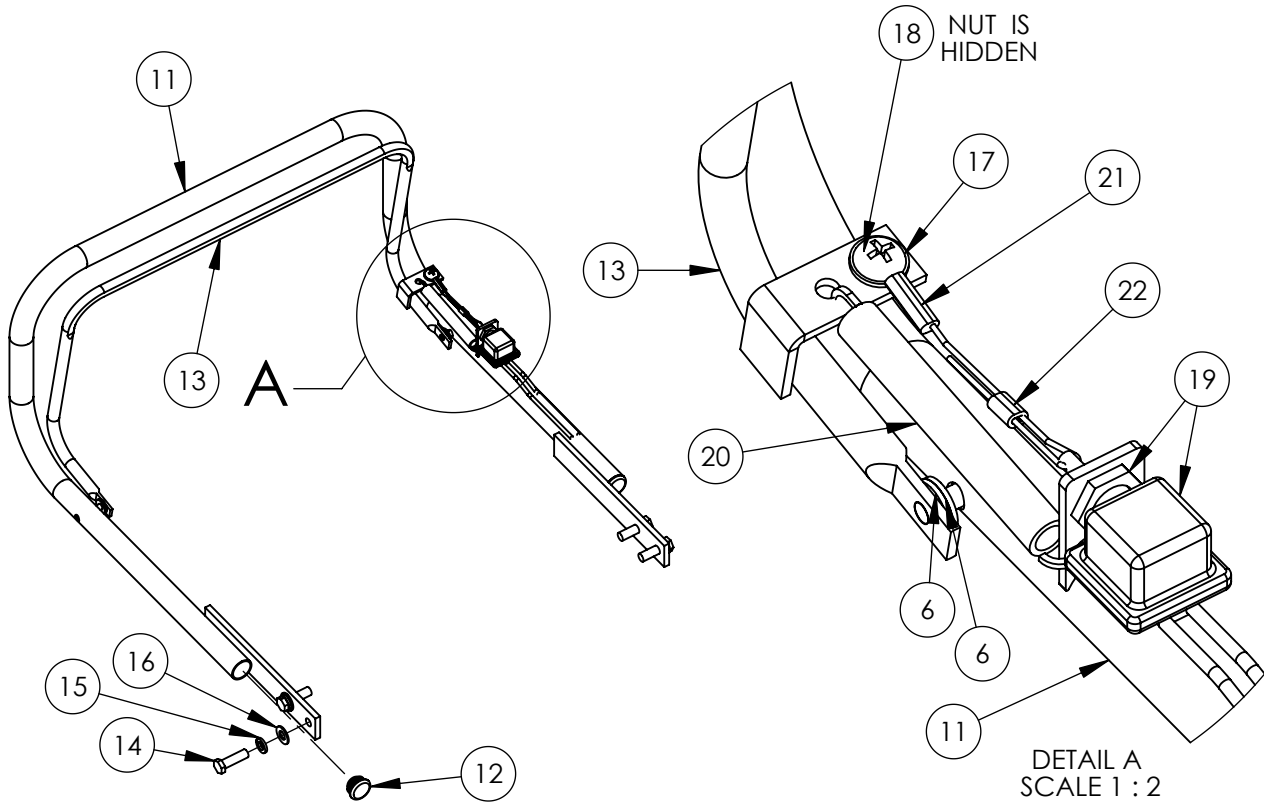
(Tensioner may have slipped, or belt may have stretched)

1. Tilt machine back and remove front cover
2. Using a 3/4" open end wrench, secure the top of the shaft and remove pad driver assembly. (see "Pad Changing Instructions" page)
3. On the top of the deck, use a 9/16" wrench or socket to loosen tensioner bolt. Leave a little snug to help hold tensioner in place after adjustment. (location shown in fig. 1)
4. Using a 15/16" socket with an extension, fully tighten tensioner from the underside of deck, and back off 10 to 15 degrees. This will be about 2 inches at the end of the socket handle. (Note: This is about one mark on the tensioner. There are five marks on the side of the tensioner, which are difficult to see with the tensioner in place. Each mark is equal to about 15 degrees. This leaves the tensioner at about 60 degrees of tightness.)(see figure 2)
5. While holding position tensioner in this proper location, fully tighten the tensioner bolt from the top. **TIGHTEN SECURELY!**
6. Make sure tensioner did not slip by pushing or pulling on side of belt away from tensioner. Belt should be tight and move the tensioner arm 10 to 15 degrees (about 1").

XT3-21 COVER AND HANDLE

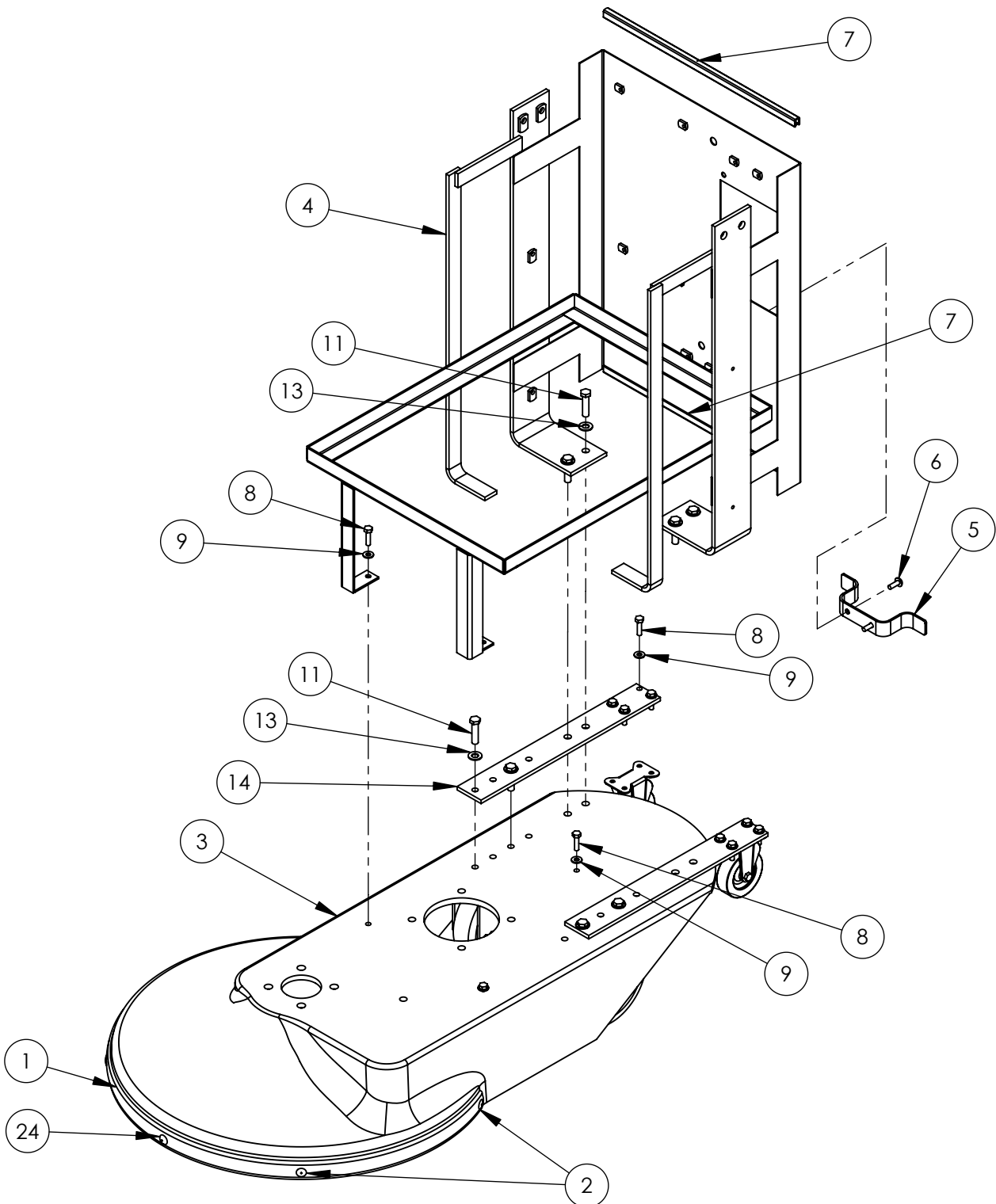


XT3-21 COVER AND HANDLE

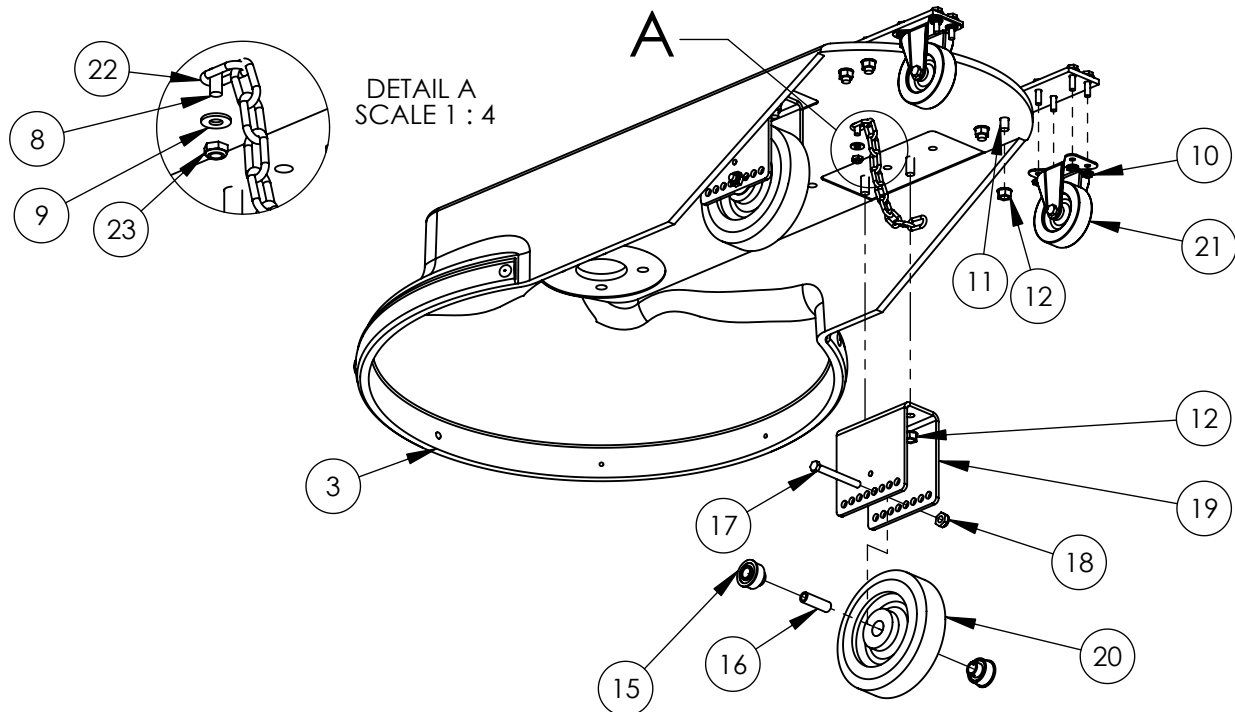


ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E012653	1	21" DURACOAT MILLED DECK
2	E012633	3	LATCH, RUBBER DRAW (PART 1 OF 2)
3	E012625	1	ROTOMOLDED SHROUD XT21G3
4	E012633	3	LATCH, RUBBER DRAW (PART 2 OF 2)
5	E012676	12	RIVET, LOAD SPREADING, 5/32"
6	E011834	11	WASHER, FLAT, 1/4
7	E012219	8	SCREW, 1/4-20 x 1, PHMS, BLACK
8	E012632	1	DOOR, ACCESS
9	E012640	1	HINGE WELDMENT A
10	E012641	1	HINGE WELDMENT B
11	E012638	1	HANDLE, MAIN XTG3
12	E010259	2	CAP, TUBING, BLACK, 1"
13	E012639	1	HANDLE, SAFETY SHUTOFF XTG3
14	E011051	4	BOLT, HEX, 1/4-20 x 1.25
15	E011504	4	WASHER, LOCK, 3/8
16	E011136	4	WASHER, FLAT, 3/8 SAE
17	E011122	1	SCREW, 1/4-20 x .5, PHMS, SS
18	E012242	1	NUT, FLANGED, 1/4-20
19	E012215	1	SWITCH, SAFETY SHUTOFF
20	E011565	1	SPRING, HANDLE RETURN
21	E011553	1	LANYARD 3/64 x 6"
22	E012221	1	SLEEVE FOR LANYARD, ALUMINUM

