



OPERATOR'S MANUAL

2500X



Congratulations on owning a Scag Tracked Power Buggy! This manual contains the operating instructions, safety information, and illustrated parts list for your machine. Reading this manual can provide you with assistance in maintenance and adjustment procedures to keep your machine performing at maximum efficiency. Please read all the information enclosed in this manual before operating your machine.

The QR code on the front cover of this manual can be scanned with your mobile device to access manuals, parts lists, and other product information on the official Scag website.



WARNING

YOUR TRACKED POWER BUGGY IS ONLY AS SAFE AS THE OPERATOR. HAZARD CONTROL AND ACCIDENT PREVENTION ARE DEPENDENT UPON THE AWARENESS, CONCERN, PRUDENCE, AND PROPER TRAINING OF THE PERSONNEL INVOLVED IN THE OPERATION, TRANSPORT, MAINTENANCE, AND STORAGE OF THE EQUIPMENT.

- Carefully read and understand the safety and operating instructions described in this manual. Always keep a copy of this manual with the machine.
- Ensure every operator is properly trained and thoroughly familiar with all controls and procedures before operating the machine.
- Under no circumstances should the machine be operated on slopes greater than 10 degrees. Always follow OSHA-approved operating procedures.
- Keep hands, feet, and clothing away from moving parts at all times.
- Do not carry passengers on the machine.
- Do not operate the machine when children or bystanders are present.
- Before performing any maintenance or service, stop the machine and remove the ignition key.

This manual covers the operating instructions and illustrated parts list for:		
SCB-2500X-23BV-S	with a serial number of	181D00026 to 181D99999
SCB-2500X-23BV-S-BB	with a serial number of	220D00001 to 220D99999
Always use the entire serial number listed on the serial number tag when referring to this product.		

Model Number:	Serial Number:

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INTRODUCTION

1.1 GENERAL INFORMATION

Your 2500X Tracked Power Buggy was built to the highest standards in the industry. However, the prolonged life and maximum efficiency of your machine depend on you following the operating, maintenance, and adjustment instructions in this manual.

Carefully read the safety and operating instructions in this manual before attempting to operate your machine. You are responsible for the safe and proper operation of your machine.

IMPORTANT

For illustrative clarity, some illustrations in this manual may show shields, guards, or plates open and removed from the machine. Under no circumstances should your machine be operated without these devices in place.

All information in this manual is based on product information available at the time of approval for printing. Scag Power Equipment reserves the right to make changes to this manual at any time without notice and without incurring any obligation. **Please visit the official Scag Power Equipment website (www.scag.com) for updated manual releases.**

A replacement manual is available from the following sources: your Authorized Scag Dealer, Scag Power Equipment Service Department (PO Box 152; Mayville, WI 53050), and on the official Scag Power Equipment website. When requesting replacement manuals, please indicate the complete model number and serial number of your Scag product.

If additional information or service is needed for your machine, please contact your Authorized Scag Dealer.

1.2 MANUAL CONVENTIONS

DIRECTIONAL REFERENCES

Directional references are used throughout this manual to locate the components of the machine. The "Right," "Left," "Front," and "Rear" of the machine are referenced from the perspective of the operator while standing in the normal operating position of the machine and facing the forward travel direction.

SAFETY ALERTS



The symbol above means, **"Attention! Become Alert! Your Safety is Involved!"** This symbol is used with the following safety alerts to identify the safety messages located throughout this manual and found on the decals located on your machine. The message that follows the safety alert contains important information about safe operating practices, hazards, and safety precautions.

Your safety and the safety of others depends on your knowledge and understanding of all correct operating practices and safety precautions of this machine. To avoid injury and possible death, carefully read all safety alerts associated with your machine. Be sure to understand all potential hazards and possible causes of injury or death before operating your machine.



DANGER

The **"DANGER"** safety alert denotes an **extremely hazardous situation that exists on or near the machine. This hazard results in a high probability of death or irreparable injury if proper precautions are not taken.**



WARNING

The **"WARNING"** safety alert denotes a hazard that exists on or near the machine that can **result in injury or death if proper precautions are not taken.**



CAUTION

The **"CAUTION"** safety alert serves as a reminder to follow safety practices while on or near the machine. **If safety precautions are not taken, personal injury can occur.**

1.3 SERVICING YOUR MACHINE

We encourage you to contact your Authorized Scag Dealer for any repairs to your machine. All Scag dealers are informed of the latest methods to service your equipment and carry a full line of Scag replacement parts. Their services are efficient, both in the field and at their service shops.

When ordering parts for your machine, always give the model number and serial number of the machine. The serial number plate is located on the center rear side of the machine. See Figure 1-1.

IMPORTANT

The use of parts other than original Scag® replacement parts will void the warranty on this product. Unauthorized replacement parts may adversely affect the performance, durability, or safety of your machine.

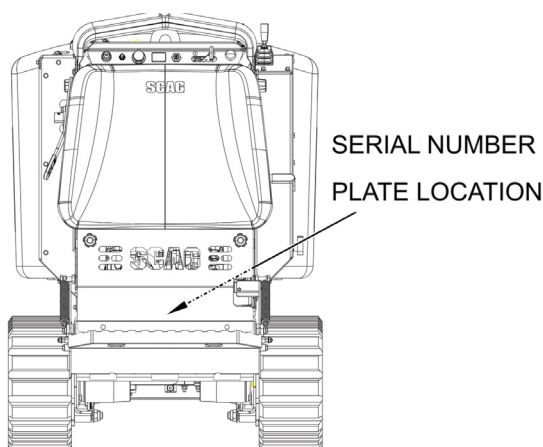


Figure 1-1. Tracked Power Buggy Serial Number Plate Location

ENGINE AND DRIVETRAIN COMPONENTS

The detailed servicing and repair procedures for the engine, hydraulic pumps, and valves of this machine are not covered in this manual. For service of these components during the limited warranty period, please contact your Authorized Scag Dealer or find an authorized servicing agent of the component manufacturer. **Any unauthorized work completed on these components during the limited warranty period may void your warranty.**

ATTACHMENTS AND ACCESSORIES

Attachments and accessories manufactured by companies other than Scag Power Equipment or Metalcraft of Mayville must be approved for use on this machine by Scag Power Equipment. Any alterations or modifications made to the machine that change the performance, durability, or allow the use of unapproved attachments and accessories will not be covered by warranty. See Section 7 for more information.

1.4 ASSEMBLY INSTRUCTIONS

1. In an open area, remove the footplate assembly and included hardware from the packaging.
2. Using side cutters, cut the two (2) cable ties securing the footplate springs to the machine frame.
3. Install the pivot bearing (P# 486834) in the footplate assembly. See Figure 1-2.