XT3-21 DECK, FRAME, AND WHEELS

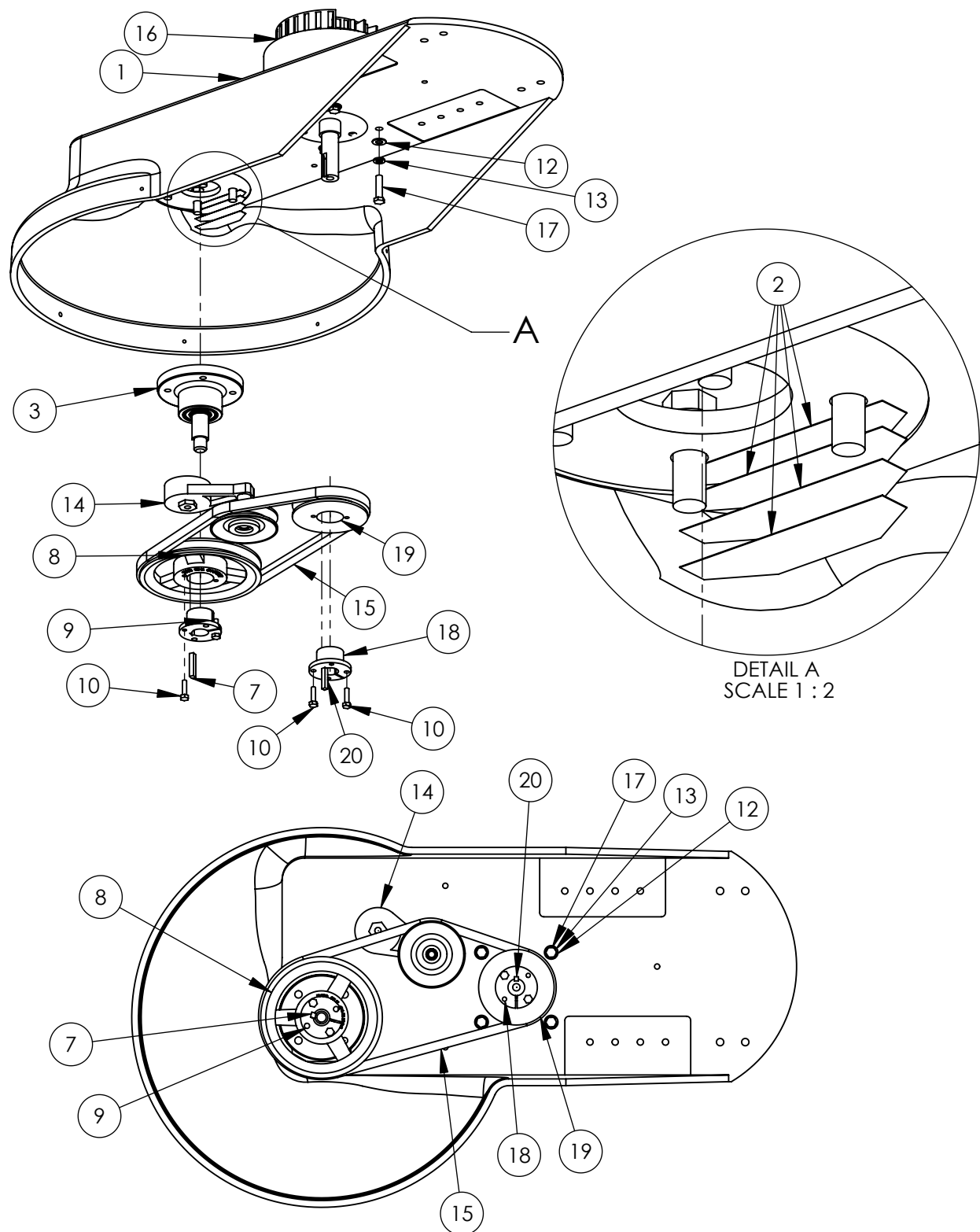


XT3-21 DECK, FRAME, AND WHEELS

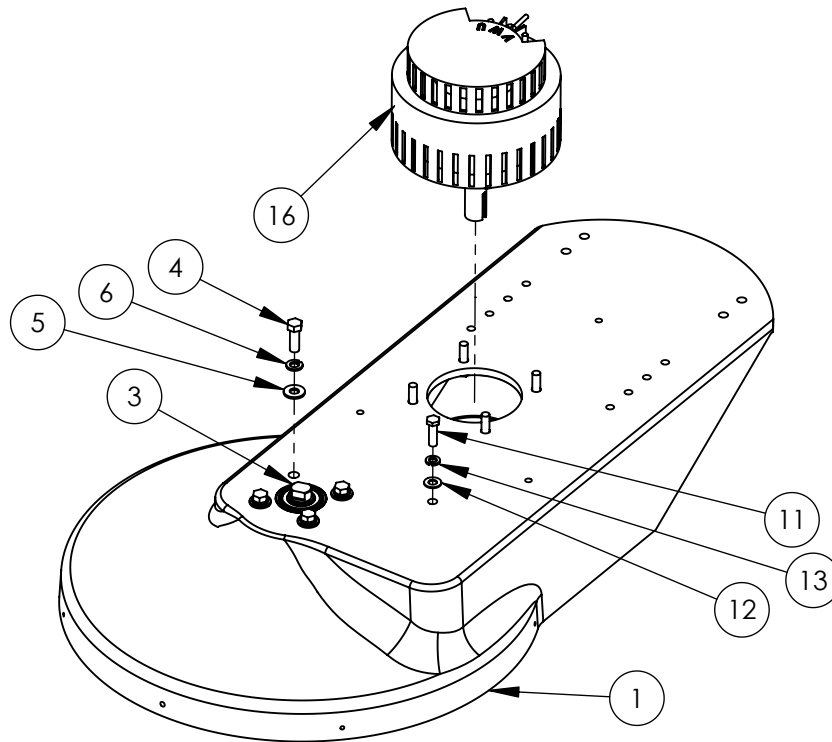


ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E010705	1	BUMPER GUARD, RED
2	E011531	5	RIVET, T-RIVET, BSP T63
3	E012653	1	21" DURACOAT MILLED DECK
4	E012634	1	FULL MOUNT FOR XT21
5	E012643	1	CHARGER CORD WRAP
6	E011833	2	SCREW, 1/4-20 x .75, PHMS, BLACK
7	E012204	2	TRIM, EDGE, SOLD BY THE FOOT
8	E012248	11	BOLT, HEX, 1/4-20 x 1
9	E011133	12	WASHER, FLAT, 1/4
10	E012242	10	NUT, FLANGED, 1/4-20
11	E011424	8	BOLT, HH, 3/8-16 x 1.5
12	E011432	8	NUT, FLANGE, 3/8-16
13	E011136	8	WASHER, FLAT, 3/8 SAE
14	E012635	2	HANDLE TO BASE MOUNT FOR XT21
15	E012672	4	BEARING, SEALED BALL BEARING FOR WHEEL
16	*	2	BUSHING, WHEEL, 1.5 x .5 OD x .312 ID
17	E012675	2	BOLT, HH, 5/16 - 18 x 2.75
18	E011176	2	NUT, NYLOC, 5/16-18
19	E012644	2	ADJUSTABLE WHEEL BRACKET 4.062 AXLE
20	E012285	2	WHEEL, 6" x 1.5" WITH BUSHING
21	E012237	2	CASTER, 3" WITH GREY WHEEL
22	E012656	1	CHAIN, STAINLESS, STATIC, SOLD BY THE FOOT
23	E012242	1	NUT, NYLOCK, 1/4-20
24	E012584	1	RIVET, 3/8" HAMMER RIVET

XT3-21 MOTOR, PULLEYS, AND BELT

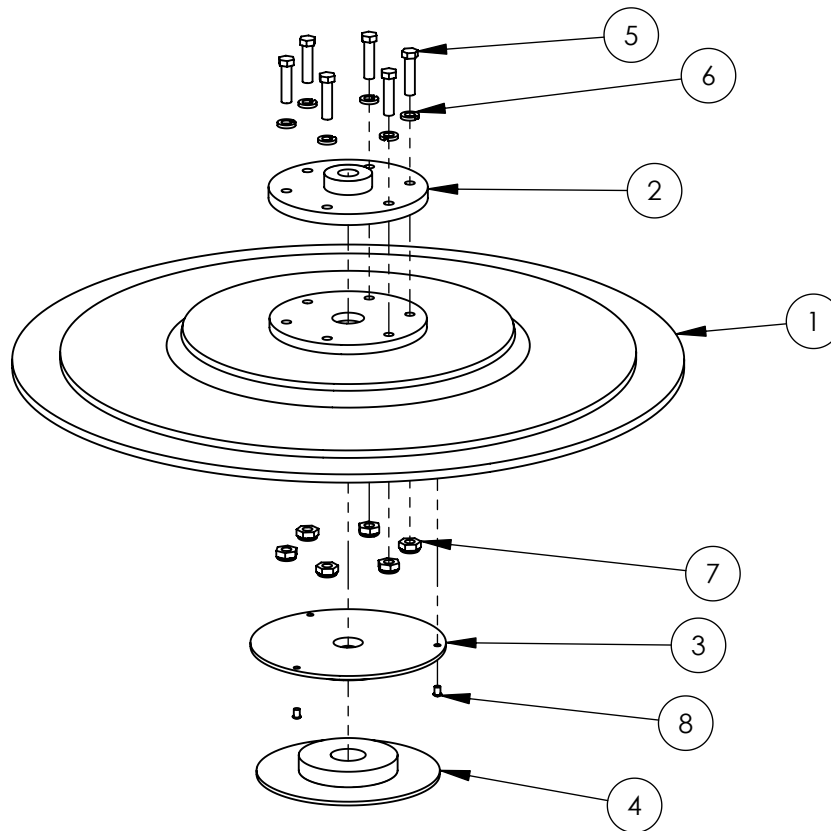


XT3-21 MOTOR, PULLEYS, AND BELT



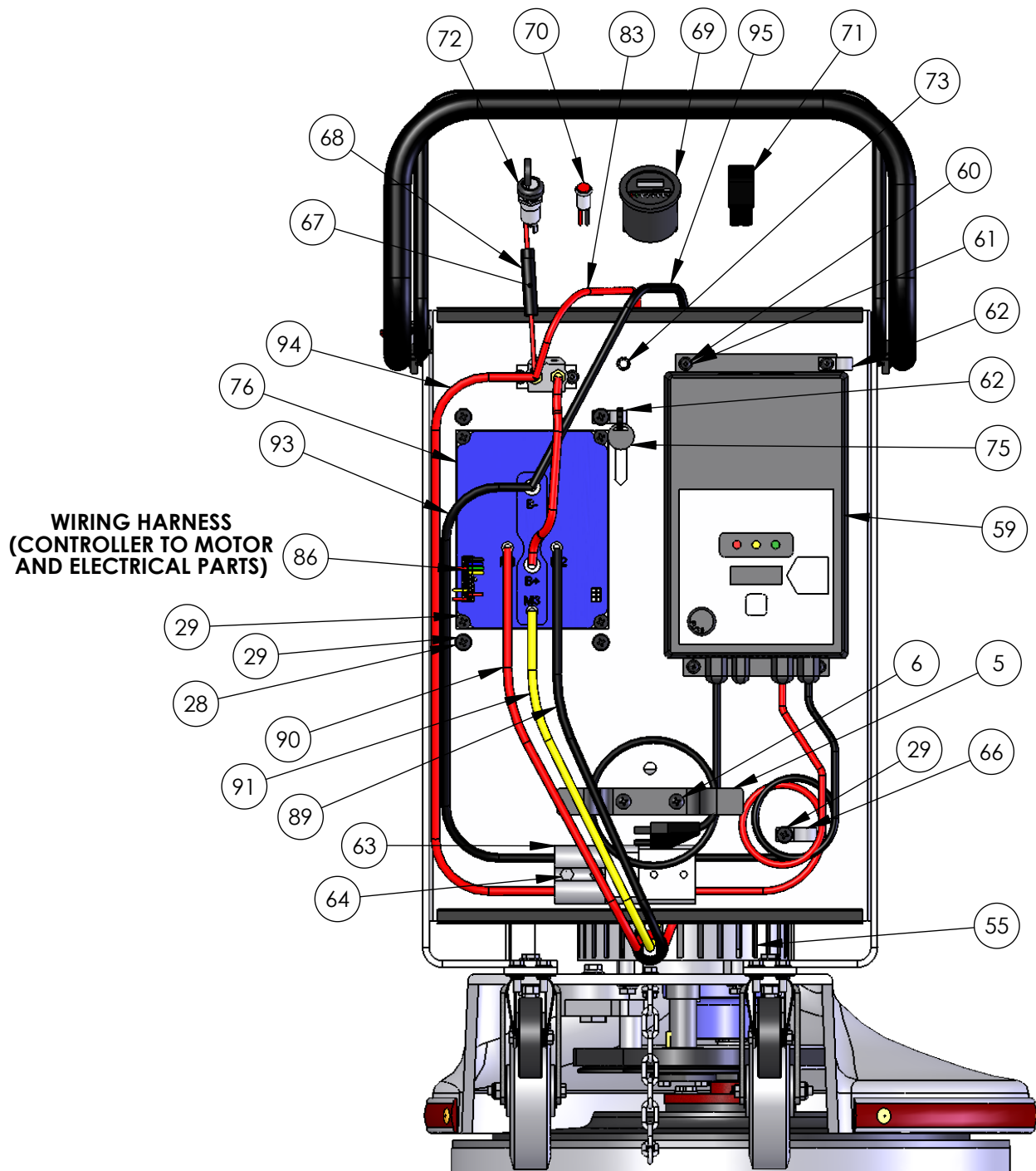
ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E012653	1	21" DURACOAT MILLED DECK
2	*	4	SHIM FOR FRONT END BEARING HOUSING
3	E012284	1	BEARING AND SHAFT ASSEMBLY
4	E010116	4	BOLT, 7/16-14 x 1.25
5	E012218	4	WASHER, FLAT, 7/16 SAE
6	E012217	4	WASHER, LOCK, 7/16
7	E012459	1	KEYSTOCK, 7mm x 8mm x 30mm
8	E012401	1	PULLEY, 7.5 OD, QT STYLE
9	E012400	1	PULLEY BUSHING, 25MM SHAFT, QT STYLE
10	E012248	4	BOLT, HEX, 1/4-20 x 1
11	E011051	1	BOLT, HEX, 1/4-20 x 1.25
12	E011136	5	WASHER, FLAT, 3/8 SAE
13	E011504	5	WASHER, LOCK, 3/8
14	E010459	1	BELT TENSIONER, SMALL FOR XT
15	E010107	1	BELT, BX40
16	E012197	1	MOTOR, 36 VDC, BRUSHLESS
17	E011424	4	BOLT, HH, 3/8-16 x 1.5
18	E012663	1	PULLEY BUSHING, 1" SHAFT, QT STYLE
19	E012662	1	PULLEY, BK45QT
20	E011723	1	KEYSTOCK, 1/4 x 1/4