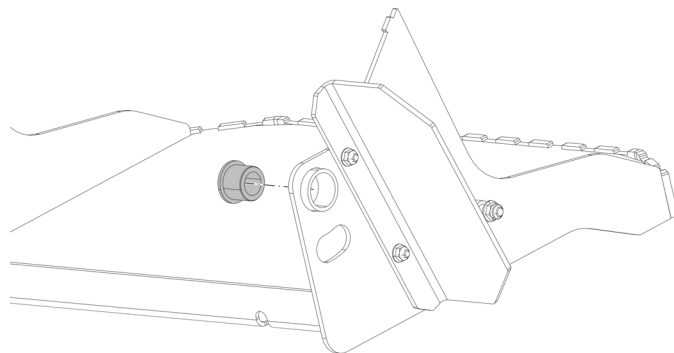


Figure 1-2. Pivot Bearing Installation

4. Secure the footplate assembly to the left side of the machine using one (1) cap screw (P# 04001-45), one (1) flat washer (P# 04041-07), one (1) spacer (P# 43572), and one (1) locknut (P# 04117-02). Repeat on the right side of the machine. See Figure 1-3.

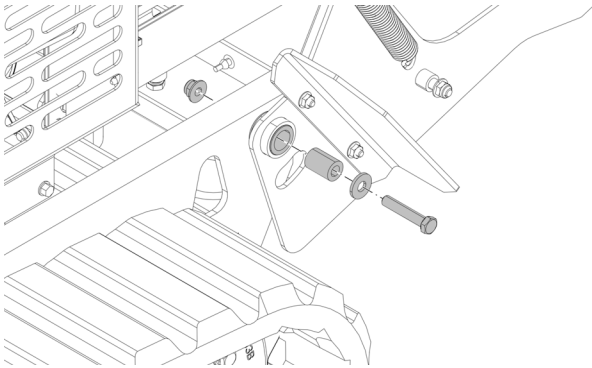


Figure 1-3. Footplate Installation

5. Install one (1) cap screw (P# 04001-45), one (1) spacer (P# 43572), and one (1) locknut (P# 04117-02) through the footplate assembly and into the left side of the machine frame. Repeat on the right side of the machine. See Figure 1-4.

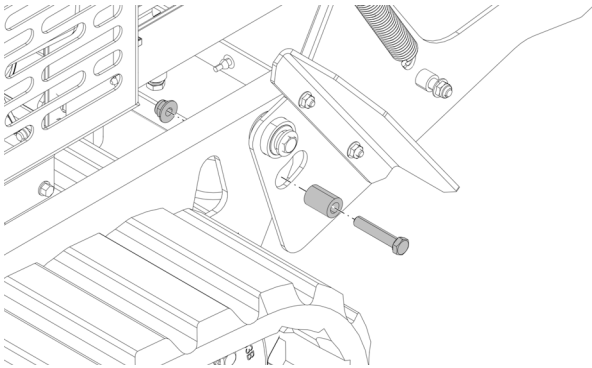


Figure 1-4. Installing Pivot Hardware

6. Secure the footplate springs to the machine frame and footplate assembly. See Figure 1-5.

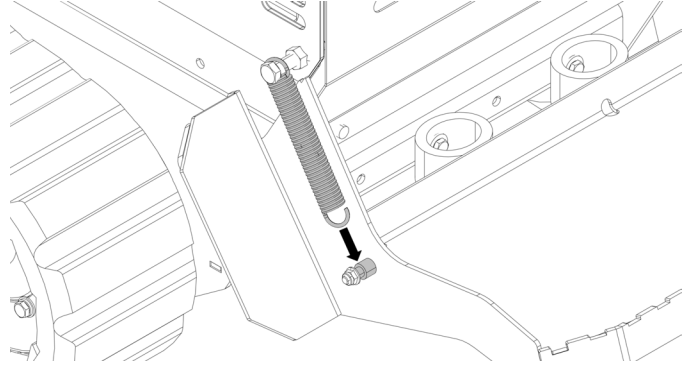
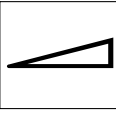
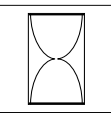
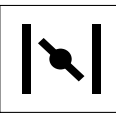
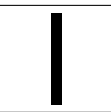
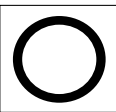
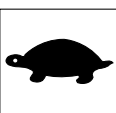
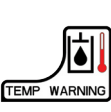
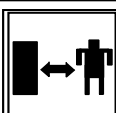


Figure 1-5. Securing Footplate Spring

1.5 SYMBOLS

SYMBOL	DESCRIPTION	SYMBOL	DESCRIPTION
	Read Operator's Manual		CE Mark
	Tie Down		Lift Point
	Parking Brake		Continuously Variable – Linear
	Hour Meter / Elapsed Operating Hours		Choke
	ON / START		OFF / STOP
	Hydraulic Oil		Oil
	Fast		Slow
	Pinch Point		Fan Warning
	High Temperature		Hot Surfaces
	Falling Hazard		Keep Bystanders Away

NOTES

SAFETY INFORMATION

2.1 INTRODUCTION

Your 2500X Tracked Power Buggy is only as safe as the operator. Hazard control and accident prevention are dependent upon the awareness, prudence, and proper training of the personnel involved in the operation, transport, maintenance, and storage of the machine. Ensure every operator is properly trained and thoroughly familiar with all controls, operating practices, and safety precautions before operating this machine.

Carefully read the safety and operating instructions in this manual before attempting to operate this machine. The owner and operator can prevent, and will be responsible for, accidents or injuries occurring to themselves, other people, or property.

NOTE

Ensure all personnel know where the manual for this machine is located. Keep a record of each employee that has read the manual.

2.2 BEFORE OPERATION SAFETY

GENERAL CONSIDERATIONS

1. Clear the operating area of all objects that could interfere with the operation of the machine. These objects can cause the machine to become unstable.
2. Ensure all operators and mechanics working with the machine are appropriately trained and understand the procedures outlined in this manual. The owner of the machine is responsible for training all operators working with the machine.
3. Do not operate the machine when children or bystanders are present. Keep children out of the operating area and in the care of a responsible adult. Turn off the machine if any children or bystanders enter the operating area.
4. Never allow children or untrained personnel to operate the machine.
5. Do not carry passengers on the machine.
6. Wear adequate protective equipment while operating the machine. Avoid loose clothing, jewelry, or long hair that could get tangled in moving parts. Wearing safety glasses, slip-resistant safety shoes, and a helmet is advisable and required by some local ordinances and insurance regulations.



WARNING

Always wear hearing protection while operating the machine. Prolonged periods of exposure while operating this machine may cause hearing loss.

7. Keep the machine in a good operating condition. Keep all shields, safety devices, and decals in place. If a shield, safety device, or decal is defective or damaged, repair or replace the component before operating the machine.
8. Before operating the machine with an attachment or accessory, ensure that the component is properly installed and approved by Scag Power Equipment.
9. All equipment must comply with state and local ordinances as well as the latest SAE J137 and/or ANSI/ASAE S279 requirements if the machine is driven on public roads. Contact your local authorities for regulations and equipment requirements.