XT3-21 FLEX-LOC PAD DRIVER ASSEMBLY (COMPLETE ASSEMBLY- PE50028)



ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E010250	1	FLEX-LOC 21
2	E010586	1	SHAFT TO PAD DRIVER COUPLING
3	E012517	1	CENTER-LOC 2 (COMES AS A SET 1 OF 2)
4	E012517	1	CENTER-LOC 2 (COMES AS A SET 2 OF 2)
5	E012247	6	BOLT, HEX, 5/16-18 x 1.25
6	E011505	6	WASHER, LOCK, 5/16
7	E011176	6	NUT, NYLOC, 5/16-18
8	E010118	3	RIVET, AAP64

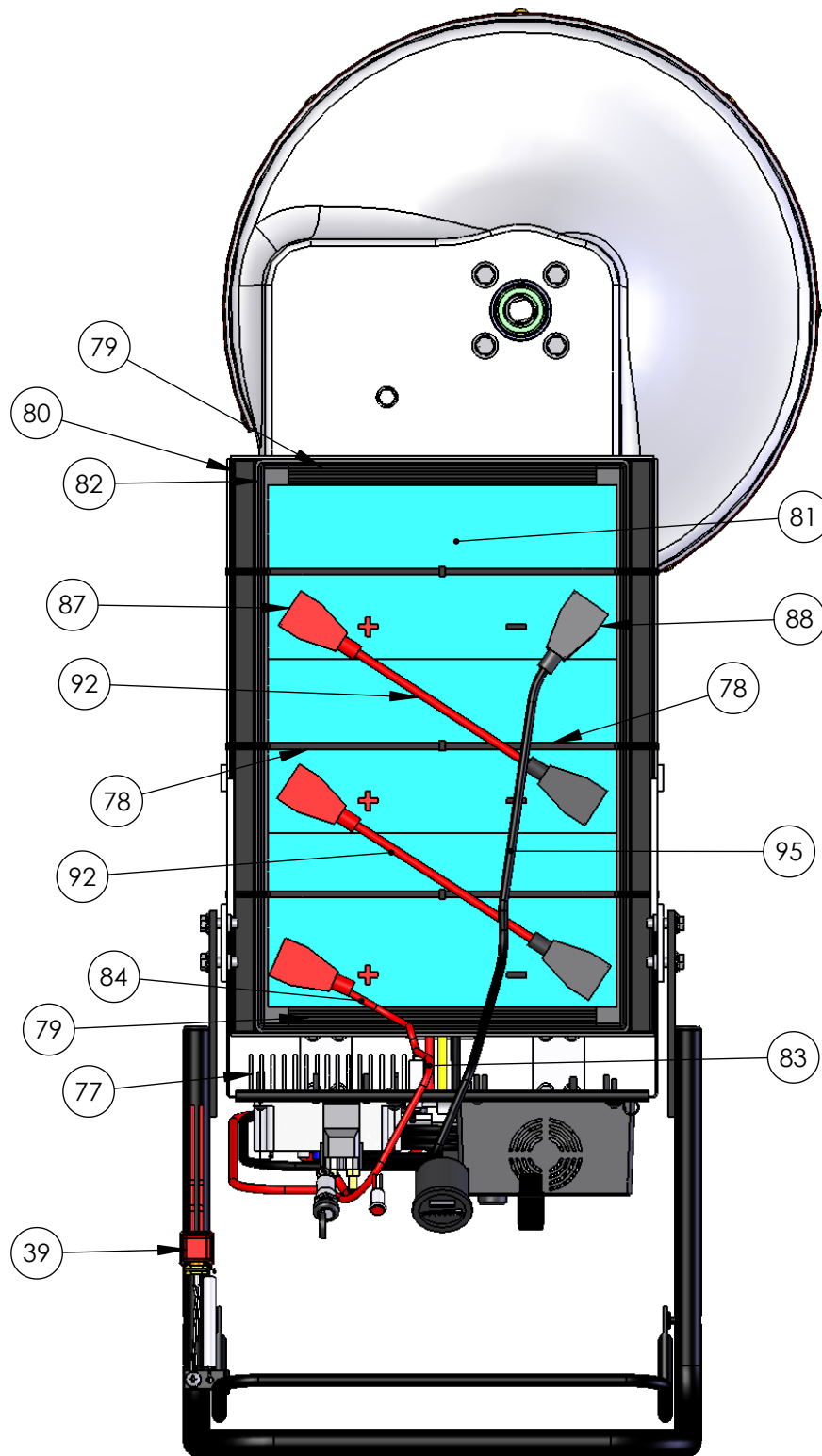
XT3-21 ELECTRICAL AND BATTERY VIEW



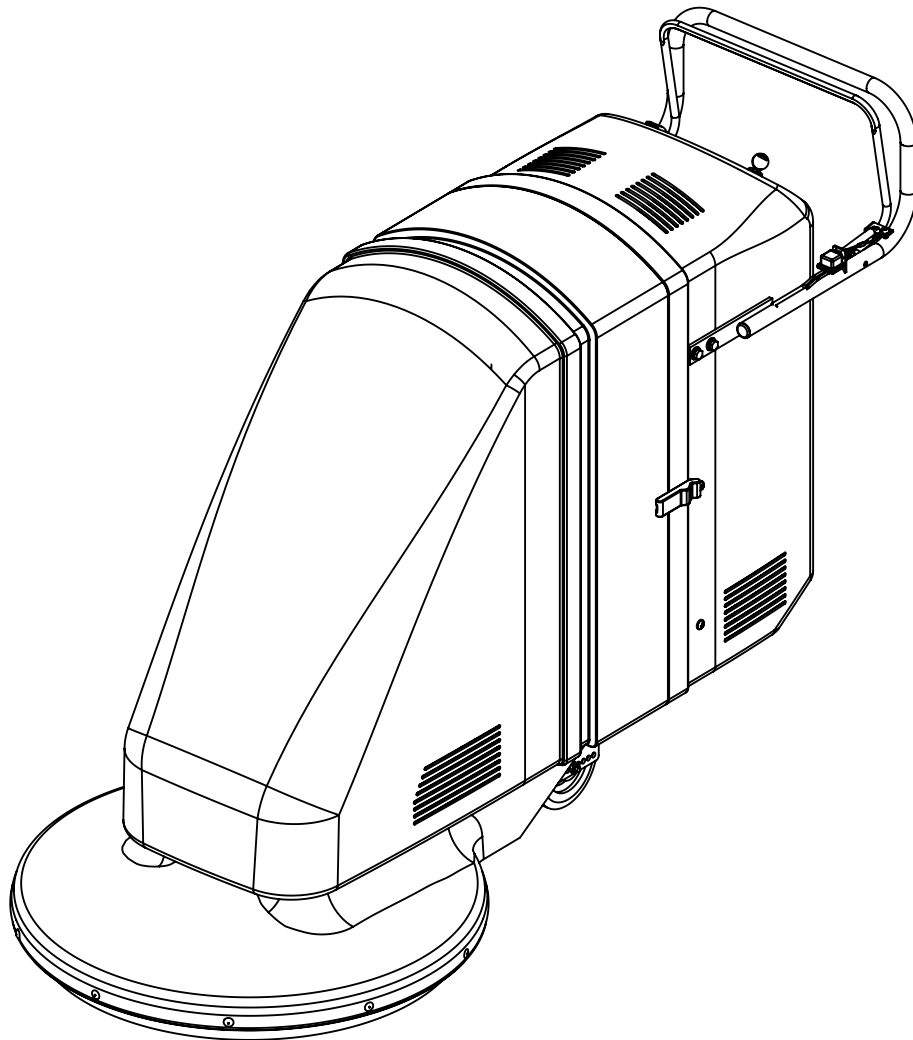
XT3-21 ELECTRICAL AND BATTERY VIEW

ITEM NO.	PART NO.	QTY.	DESCRIPTION
5	E012643	1	CHARGER CORD WRAP
6	E011833	2	SCREW, 1/4-20 x .75, PHMS, BLACK
28	E011834	16	WASHER, FLAT, 1/4
29	E012219	17	SCREW, 1/4-20 x 1, PHMS, BLACK
55	E012197	1	MOTOR, 36 VDC, BRUSHLESS
59	E012628	1	CHARGER, ON-BOARD, SPE WITH CORDS
60	E012219	6	SCREW, 10-24 x 1, PHMS, BLACK
61	E011834	6	WASHER, #10, SAE, BLACK
62	E010137	2	TUBE CLIP, .5, COV-0909
63	E010878	1	ELECTRICAL PLUG, SB-175, GREY, 36 VOLT
64	E011623	2	BOLT, HH, 1/4-20 x 1.25
65	E012592	1	SOLENOID, 36V, CURTIS-ALRIGHT
66	E011353	1	TUBE CLIP, .75 COV-1309
67	E011106	1	FUSE, 10 AMP, AGC, 1.25" LONG
68	E011835	1	FUSE HOLDER, FOR 1.25" AGC FUSE
69	E012630	1	BDI (BATTERY DISCHARGE INDICATOR AND HOUR METER)
70	E012646	1	LAMP, LED, 36V
71	E011529	1	SWITCH, ROCKER, DPST
72	E012629	1	KEYSWITCH, HEAVY DUTY WITH 2 KEYS
73	E011528	1	CIRCUIT BREAKER, 70 AMP
74	E010708	1	CABLE TIE, BLACK, 7.5"
75	*	1	SPARE KEY
76	E012199	1	MOTOR CONTROLLER
77	E012631	1	HEAT SINK
78	E012561	6	CABLE TIE, BLACK, AF529
79	E012660	14	SHIM, PLASTIC, 12 x 1.5 x .125
80	E012642	1	BATTERY TRAY STEEL
81	E012652	3	BATTERY, AGM, MAINTENANCE FREE
82	E012624	1	BATTERY TRAY, PLASTIC, 3 BATTERIES
83	E010133	1	WIRE, BATTERY CABLE, RED, 4 GA x 11"
84	E012568	1	WIRE, BATTERY CABLE, 4GA x 7.75"
85	E012673	1	LOOM, 1" DIA
86	E012655	1	WIRING HARNESS FOR XT3
87	E012543	3	TERMINAL PROTECTOR, STRAIGHT, RED
88	E012542	3	TERMINAL PROTECTOR, STRAIGHT, BLACK
89	E012562	1	WIRE, BATTERY CABLE, 4 GA, BLACK, 36"
90	E012563	1	WIRE, BATTERY CABLE, 4 GA, RED, 36"
91	E012669	1	WIRE, BATTERY CABLE, 4 GA, RED WITH YELLOW ENDS, 33"
92	E011139	2	WIRE, BATTERY CABLE, 4 GA, BLACK OR RED, 16"
93	E012565	1	WIRE, BATTERY CABLE, 4 GA, BLACK, CHARGING, 24"
94	E012564	1	WIRE, BATTERY CABLE, 4 GA, RED, CHARGING, 28"
95	E012562	1	WIRE, BATTERY CABLE, 4GA, BLACK, 36"
96	E011837	1	WIRE, BATTERY CABLE, 4 GA, RED, 7"