PROTECTING CHILDREN

1. Children are attracted to construction machines and construction activities. Many associate construction machines with fun because someone has given them a ride on a machine. Death or serious injury may occur if the operator is not alert to the presence of children.
2. Keep children out of the operating area and in the care of a responsible adult. Be aware of any children near the operating area.
3. Do not assume that children will stay where you last saw them. Turn off the machine if children enter the operating area.
4. Never allow children to ride on the machine, even if the hydraulic system is disengaged. Children may interfere with safe operating procedures and risk serious injury if thrown from the machine.
5. Children do not understand the dangers of power equipment nor the fact that the operator is unaware of their presence. Children who have received rides in the past may suddenly appear in the operating area for another ride and be run over or backed over by the machine.

6. Tragic accidents can occur if the operator is not alert to the presence of children, especially when children approach the machine from behind. Look down and behind the machine before traveling in reverse.

FUEL & FLUID SAFETY

1. Fuel is flammable; handle it with extreme care.
2. Keep all flammable ignition sources (cigarettes, matches, etc.) away from the machine and any fuel containers. Never store fuel near open flames, heat sources, or sparks.
3. Only use approved containers to store fuel. Always use a funnel or spout to prevent spillage. Never fuel indoors or inside enclosed spaces, and clean any spillage before starting the machine.

CAUTION

If fuel is spilled on clothing, change clothing immediately and wash affected skin. Affected areas may suffer from irritation, chemical burns, and contact dermatitis.

4. Do not fill containers on a truck or trailer bed with a plastic liner. Always place containers on the ground and away from your vehicle before filling.
5. Never remove the fuel tank cap or add fuel while the machine is running. Allow for the engine to fully cool before adding fuel.
6. Do not operate the machine without the exhaust system installed and working properly.

DANGER

Exhaust fumes are hazardous and contain carbon monoxide, which can cause brain injury and death. Do not run the machine indoors or inside confined areas without proper ventilation.

7. Ensure all hydraulic fluid connections are tight and all hydraulic hoses and lines are in good condition before starting the machine.

SAFETY INTERLOCK SYSTEM

WARNING

This machine is equipped with a safety interlock system intended to protect the operator and others from injury.

This is accomplished by preventing the engine from starting unless the operator is standing on the operator platform.

The safety interlock system will shut off the engine if the operator leaves the operator platform without returning the steering control levers to the neutral position.

Never operate the machine with the interlock system disconnected, bypassed, or malfunctioning.

The safety interlock system should be tested before every use of the machine. If the safety interlock system does not operate as described below, contact your local Authorized Scag Dealer immediately to have the safety interlock system repaired. Do not operate the machine until the safety interlock system has been repaired.

1. Stand on the operator platform and place the steering control levers in the neutral position. With the engine running, step backwards off of the operator platform. The engine should stay running.
2. Stand on the operator platform and place the steering control levers in the forward position. With the engine running, step backwards off of the operator platform. The engine should shut off.

2.3 DURING OPERATION SAFETY

GENERAL CONSIDERATIONS

WARNING

Extended operation of this machine exposes the operator to whole-body and hand-arm vibration. Prolonged exposure to these vibrations may cause discomfort, numbness, tingling, fatigue, back pain, and reduced hand dexterity. Long-term exposure may lead to permanent circulatory issues, nerve damage, carpal tunnel syndrome, and musculoskeletal injury.

Reduce vibration exposure by limiting operation time and taking regular breaks.

1. Understand the function of all controls and how to stop the machine quickly before use.
2. Do not exceed the operating capacity of the machine. Exceeding the operating capacity of the machine may cause the machine to become unstable, which can result in a loss of control.
3. Avoid all distractions while operating the machine. Do not operate the machine while sick, tired, or under the influence of alcohol or drugs.
4. Only operate the machine in daylight, artificial light, and appropriate weather conditions. Do not operate the machine during lightning, thunderstorms, or other inclement weather.
5. Before attempting to start the engine, place the steering control levers in the neutral position and engage the parking brake.
6. Start the engine with the operator in the operating position, the parking brake engaged, and both the steering control levers and the hopper control levers in the neutral position.
7. Operate the machine using steady motions. Do not turn sharply. Be aware of your surroundings while backing up. Always yield the right-of-way when crossing roads and sidewalks.

8. Be aware of obstacles in your work area. Keep away from any trees, walls, and drop-offs. Beware of overhead obstructions (low branches, electrical wires, etc.) and underground obstructions (holes, rocks, roots, pipes, sprinklers, etc.). Stay alert for hidden hazards, and cautiously enter new areas.
9. Use caution when operating the machine near blind corners, shrubs, trees, or other objects that may obscure vision.
10. Never leave the machine unattended while running. Always lower the hopper, set the parking brake, stop the engine, and remove the key.
11. Keep hands, feet, and clothing away from moving parts of the machine while it is running. Do not make adjustments to the machine while it is running.

CAUTION

Do not touch the engine or the muffler while the engine is running or immediately after stopping the machine. These areas are hot enough to cause burns.

12. Always look behind you while moving the machine in reverse.
13. If you are uneasy while operating the machine due to uncertainty of the terrain, stop immediately.

HOPPER SAFETY

1. Ensure that the hopper on the machine is properly installed. Test operation before beginning work.
2. Confirm the operating capacity of the hopper before loading materials. Exceeding the operating capacity may cause the machine to become unstable.
3. Evenly distribute loads to improve stability and control over the machine.
4. Ensure that your load cannot escape the hopper during movement and operation of the machine.
5. Be aware of the physical characteristics and the associated risks of your load. Liquid loads will shift, which may cause the machine to become unstable.

6. Ensure that your load can shift freely within the hopper. Blocked materials may cause the machine to become unstable if suddenly dislodged.
7. Never direct the discharge of material towards bystanders or allow anyone near the machine while in operation.
8. Lower the hopper when not in use or while transporting the machine.

SLOPE OPERATION

Slopes are a major cause of instability, loss-of-control, and tip-over accidents, which may result in severe injury or death. Before operating the machine on any slope, review the safety guidelines and instructions listed in this manual. The owner and operator will be responsible for the safe operation of this machine on slopes.



WARNING

Never operate the machine on slopes greater than 10 degrees (see Section 2.9). When operating the machine on a slope, only travel up and down the slope. Traveling across a slope may cause the machine to become unstable and overturn.