XT3-21 ELECTRICAL AND BATTERY VIEW



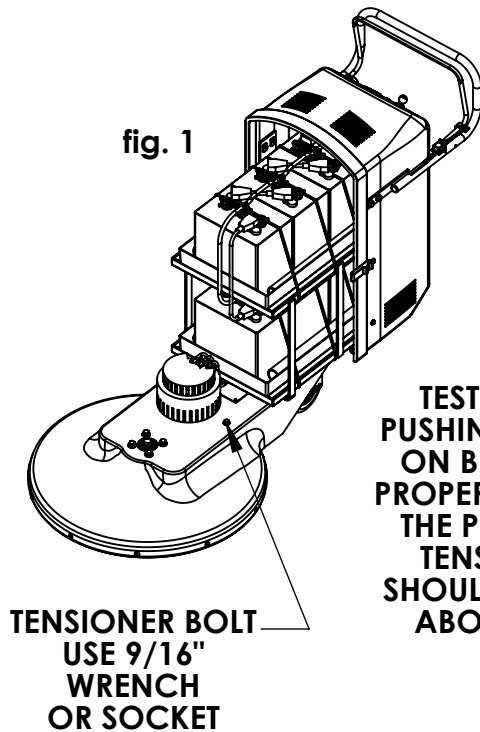
XT3-27 PARTS AND INFORMATION SECTION



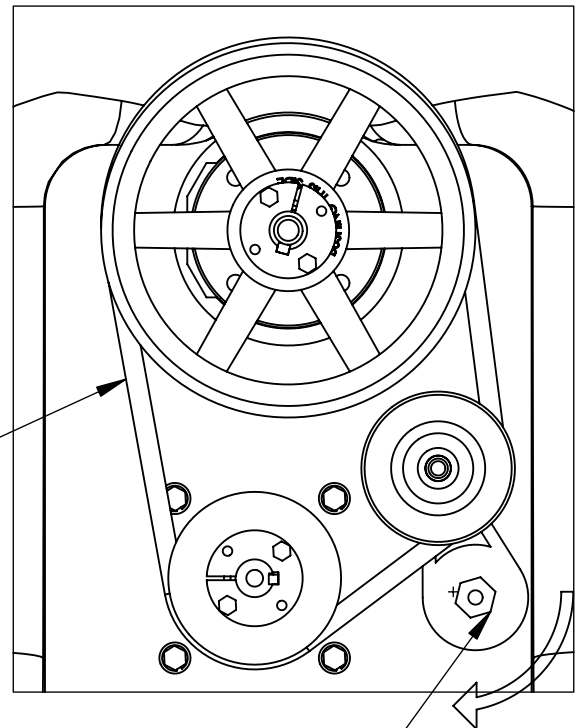
XT3-27 SPECIFICATIONS

Pad size and burnish path	27"
Motor	Brushless, computer controlled, maintenance free, rated at 5hp
Motor controller	Computer keeps motor at constant speed
Pad pressure	30 lbs.
Motor speed	2000 rpm
Pad Driver	Flex Lock III
Noise level	70db (at operator)
Voltage	36 volt system
Batteries	(6 batteries) 6 volts each, 225 amp hour,
Battery maintenance	"Pro-Fill" on-board watering system
Run time	2 to 3 hours
Battery charger	On board charger. High frequency. Computer controlled
Battery gauge	BDI (Battery Discharge Indicator) Computer controlled
Hour meter	BDI also has a built in hour meter
Key switch	System power on. Heavy duty switch.
Safety switch	Spring loaded normally open switch is connected to safety run lever
Length	68"
Width	30"
Height	40.5"
Weight	616 lbs.
Productivity (3" overlap, 2.5 miles/hour)	29,800 sq.ft./hour

figure 2
DETAIL VIEW OF BELT AND TENSIONER



TEST TENSION BY
PUSHING OR PULLING
ON BELT. WITH BELT
PROPERLY TENSIONED,
THE PULLEY ON THE
TENSIONER ARM
SHOULD MOVE ONLY
ABOUT AN INCH.



USE 15/16 SOCKET WITH EXTENSION
TO TIGHTEN TENSIONER IN DIRECTION
SHOWN TO PUSH INSIDE OF BELT OUT

TO TIGHTEN THE BELT TENSIONER

(Tensioner may have slipped, or belt may have stretched)

1. Tilt machine back and remove front cover
2. Using a 3/4" open end wrench, secure the top of the shaft and remove pad driver assembly. (see "Pad Changing Instructions" page)
3. On the top of the deck, use a 9/16" wrench or socket to loosen tensioner bolt. Leave a little snug to help hold tensioner in place after adjustment. (location shown in fig. 1)
4. Using a 15/16" socket with an extension, fully tighten tensioner from the underside of deck, and back off 10 to 15 degrees. This will be about 2 inches at the end of the socket handle. (Note: This is about one mark on the tensioner. There are five marks on the side of the tensioner, which are difficult to see with the tensioner in place. Each mark is equal to about 15 degrees. This leaves the tensioner at about 60 degrees of tightness.)(see figure 2)
5. While holding position tensioner in this proper location, fully tighten the tensioner bolt from the top. **TIGHTEN SECURELY!**
6. Make sure tensioner did not slip by pushing or pulling on side of belt away from tensioner. Belt should be tight and move the tensioner arm 10 to 15 degrees (about 1 ").

WATERING SYSTEM INSTRUCTIONS

FOR 6 VOLT WET CELL BATTERIES

PLEASE REFER TO SEPARATE

“PRO-FILL ON-BOARD WATERING SYSTEM”

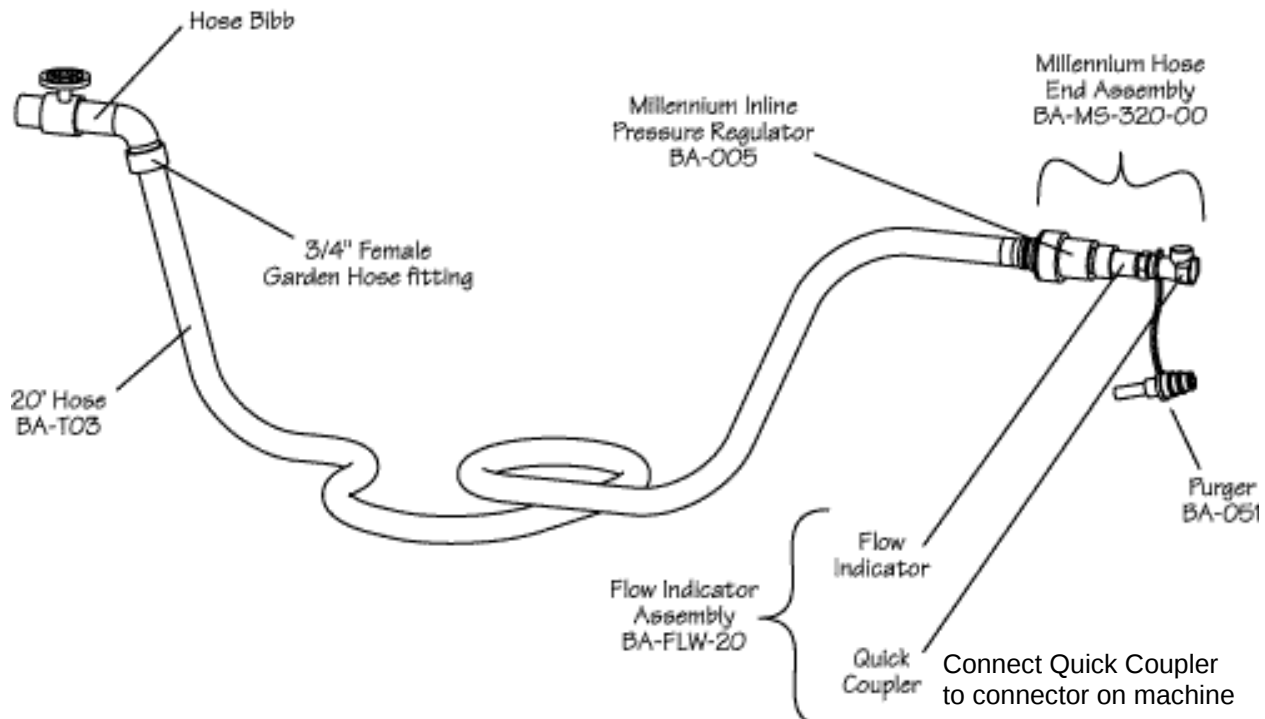
MANUAL FOR DETAILED INFORMATION

BATTERY FILL INSTRUCTIONS

- Connect the hose to a dedicated hose bibb.
- After installing, purge the air out of the hose. Purging is necessary after the Millennium SPW™ system is installed and each time that the system is disconnected and reconnected to the hose bibb. See included Purge Procedure instructions.

PURGING IS REQUIRED BEFORE FIRST USE, OR IF HOSE ASSEMBLY HAS BEEN REINSTALLED SINCE LAST USE
(See next page and separate manual)

- **REFILL BATTERIES AFTER THEY HAVE BEEN CHARGED.** One watering per week is usually enough. Firmly mate the quick coupler. When the connection is made the redballs in the Flow Indicator will start rotating indicating water is flowing into the battery cells.
- After the Flow Indicator balls stop rotating, immediately disconnect by
- pushing the CPC button in and pulling the male Quick Coupler out.
- Put the dust cover back on the battery's male Quick Coupler.
- Store hose out of traffic area when not in use.