1. Use extreme caution while operating the machine on any slope or uneven surface.
2. Be aware of obstacles at the base of and on the slope. Do not operate the machine near drop-offs, ditches, embankments, or bodies of water. Remove any hazards before operation, or keep a safe distance between the machine and the hazard.
3. Mark uneven terrain (holes, bumps, roots, rocks, ruts, soft turf, etc.) before operation. Uneven terrain may cause instability and overturn the machine.
4. Always operate on slopes with the heavy end of the machine facing uphill. Weight distribution of the machine will change depending on load distribution.
5. Reduce speed and use extreme caution on slopes and in sharp turns to prevent instability, loss of control, and tipping. Be especially cautious when changing directions on slopes.
6. Do not coast when traveling downhill. Keep the machine in gear when operating on slopes.
7. Avoid starting and stopping on slopes. Keep all movements on slopes slow and gradual. If the machine loses traction, proceed slowly down the slope.
8. Do not operate the machine in conditions with questionable traction, steering, or stability. Use caution when operating on wet surfaces as the reduced traction may cause sliding and a loss of braking and steering.
9. Do not raise the hopper while operating the machine on slopes. Raising the hopper will change the load distribution of the machine and affect stability.
10. Never park the machine on slopes or uneven terrain.
11. If you lose control of the machine, step off and away from the direction of travel of the machine.

2.4 AFTER OPERATION SAFETY

GENERAL CONSIDERATIONS

1. Return the steering control levers to the neutral position, engage the parking brake, lower the hopper, stop the engine, and remove the key before cleaning, adjusting, or repairing the machine. Wait for all movement to stop before proceeding.
2. Never make adjustments to the machine while the engine is running unless specifically instructed to do so. Keep hands, feet, and clothing away from the moving parts of the machine.
3. Do not touch parts that may be hot from operating the machine. Allow for all hot parts to cool before maintaining, adjusting, or servicing the machine.
4. Clean dirt and debris from drives, muffler, and the engine after use. Prevent fires by cleaning all oil and fuel spills before and after operating the machine.

CLEANING THE MACHINE

1. Clean the inside of the hopper using water.
2. Clean any dirt or debris from under the hopper.
3. Clear any dirt or debris buildup on the engine and drivetrain with a brush or air blower.

IMPORTANT

Do not use a pressure washer to clean the machine. High-pressure washing can damage the electrical system and hydraulic valves, or deplete grease.

4. Wipe away any dirt or debris from the air cleaner.

MAINTENANCE SAFETY

1. Always park the machine on a level surface and engage the parking brake.
2. Never allow untrained personnel to service the machine. Ensure all mechanics working with the machine are appropriately trained and understand the procedures outlined in this manual.
3. Keep all nuts, bolts, and screws tight to ensure the machine is in a safe working condition.
4. Keep all parts in a good working condition. Replace all worn, damaged, or defective decals.
5. Disconnect the battery before repairing the machine. Disconnect the negative terminal first and the positive terminal last. Reconnect the positive terminal first and the negative terminal last when reinstalling the battery.
6. Use jack stands rated for the weight of the machine to support components when required.
7. Do not adjust the engine governor settings or overspeed the engine. See the engine manual for more information on engine settings.

8. Never use hands to check for hydraulic leaks.



WARNING

Keep body and hands away from pinholes or nozzles that eject high-pressure hydraulic fluid. If hydraulic fluid is injected into the skin, it must be surgically removed by a doctor within a few hours, or gangrene may result. If your machine hydraulic system needs service, please see your Authorized Scag Dealer.

9. Carefully release pressure from any components with stored energy.
10. When performing service that requires the hopper to be raised, ensure the cylinder lock is engaged and secure. See Figure 2-1 and Section 6.3.

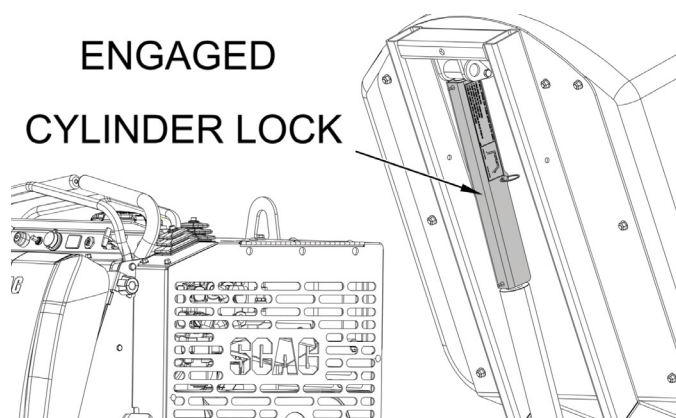


Figure 2-1. Engaged Cylinder Lock

STORAGE & TRANSPORTATION SAFETY

1. Allow the engine to cool before storing the machine.
2. Shut off the fuel system while storing or transporting the machine.
3. Store the machine in a clean garage or storage area. Do not store the machine near open flames, sparks, fuel containers, or other hazards.
4. Service the machine before storing over long periods of time. Check all nuts, bolts, and screws to ensure the machine is in a safe working condition. Change the air cleaner, engine oil, and apply grease.

5. Cover the machine to protect it while storing over long periods of time.
6. Charge the battery in an open, well-ventilated area. Keep away from sparks and open flames. Unplug the charger before connecting or disconnecting from the battery. Always wear protective clothing and use insulated tools while working with the battery.
7. Transport the machine using a heavy-duty trailer or truck with a load rating greater than the weight of the machine. Ensure the trailer or truck complies with all legal requirements for lighting and markings. Refer to local ordinances for specific trailer and tie-down requirements before use.
8. Only use a full-width ramp to transport the machine. The ramp angle should be no more than 10 degrees. See Section 2.9.
9. Always load and unload the machine with the heavy end of the machine facing up the ramp.
10. When transporting the machine, ensure the steering control levers are in the neutral position, the parking brake is engaged, and the engine is off with the key removed. Block the tracks before transporting.
11. Tie the machine down securely using straps, chains, or cables. Both the front and rear straps must be directed down and outward from the machine. Refer to local ordinances for tie-down requirements before use. See Figure 2-2.
12. Do not transport the machine with the hopper raised. Lower the hopper when parked or during storage if not installing the cylinder lock.