WATERING SYSTEM INSTRUCTIONS

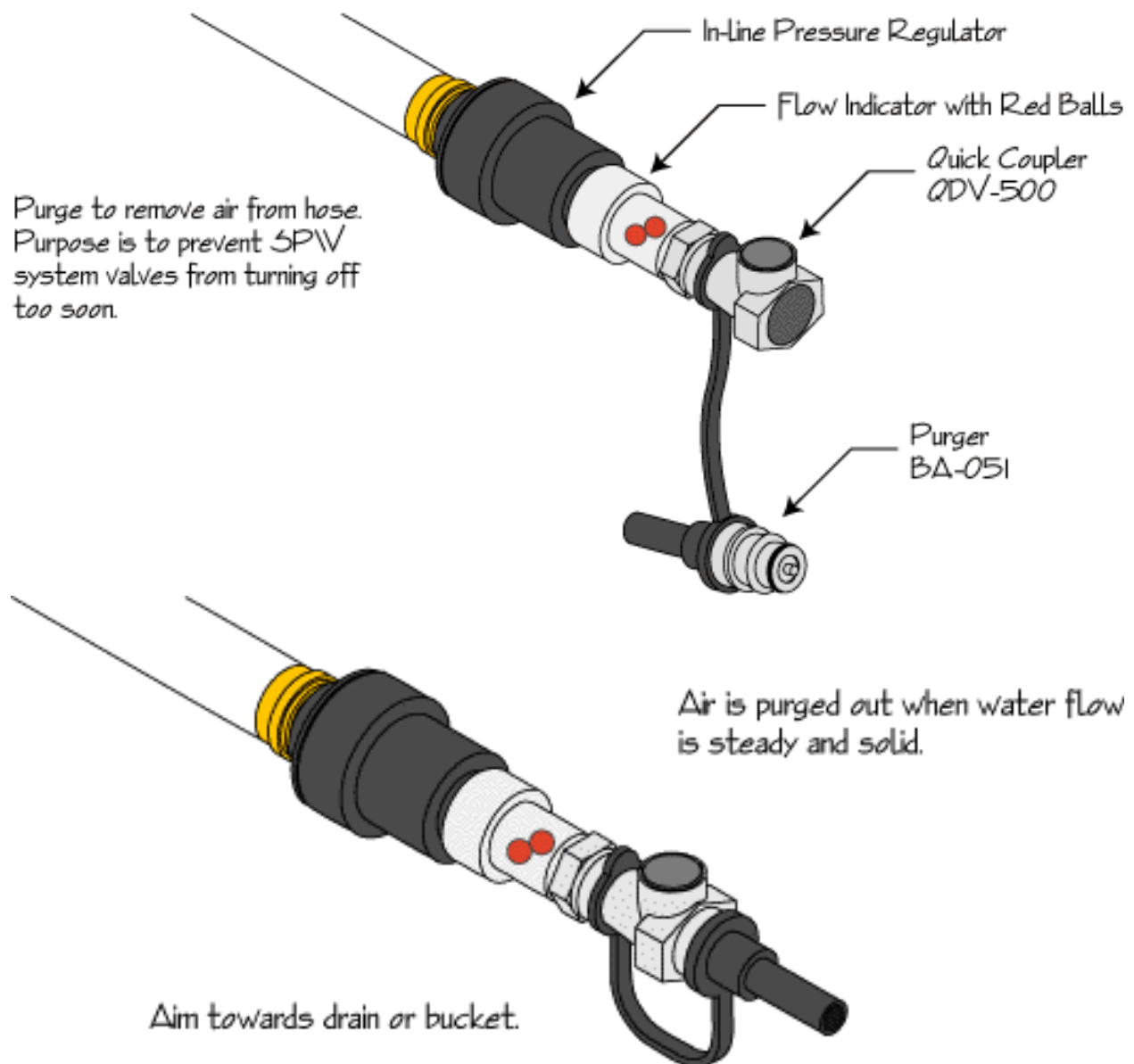
FOR 6 VOLT WET CELL BATTERIES

PLEASE REFER TO SEPARATE

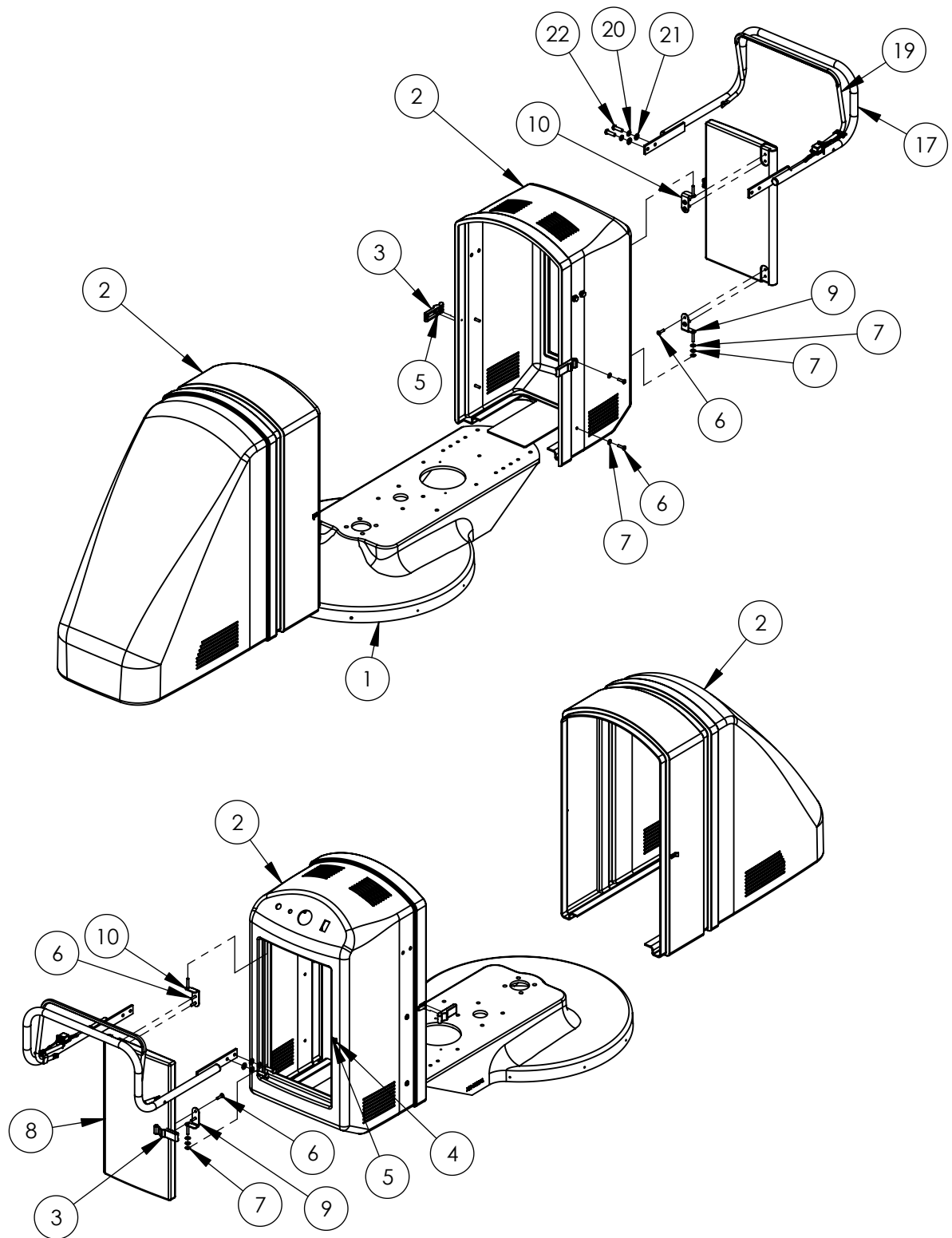
“PRO-FILL ON-BOARD WATERING SYSTEM”