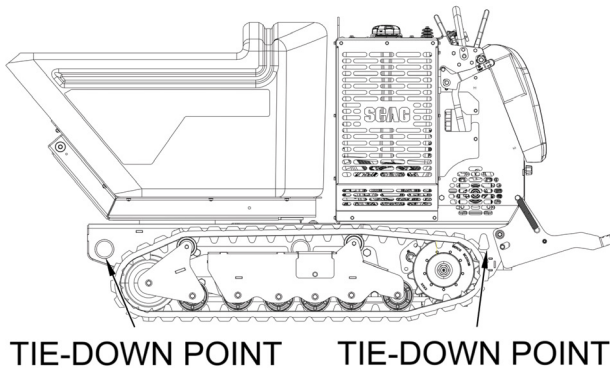
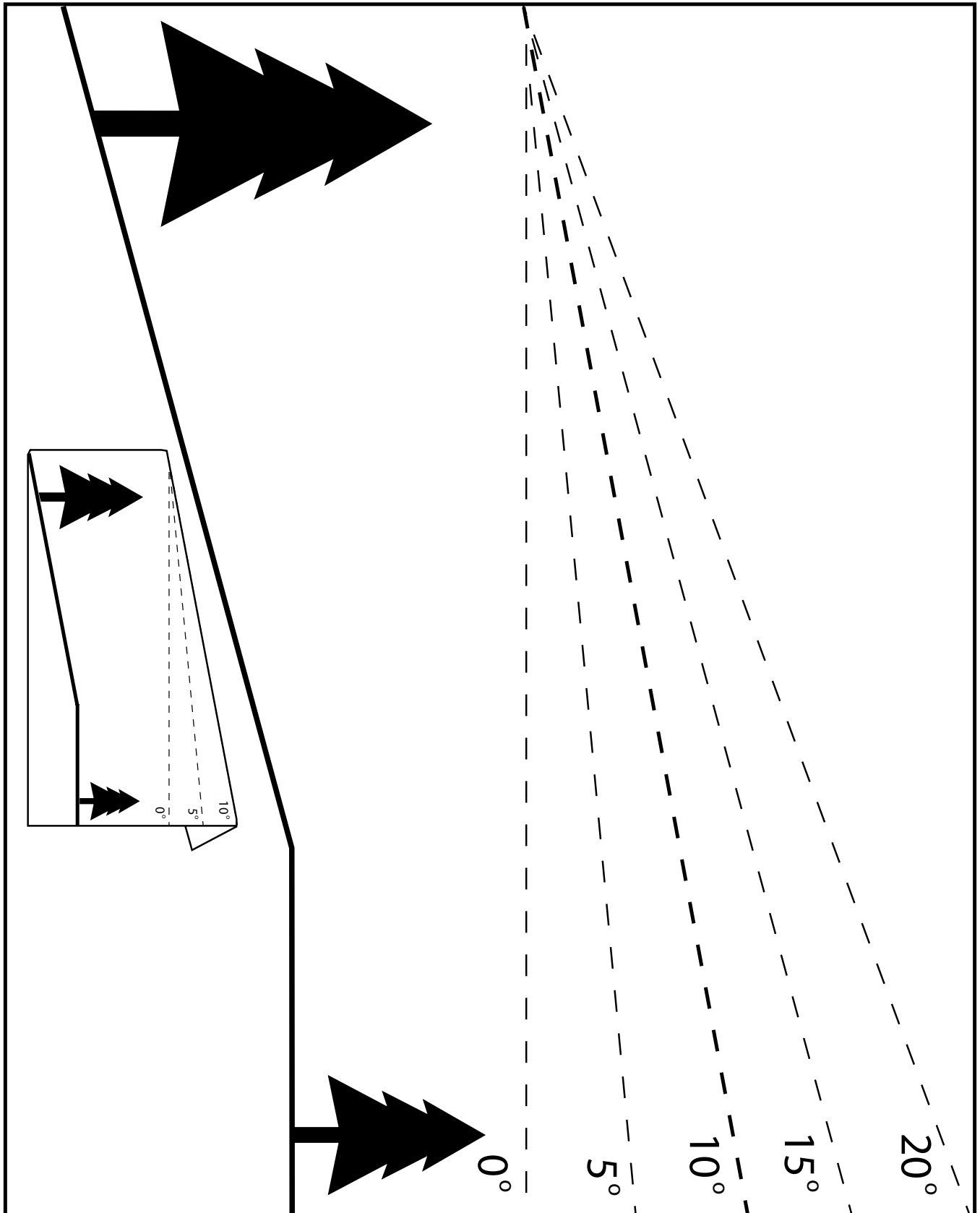
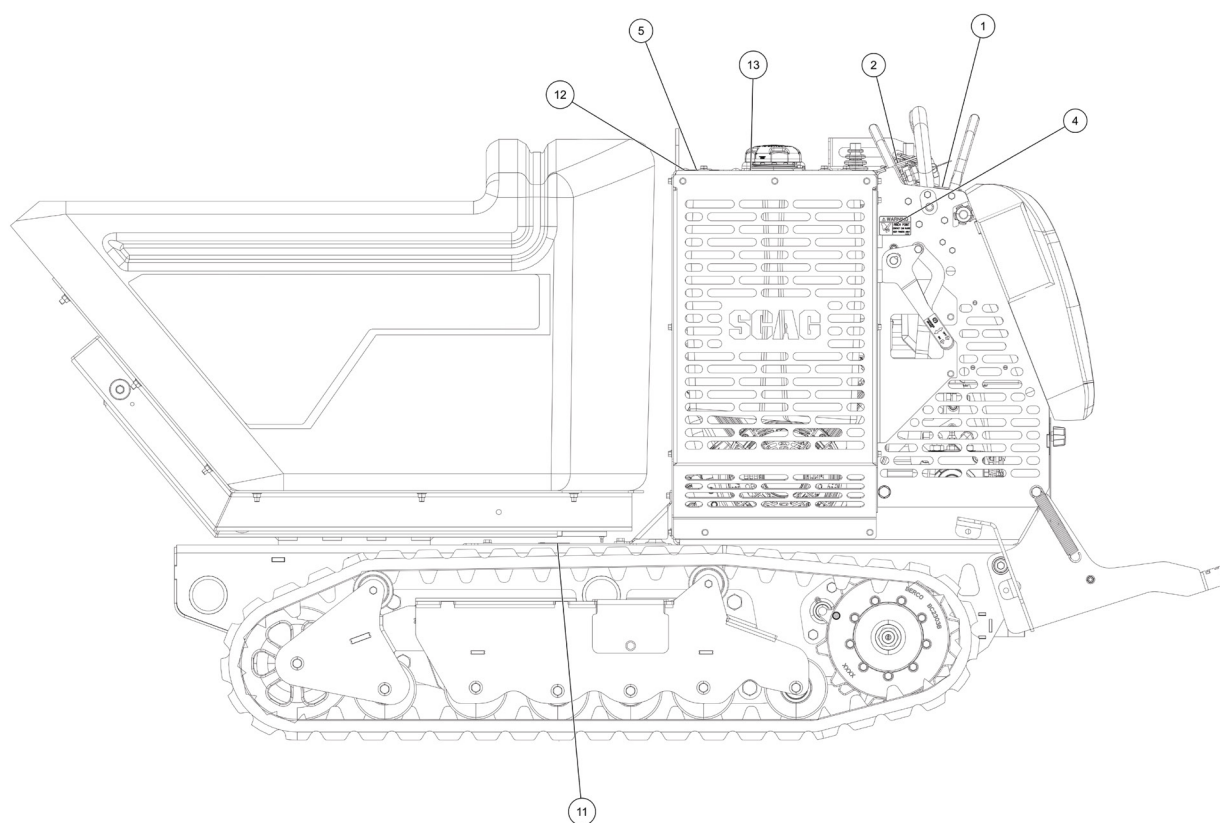
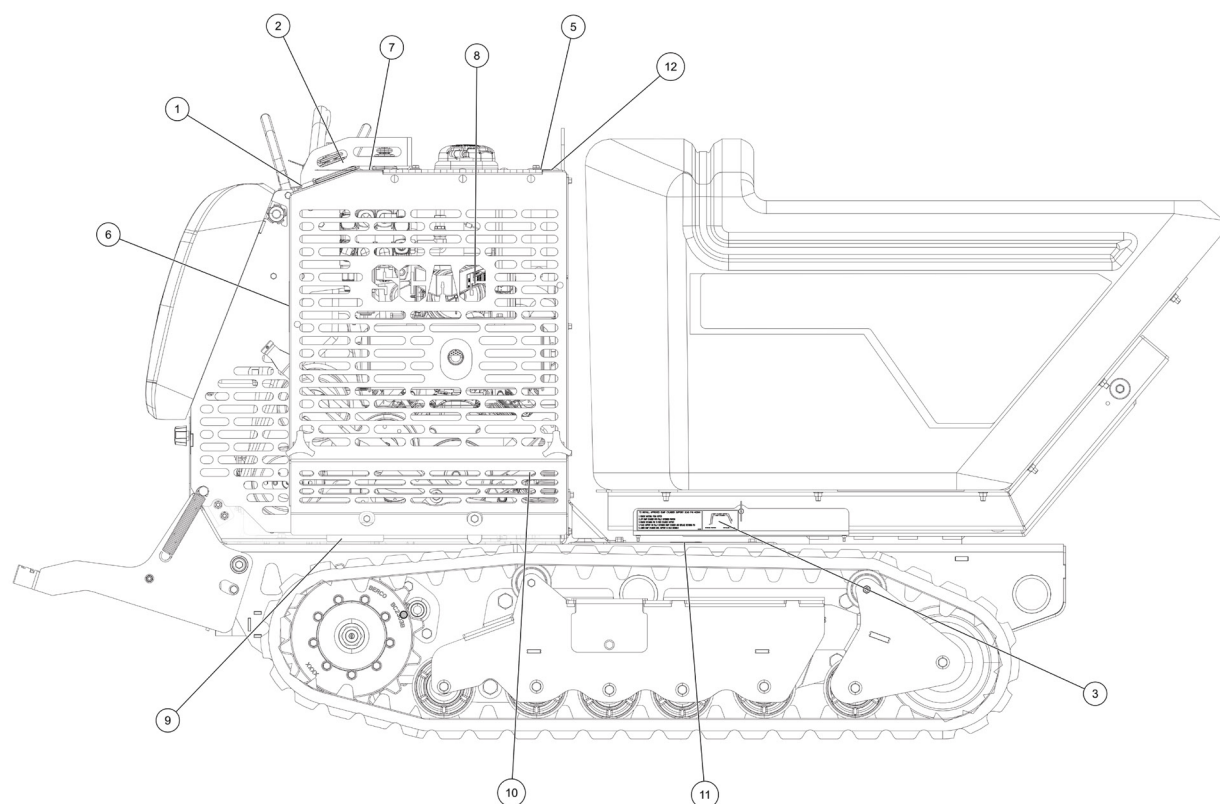