MANUAL FOR DETAILED INFORMATION

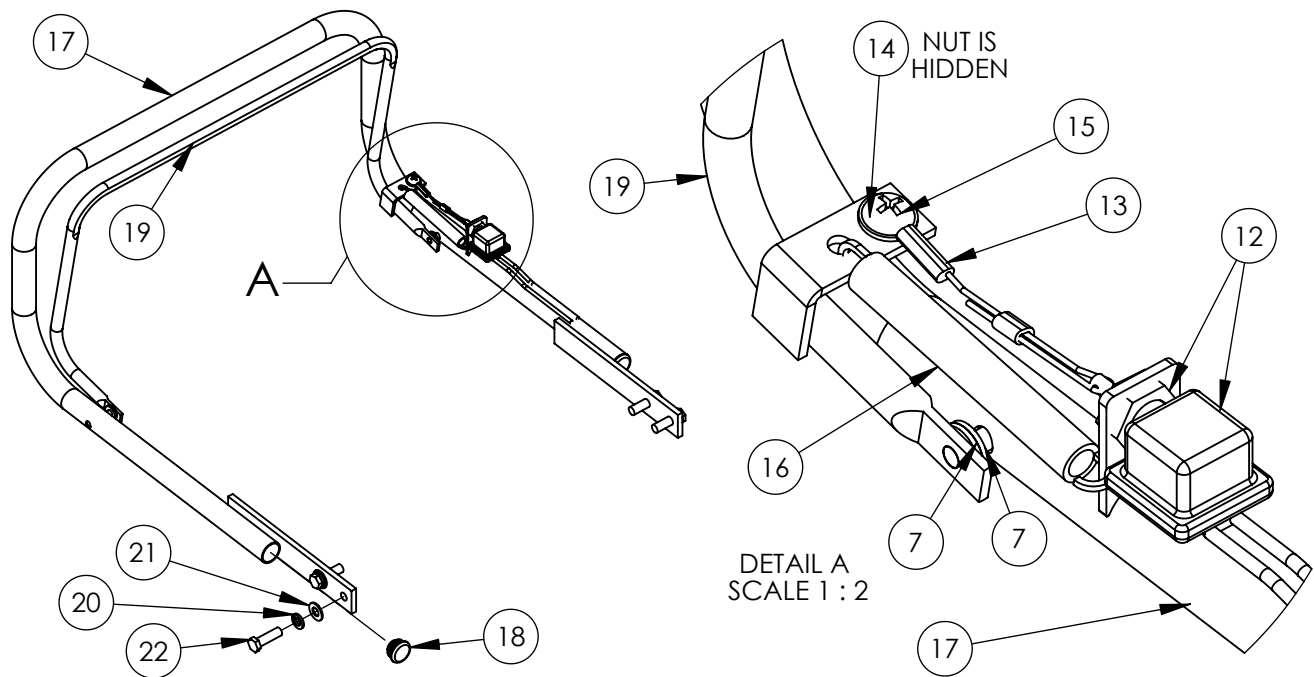
PURGING INSTRUCTIONS



XT3-27 COVER AND HANDLE

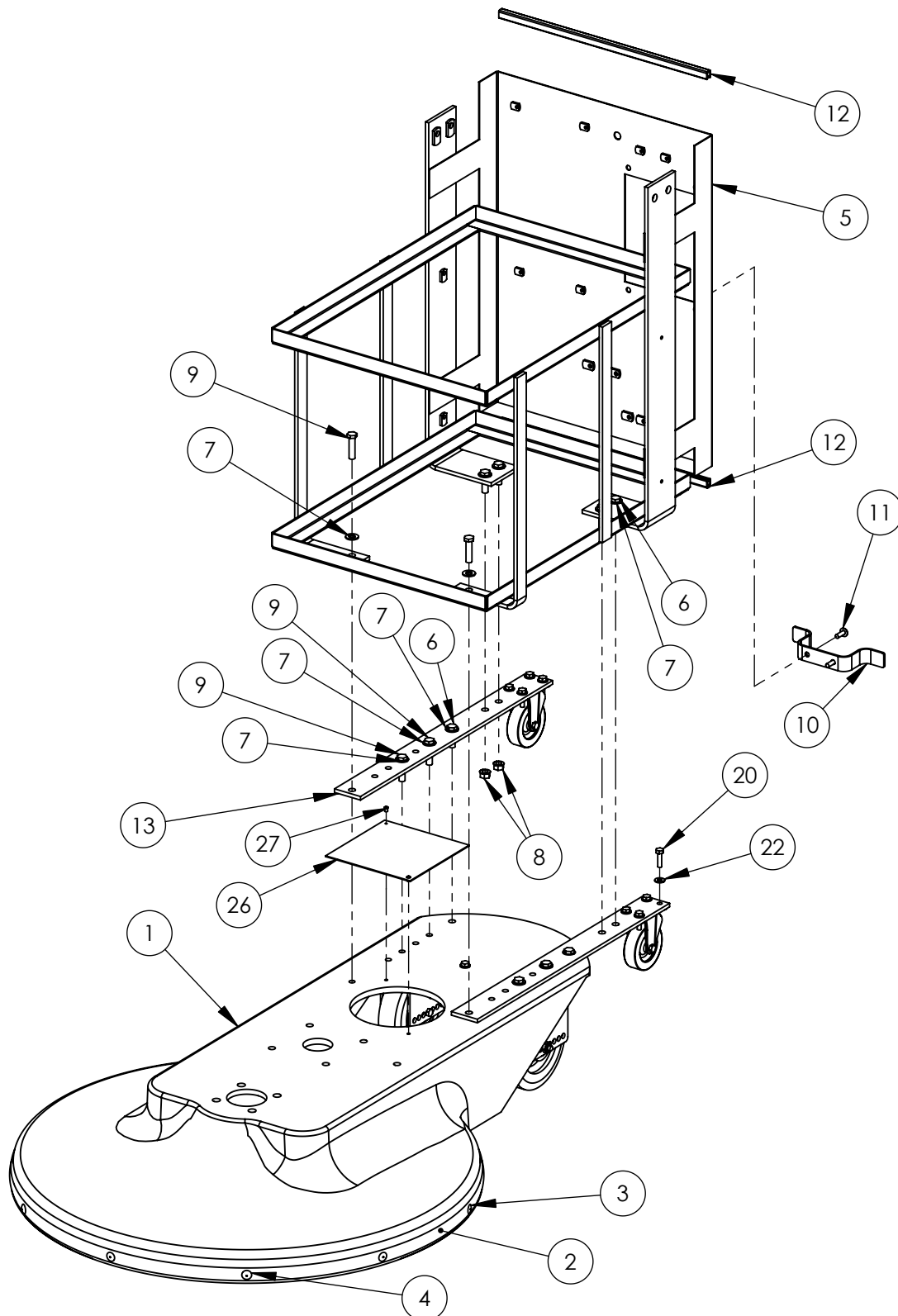


XT3-27 COVER AND HANDLE

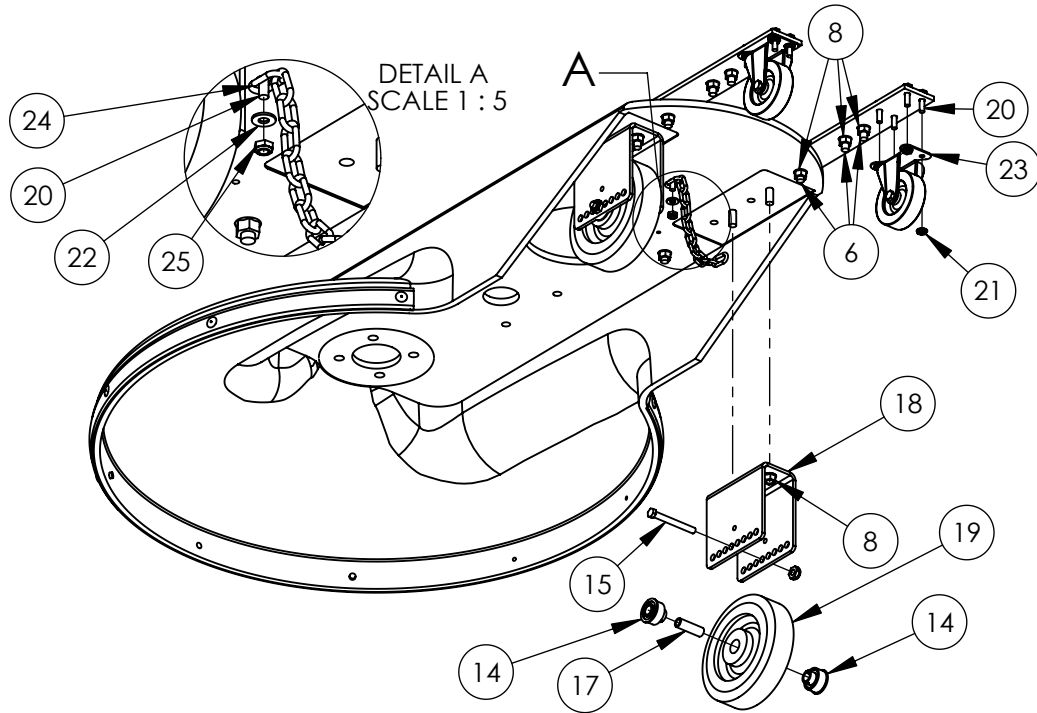


ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E012654	1	27" DURACOAT MILLED DECK
2	E012626	1	ROTOMOLDED SHROUD XT27G3
3	E012633	3	LATCH, RUBBER DRAW (PART 1 OF 2)
4	E012633	3	LATCH, RUBBER DRAW (PART 2 OF 2)
5	E012676	12	RIVET, LOAD SPREADING, 5/32"
6	E012219	8	SCREW, 1/4-20 x 1, PHMS, BLACK
7	E011834	11	WASHER, FLAT, 1/4
8	E012632	1	DOOR, REAR ACCESS
9	E012640	1	HINGE WELDMENT A
10	E012641	1	HINGE WELDMENT B
11	E012221	1	SLEEVE FOR LANYARD, ALUMINUM
12	E012215	1	SWITCH, SAFETY SHUTOFF
13	E011553	1	LANYARD 3/64 x 6"
14	E012242	1	NUT, FLANGED, 1/4-20
15	E011122	1	SCREW, 1/4-20 x .5, PHMS, SS
16	E011565	1	SPRING, HANDLE RETURN
17	E012638	1	HANDLE, MAIN XTG3
18	E010259	2	CAP, TUBING, BLACK, 1"
19	E012639	1	HANDLE, SAFETY SHUTOFF XTG3
20	E011504	4	WASHER, LOCK, 3/8
21	E011136	4	WASHER, FLAT, 3/8 SAE
22	E011051	4	BOLT, HEX, 1/4-20 x 1.25

XT3-27 DECK, FRAME, AND WHEELS

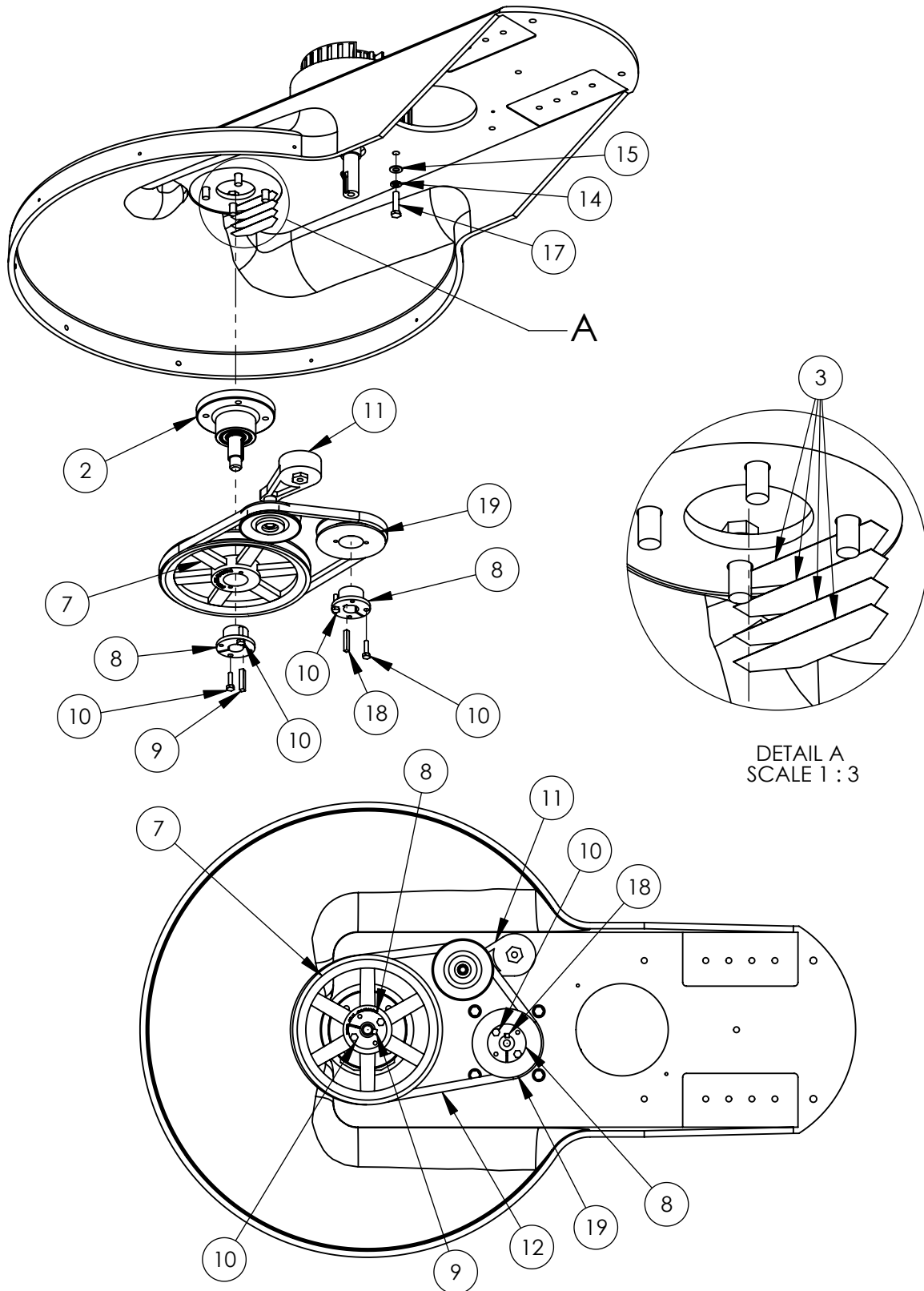


XT3-27 DECK, FRAME, AND WHEELS

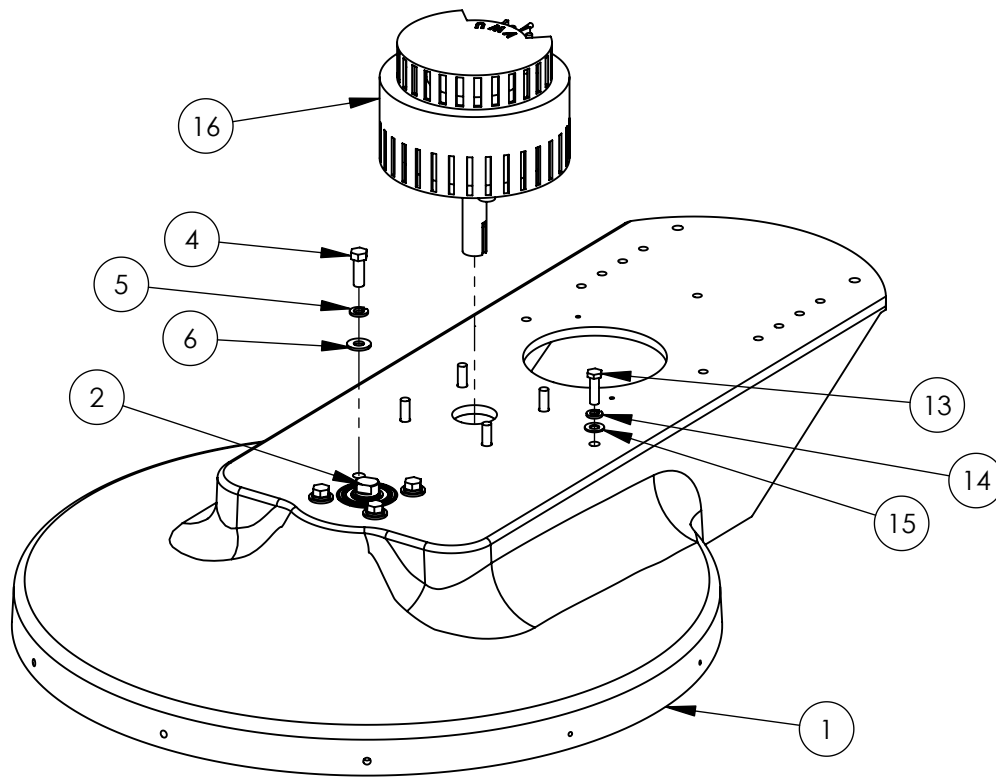


ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E012654	1	27" DURACOAT MILLED DECK
2	E010705	1	BUMPER GUARD, RED
3	E011531	7	RIVET, T-RIVET, BSP T63
4	E012584	2	RIVET, 3/8" HAMMER RIVET
5	E012636	1	FULL MOUNT FOR XT27
6	E011051	6	BOLT, HEX, 1/4-20 x 1.25
7	E011136	12	WASHER, FLAT, 3/8 SAE
8	E011432	12	NUT, FLANGE, 3/8-16
9	E011424	6	BOLT, HH, 3/8-16 x 1.5
10	E012643	1	CHARGER CORD WRAP
11	E011833	2	SCREW, 1/4-20 x .75, PHMS, BLACK
12	E012204	2	TRIM, EDGE, SOLD BY THE FOOT
13	E012637	2	HANDLE TO BASE MOUNT FOR XT27
14	E012672	4	BEARING, SEALED BALL BEARING FOR WHEEL
15	E012675	2	BOLT, HH, 5/16 - 18 x 2.75
16	E011176	2	NUT, NYLOC, 5/16-18
17	*	2	BUSHING, WHEEL, 1.5 x .5 OD x .312 ID
18	E012644	2	ADJUSTABLE WHEEL BRACKET 4.062 AXLE
19	E012285	2	WHEEL, 6" x 1.5" WITH BUSHING
20	E012248	9	BOLT, HEX, 1/4-20 x 1
21	E012242	8	NUT, FLANGED, 1/4-20
22	E011133	10	WASHER, FLAT, 1/4
23	E012237	2	CASTER, 3" WITH GREY WHEEL
24	E012656	1	CHAIN, STAINLESS, STATIC, SOLD BY THE FOOT
25	E012242	1	NUT, NYLOCK, 1/4-20
26	E012661	1	PLATE, HOLE COVER
27	E010118	2	RIVET, AAP64