Figure 2-2. Main Tie-Down Points

2.5 SLOPE ANGLE GRAPH



2.6 SAFETY AND INSTRUCTIONAL DECAL LOCATIONS



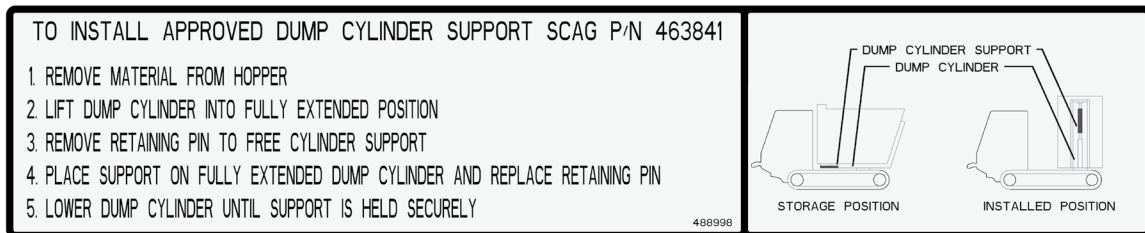
2.7 SAFETY AND INSTRUCTIONAL DECAL DETAILS



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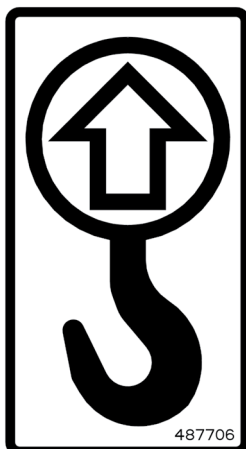
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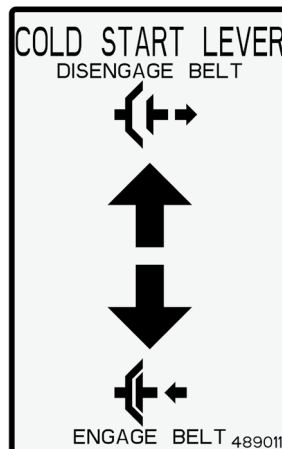
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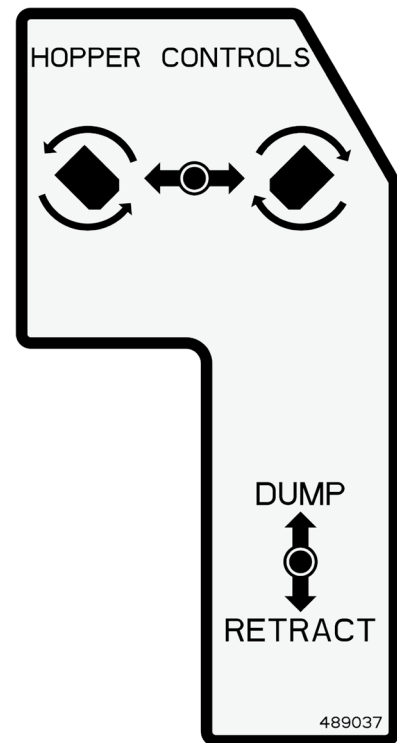
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2.8 SAFETY AND INSTRUCTIONAL DECAL DETAILS (CONT.)