XT3-27 MOTOR, PULLEYS, AND BELT

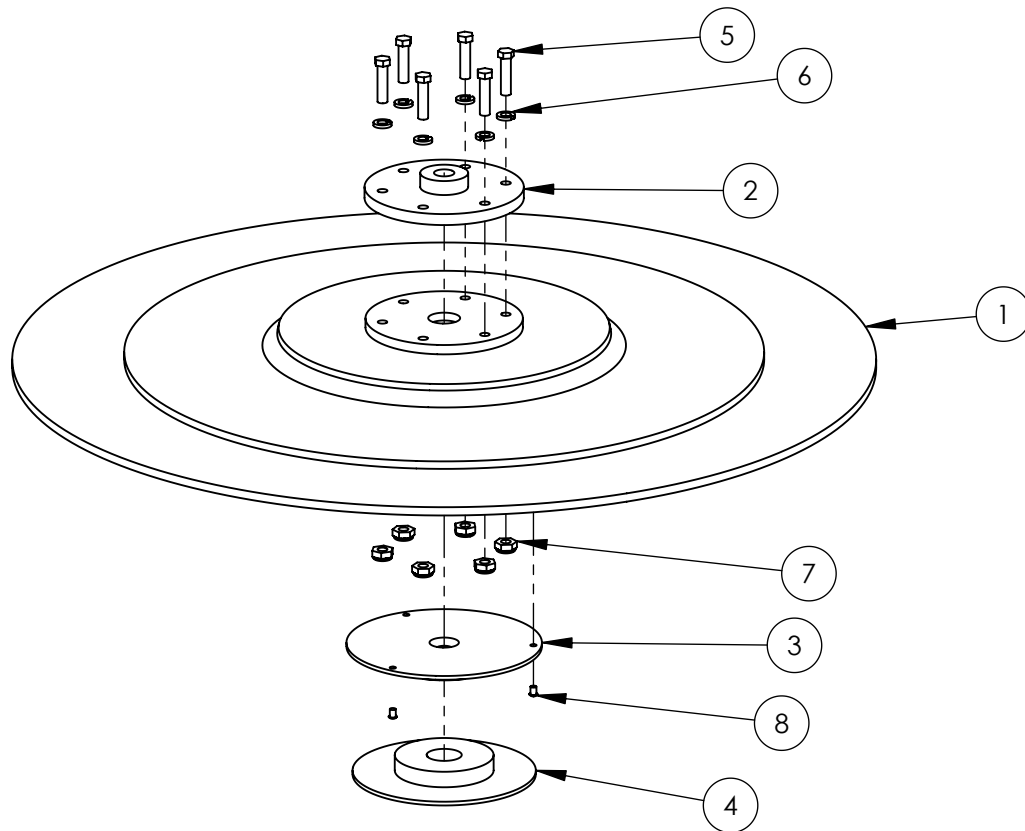


XT3-27 MOTOR, PULLEYS, AND BELT



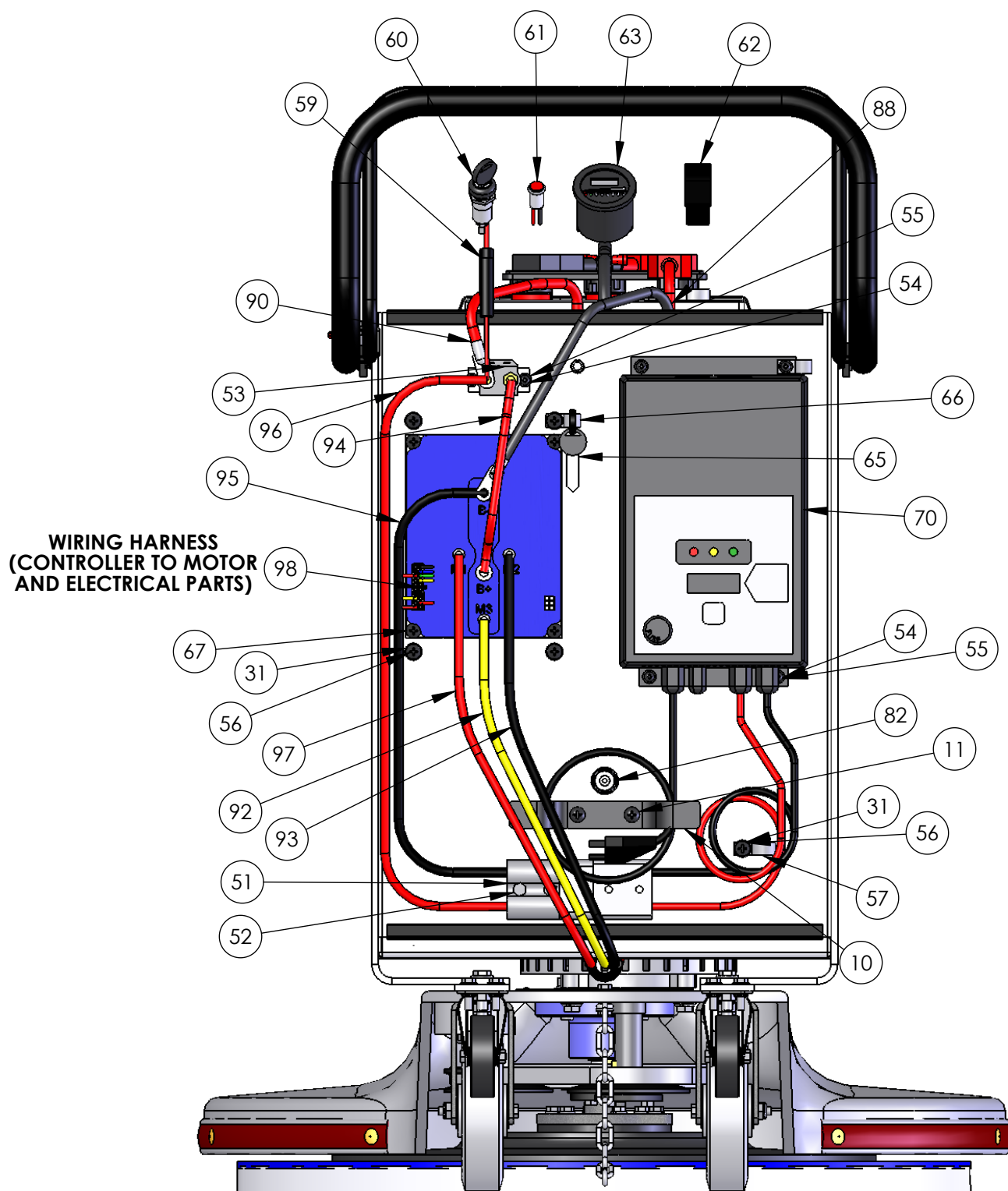
ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E012654	1	27" DURACOAT MILLED DECK
2	E012284	1	BEARING AND SHAFT ASSEMBLY
3	*	4	SHIM FOR FRONT END BEARING HOUSING
4	E010116	4	BOLT, 7/16-14 x 1.25
5	E012217	4	WASHER, LOCK, 7/16
6	E012218	4	WASHER, FLAT, 7/16 SAE
7	E010428	1	PULLEY, 10" OD, QT STYLE
8	E012400	2	PULLEY BUSHING, 25MM SHAFT, QT STYLE
9	E012459	1	KEYSTOCK, 7mm x 8mm x 30mm
10	E012248	4	BOLT, HEX, 1/4-20 x 1
11	E010459	1	BELT TENSIONER, SMALL FOR XT
12	E010107	1	BELT, BX40
13	E011051	1	BOLT, HEX, 1/4-20 x 1.25
14	E011504	5	WASHER, LOCK, 3/8
15	E011136	5	WASHER, FLAT, 3/8 SAE
16	E012197	1	MOTOR, 36 VDC, BRUSHLESS
17	E011424	4	BOLT, HH, 3/8-16 x 1.5
18	E011723	1	KEYSTOCK, 1/4 x 1/4
19	E012662	1	PULLEY, BK45QT

XT3-27 FLEX-LOC PAD DRIVER ASSEMBLY (COMPLETE ASSEMBLY - PE50040)



ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E010252	1	FLEX-LOC 27
2	E010586	1	SHAFT TO PAD DRIVER COUPLING
3	E012517	1	CENTER-LOC 2 (COMES AS A SET 1 OF 2)
4	E012517	1	CENTER-LOC 2 (COMES AS A SET 2 OF 2)
5	E012247	6	BOLT, HEX, 5/16-18 x 1.25
6	E011505	6	WASHER, LOCK, 5/16
7	E011176	6	NUT, NYLOC, 5/16-18
8	E010118	3	RIVET, AAP64