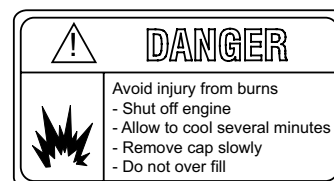
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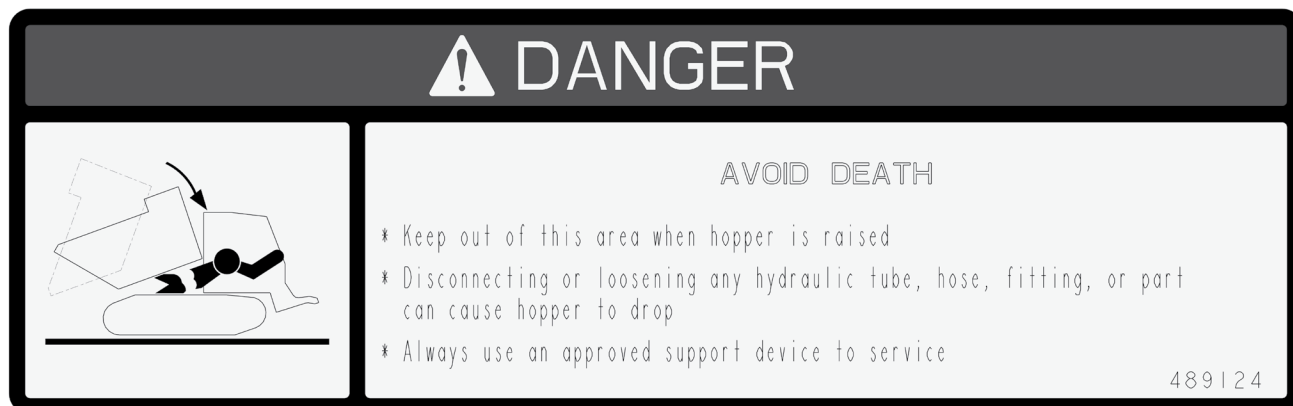
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NOTES

SPECIFICATIONS

3.1 ENGINE

General Type	Heavy Duty Commercial Gas
Engine Model:	
Briggs & Stratton Vanguard 23BV	Briggs & Stratton Model # 386447
Horsepower:	
Briggs & Stratton Vanguard 23BV	23 HP
Displacement:	
Briggs & Stratton Vanguard 23BV	627cc
Idle Speed:	
Briggs & Stratton Vanguard 23BV	1750 RPM (±100 RPM)
Full Speed:	
Briggs & Stratton Vanguard 23BV	3600 RPM (±100 RPM)
Fuel Pump:	
Briggs & Stratton Vanguard 23BV	Mechanical Fuel Pump
Fuel.....	Non-Leaded Gasoline with a Minimum Octane Rating of 87
Belts.....	Kevlar Cord, Self-Adjusting, Self-Tightening

3.2 ELECTRICAL

Battery	12V
Charging Output	12V, 20 Amp
System Polarity.....	Negative Ground
Instrument Panel	Inductive Hour Meter, Throttle Lever, Choke Control, Ignition Key Switch, Light Switch, Horn Button, 12V Power Plug
Fuses.....	Two (2) 20 Amp

3.3 DRIVE SYSTEM

Drive System	Track
Hydraulic Pumps	Hydro-Gear™ Tandem 16cc Piston Pump
Hydraulic Drive Motors	Two (2) Parker TKG Series Torqmotor™ Motors
Steering/Travel Control.....	Twin Lever Steering Control with Individual Track Control
Parking Brake	Mechanical Sprocket Lock
Fuel Tank Capacity	9.25 Gallon
Travel Speed:	
Forward	6 MPH
Reverse	4 MPH

3.4 HYDRAULIC SYSTEM

Hydraulic Oil Filter	500 Hours
Hydraulic Oil Capacity	6 Gallons

3.5 WEIGHTS AND DIMENSIONS

Machine Width.....	35.5 in
Machine Length.....	96 in
Machine Height.....	50 in
Track Width	7 in
Assembled Weight:	
Plastic Hopper	1700 lbs.
Steel Hopper	2000 lbs.
Operating Capacity.....	2500 lbs.

3.6 PRODUCTIVITY

Hopper Capacity.....	13.5 ft ³ / 0.5 yd ³
Discharge Height.....	17.5 in
Dump Angle	90°
Pivot Angle.....	90°

OPERATING INSTRUCTIONS



CAUTION

Do not attempt to operate this machine before reading this manual. Become familiar with the location and purpose of all controls, instruments, operating practices, and safety decals before operating this machine.

4.1 CONTROLS AND INSTRUMENTS

Before operating the 2500X Tracked Power Buggy, familiarize yourself with all buggy controls and engine controls. Knowing the location, function, and operation of these controls is crucial for the safe and efficient operation of the machine.

1. **Ignition Switch (Figure 4-2):** The ignition switch is used to start the engine and has three positions: OFF, ON, and START.
2. **Engine Choke Control (Figure 4-2):** Controls the air pressure in the intake manifold. Only use when starting a cold engine.
3. **Engine Throttle Control (Figure 4-2):** Controls the engine speed. Pushing the lever forward increases the engine speed. Pulling the lever back decreases the engine speed. The furthest back position of the lever is the IDLE position.
4. **Inductive Hour Meter (Figure 4-2):** Indicates the number of hours the machine has been operated for.
5. **Light Switch (Figure 4-2):** Controls the working lights on the machine.
6. **Horn Button (Figure 4-2):** Controls the horn on the machine.
7. **12V Power Plug (Figure 4-2):** An additional power supply for all your worksite needs.
8. **Left Steering Control (Figure 4-2):** Controls power to the left track. See Section 4.4 for further information regarding ground travel and steering.
9. **Right Steering Control (Figure 4-2):** Controls power to the right track. See Section 4.4 for further information regarding ground travel and steering.
10. **Parking Brake Lever (Figure 4-2):** Engages and disengages the parking brakes. Move the lever back and lock to engage the parking brakes. Unlock the lever and move forward to disengage the parking brakes.
11. **Hopper Lift Control Lever (Figure 4-2):** Controls the dump and lift action of the hopper.
12. **Hopper Pivot Control Lever (Figure 4-2):** Controls the turning pivot action of the hopper.
13. **Fuse Holders (Figure 4-2):** Two 20-amp fuses protect the electrical system of the machine. Pull a fuse out of the socket to replace.
14. **Fuel Gauge (Figure 4-2):** Indicates the amount of fuel in the fuel tank.
15. **Fuel Shut-Off Valve (Figure 4-2):** Controls the fuel supply to the engine. Located on top of the fuel tank and accessible on top of the machine.
16. **Dump Valve Controls (Figure 4-2):** Located on the hydraulic pumps and used to "free-wheel" the buggy. Rotating clockwise until closed allows the machine to move under hydraulic power. The levers must be in this position and torqued 7 to 10 ft-lb during the operation of the machine. Rotating counter-clockwise allows the machine to be moved by hand (free-wheeling). See Figure 4-1.
17. **Declutch Lever (Figure 4-2):** Detent control for the pump drive idler arm. Pull the lever out to lock the idler arm. Push the lever in to release the idler arm and allow motion.