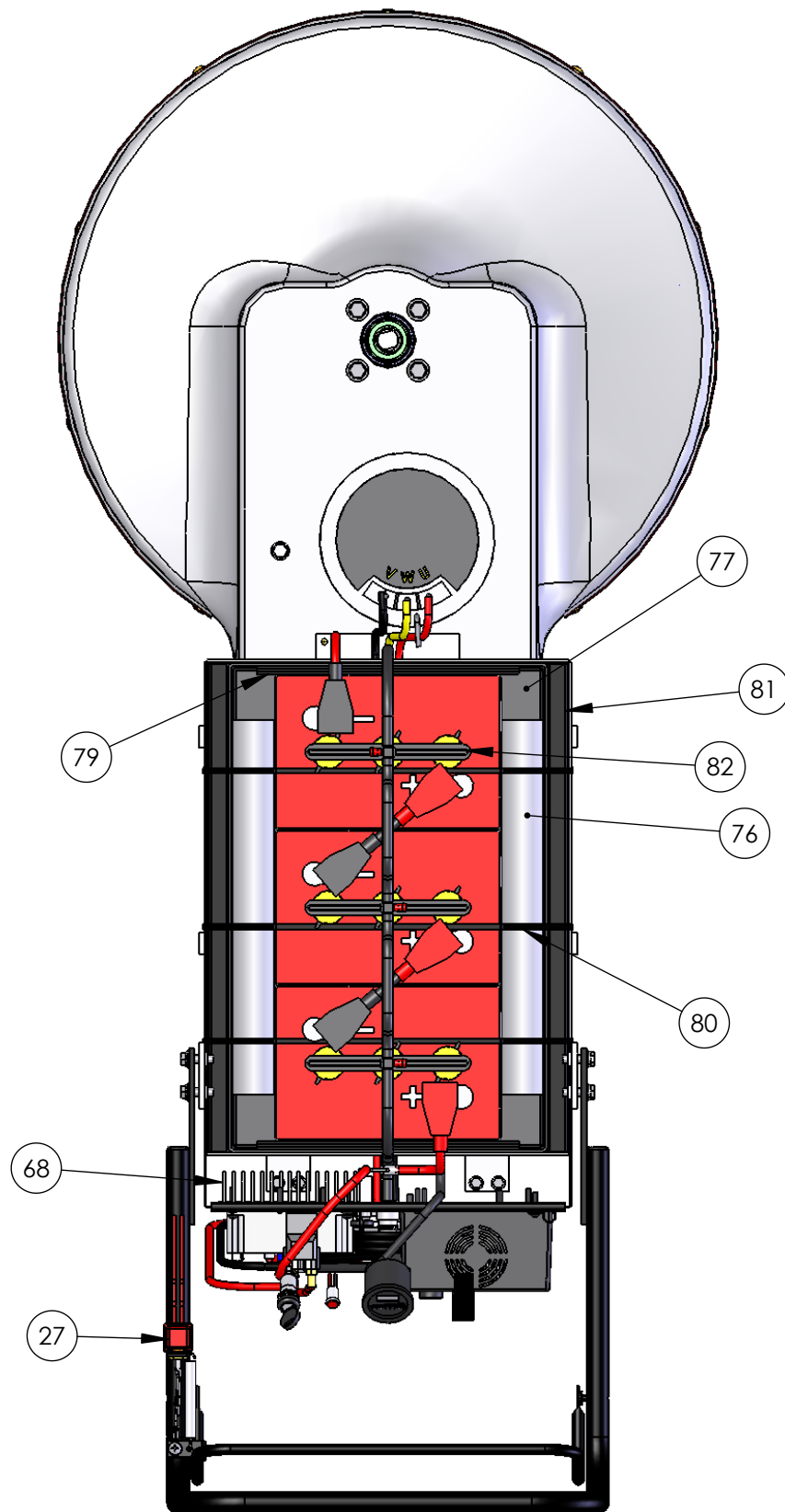
XT3-27 ELECTRICAL



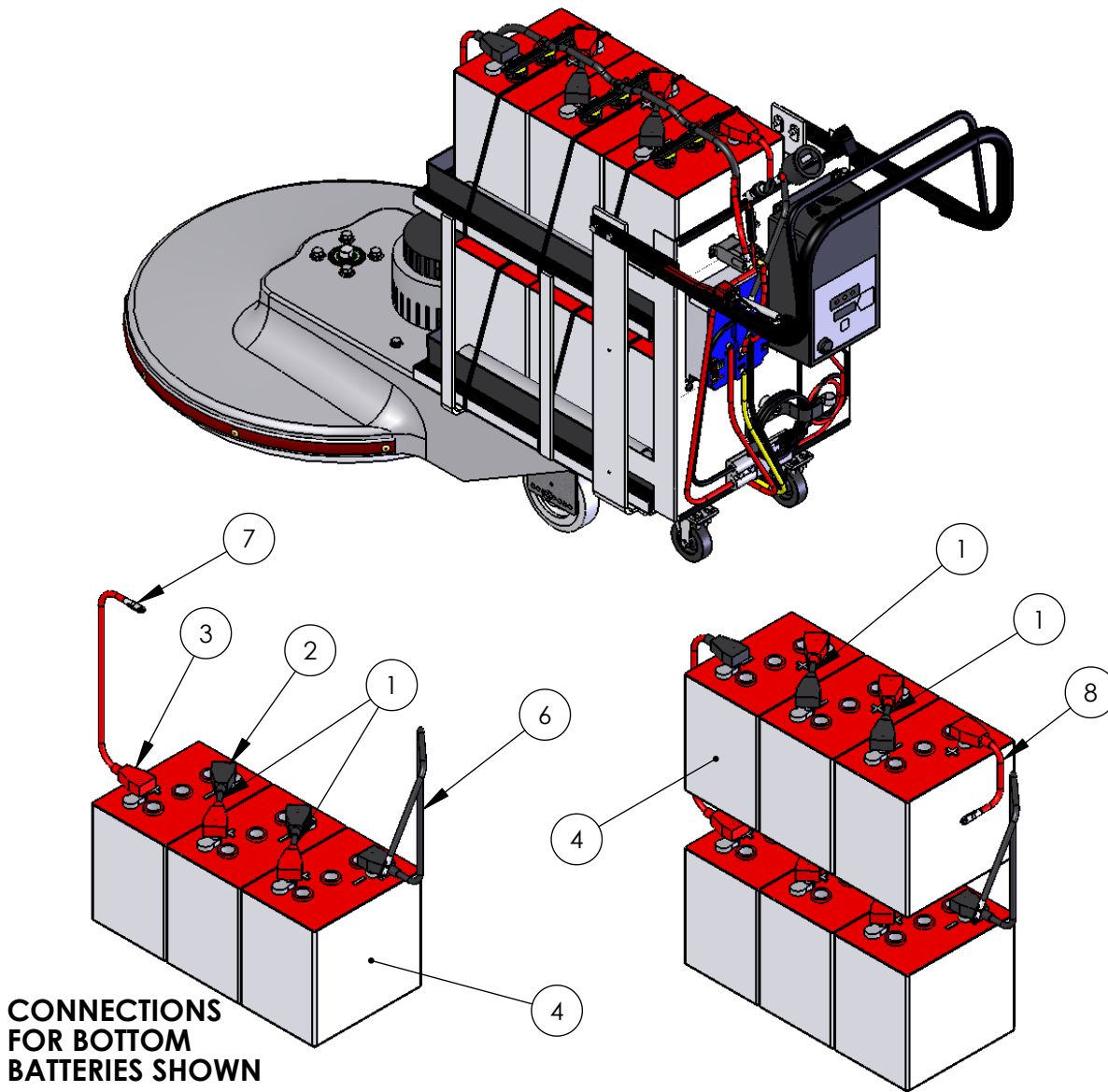
XT3-27 ELECTRICAL

ITEM NO.	PART NO.	QTY.	DESCRIPTION
10	E012643	1	CHARGER CORD WRAP
11	E011833	2	SCREW, 1/4-20 x .75, PHMS, BLACK
31	E011834	9	WASHER, FLAT, 1/4
51	E010878	1	ELECTRICAL PLUG, SB-175, GREY, 36 VOLT
52	E011623	2	BOLT, HH, 1/4-20 x 1.25
53	E012592	1	SOLENOID, 36V, CURTIS-ALRIGHT
54	E012219	6	SCREW, 10-24 x 1, PHMS, BLACK
55	E011834	6	WASHER, #10, SAE, BLACK
56	E012219	9	SCREW, 1/4-20 x 1, PHMS, BLACK
57	E011353	1	TUBE CLIP, .75 COV-1309
58	E011106	1	FUSE, 10 AMP, AGC, 1.25" LONG
59	E011835	1	FUSE HOLDER, FOR 1.25" AGC FUSE
60	E012629	1	KEYSWITCH, HEAVY DUTY WITH 2 KEYS
61	E012646	1	LAMP, LED, 36V
62	E011529	1	SWITCH, ROCKER, DPST
63	E012630	1	BDI (BATTERY DISCHARGE INDICATOR AND HOUR METER)
64	E010708	1	CABLE TIE, BLACK, 7.5"
65	*	1	SPARE KEY
66	E010137	2	TUBE CLIP, .5, COV-0909
67	E012199	1	MOTOR CONTROLLER
68	E012631	1	HEAT SINK
69	E011528	1	CIRCUIT BREAKER, 70 AMP
70	E012628	1	CHARGER, ON-BOARD, SPE WITH CORDS
73	E012568	4	WIRE, BATTERY CABLE, 4 GA, RED, 7.75"
74	E012542	6	TERMINAL PROTECTOR, STRAIGHT, BLACK
75	E012543	6	TERMINAL PROTECTOR, STRAIGHT, RED
76	E012674	4	SPACER, BATTERY END
77	E012624	2	BATTERY TRAY, PLASTIC, 3 BATTERIES
78	E011563	6	BATTERY, 6 VOLT, 225 AMP HOUR
79	E012660	12	SHIM, PLASTIC, 12 x 1.5 x .125
80	E012561	12	CABLE TIE, BLACK, AF529
81	E012642	2	BATTERY TRAY STEEL
82	E012613	1	WATERING SYSTEM, FOR NEW STYLE 6 VOLT BATTERY
88	E012562	1	WIRE, BATTERY CABLE, 4 GA, BLACK, 36"
89	E012263	1	WIRE, BATTERY CABLE, 4 GA, 20"
90	E010133	1	WIRE, BATTERY CABLE, 4 GA, RED, 11"
91	E012568	1	WIRE, BATTERY CABLE, RED, 4 GA, 7.75"
92	E012670	1	WIRE, BATTERY CABLE, 4 GA, RED WITH YELLOW ENDS, 49"
93	E011142	1	WIRE, BATTERY CABLE, 4 GA, BLACK, 52"
94	E011837	1	WIRE, BATTERY CABLE, 4 GA, RED, 7"
95	E012565	1	WIRE, BATTERY CABLE, 4 GA, BLACK, CHARGING, 24"
96	E012564	1	WIRE, BATTERY CABLE, 4 GA, RED, CHARGING, 28"
97	E011141	1	WIRE, BATTERY CABLE, 4 GA, RED, 52"
98	E012655	1	WIRING HARNESS FOR XT3

XT3-27 ELECTRICAL



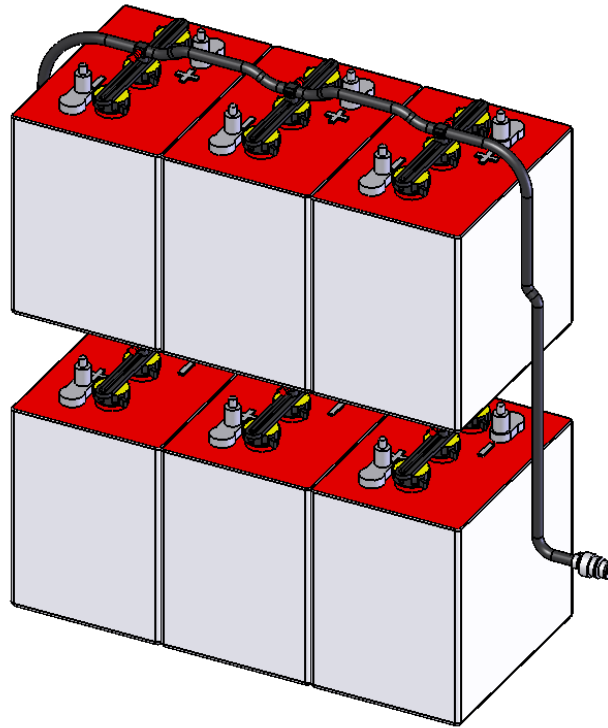
XT3-27 BATTERY CONNECTIONS



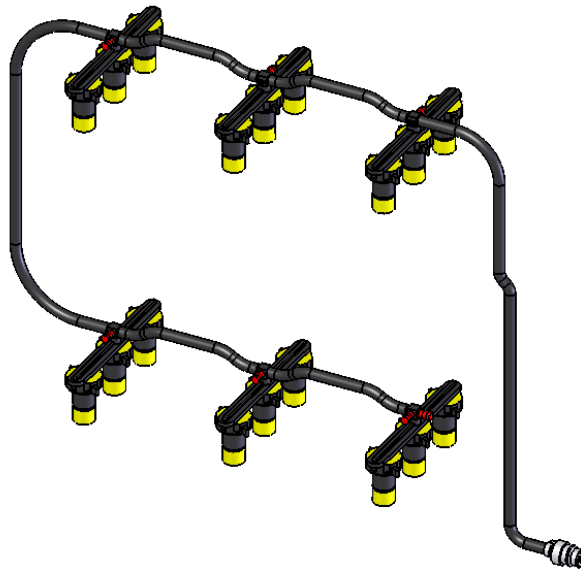
**RED TERMINAL PROTECTORS ARE ON POSITIVE TERMINALS
BLACK TERMINAL PROTECTORS ARE ON NEGATIVE TERMINALS**

ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	E012568	4	WIRE, BATTERY CABLE, 4 GA, RED, 7.75"
2	E012542	6	TERMINAL PROTECTOR, STRAIGHT, BLACK
3	E012543	6	TERMINAL PROTECTOR, STRAIGHT, RED
4	E011563	6	BATTERY, 6 VOLT, 225 AMP HOUR
5	E012613	1	WATERING SYSTEM, FOR NEW STYLE 6 VOLT BATTERY
6	E012562	1	WIRE, BATTERY CABLE, 4 GA, BLACK, 36"
7	E012263	1	WIRE, BATTERY CABLE, 4 GA, 20"
8	E012568	1	WIRE, BATTERY CABLE, RED, 4 GA, 7.75"

XT3-27 WATERING WITH STANDARD BATTERIES



PRO-FILL WATERING SYSTEM - PART # E012613



PROBLEM	CAUSE	POSSIBLE SOLUTION
No sign of power. No on lamp, no BDI readout.	(a) Bad connection (b) Bad connection to BDI (c) On-board charger is plugged in (d) Batteries dead (e) Charger plugged into outlet	(a) Check all connections. (b) Make sure connector is fully pushed into BDI. (c) Disconnect charger from wall outlet. (d) Recharge or replace batteries as needed. (e) Unplug charger from 110v outlet. Charger has an "inhibit" circuit that prevents machine from running if charger is plugged in.
Powers on with key switch, but solenoid does not "click" with rocker switch.	Bad connection	Check all connections.
Powers on, solenoid "clicks", but does not run	(a) Safety run switch problem. Not pulling plunger enough to activate. (b) Safety run switch wire connectors may be loose	(a) Cable may have slipped and sleeve needs to be re-crimped or replaced. (b) Push in connectors
Pad "bogs down"	Too much pad pressure	Decrease pressure using directions on "Balancing Instructions" page
Machine will not set upright with cover on	Too little pad pressure	Increase pad pressure using directions on "Balancing Instructions" page
Low runtime	(a) Improper charge (b) Old batteries or defective cell in battery (c) Too much pad pressure. (d) BDI set to too high a voltage	(a) Make sure that batteries get a full charge after each use. (b) Replace batteries. Best to replace as a set. (c) Balance machine. See "Balancing Instructions" page. (d) See BDI instruction page on how to set to a value of 4 for optimal run time and battery life
Machine vibrates	(a) Pad not centered (b) Pad is torn or worn excessively	(a) Remove pad and re-center the pad (b) Replace pad
Noise coming from underside of deck	Belt is loose and causing belt tensioner to "chatter".	Tighten belt. See page with "Belt tightening instructions".
Machine hard to push	(a) Worn pad (b) Worn wheel bearings (c) Pad out of alignment	(a) Replace pad. (b) Replace bearings or replace wheels. (c) See solution to next problem "Machine pulls left".
Machine pulls left	(a) Worn pad (b) Wrong pad (c) Right side of pad needs a little more contact than the left so "pad assist" can help pull machine forward .	(a) Replace pad (b) Replace pad with pad approved use with XT burnisher. (c) Add a small shim (.010 thick) between bearing housing and deck on the right side. This will "push" right side down toward floor. (If there are too many shims, then left side of pad will not contact properly).
Uneven floor buffing (right side of pad polishes and left side does not)	Right side of pad contacting too much, therefore left side is not contacting enough.	The reverse of the previous procedure. Remove one of the small shims (.010 thick) between bearing housing and deck on the right side

XT3 BATTERY BURNISHER

THREE YEAR LIMITED WARRANTY

PowerBuff, Inc. warrants new machines to be free from defects in material and workmanship under normal use and service to the original purchaser. This warranty period is subject to the conditions stated below.

BATTERY AND BATTERY CHARGER WARRANTIES

Battery warranty is for one year on a prorated basis. Battery warranty is void if batteries are not maintained at the proper fluid level with distilled water. Battery charger is warranted for one year.

EXCLUSIONS

This warranty does not cover normal wear and maintenance items including, but not limited to: carbon motor brushes, scrub brushes, squeegees, valves, gaskets, wheels, casters, and routine adjustments. This warranty does not cover damage or failure which is the result of misuse, negligent operation, handling or repair, or which is the result of modification or repair by any person other than an authorized PowerBuff, Inc. service representative.

LIMITATIONS

STATED WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED. PowerBuff's liability under this warranty is limited to repair of the product and/or replacement parts and is given to purchaser in lieu of all other remedies, including incidental and consequential damages.

WARRANTY DETAILS AND CLAIM PROCEDURES

PowerBuff, Inc. warrants to buyer that for the applicable shipment, such material will be free from defects in material and workmanship or failure to meet specifications (a defect) appears in the material; then seller will, at it's option, either repair or replace the defective goods without charge or credit or refund the purchase price of the defective material, provided that:

The defect appears within the applicable warranty period.

Buyer notifies seller in writing of the claimed defect promptly after buyer knows or reasonably should know of the claimed defect.

Seller's examination if the material discloses that the claimed defect actually exists.

Buyer shall follow seller's instruction regarding return of defective material, and no material will be accepted for repair, replacement, credit, or refund without the written authorization of and in accordance with seller's instructions. In the case of any such return, buyer shall bear the risk of in-transit loss or damage; and shall prepay all transportation charges to seller. Repaired or replacement material will be shipped prepaid by seller, and buyer shall bear the risk of in-transit loss or damage. The replaced material shall become the seller's property.