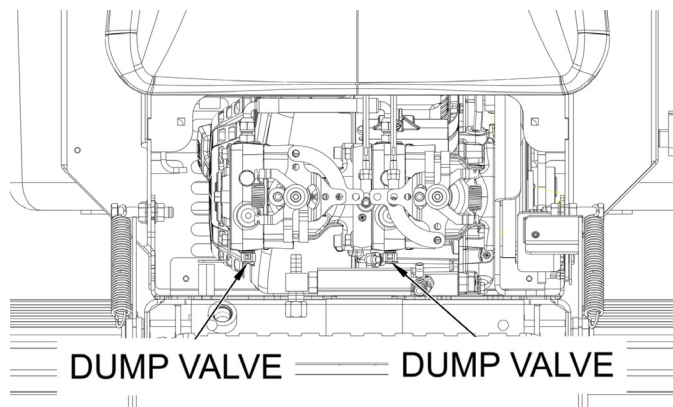


Figure 4-1. Dump Valve Location

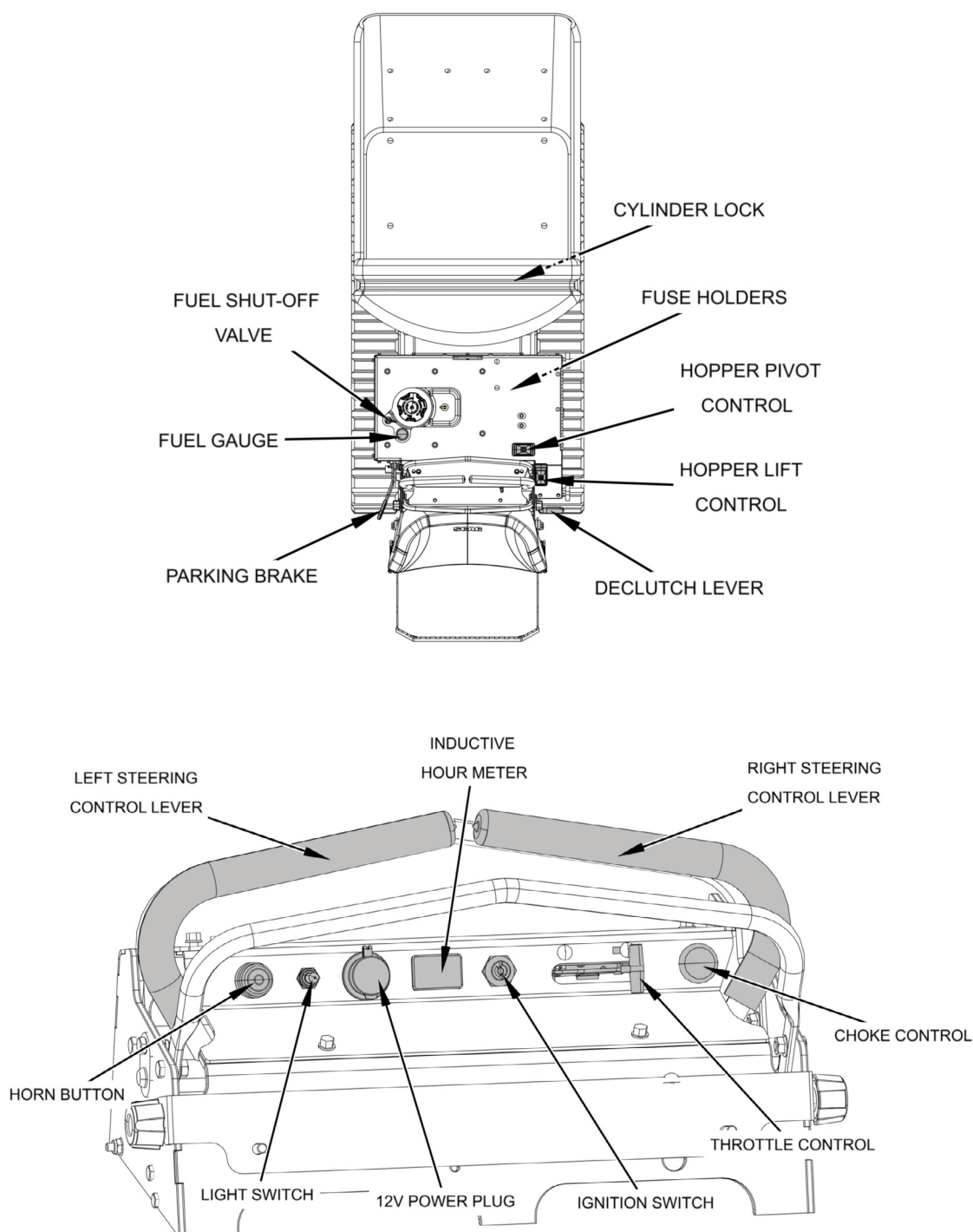


Figure 4-2. Controls and Instruments

4.2 INITIAL RUN-IN PROCEDURES

FIRST DAY OR 20 HOURS OF USE

1. Inspect the machine before each use for missing or damaged safety shields, guards, and decals. Repair or replace as needed.
2. Change the engine oil and oil filter after the first 20 hours of operation. See Section 6.6.
3. Check the hydraulic oil level in the hydraulic system reservoir. See Section 6.5.
4. Check all belts for proper alignment and wear at two, four, and eight hours of operation.
5. Check track tension and adjust as necessary. See Section 5.3.
6. Check for loose hardware and tighten as necessary.

4.3 STARTING THE ENGINE



CAUTION

Never use starting fluids with this machine. The use of starting fluids in the air intake system may cause explosions or a "runaway" engine condition, which can result in engine damage and personal injury.

1. Ensure the fuel shut-off valve, located on top of the fuel tank, is completely open. See Figure 4-3.

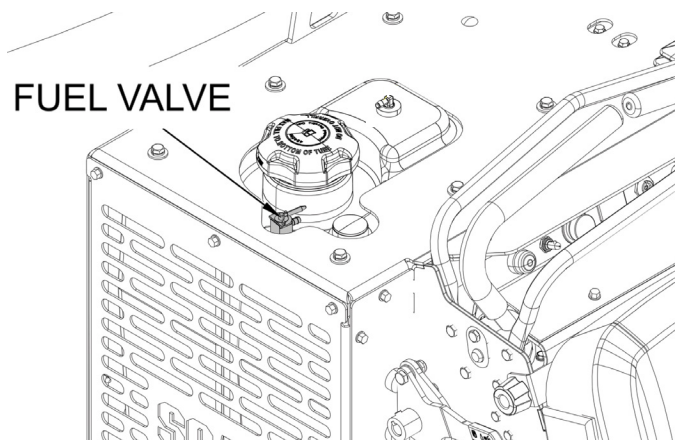


Figure 4-3. Fuel Valve Location

2. Stand in the operating position before attempting to start the machine.
3. Ensure that the steering control levers are in the neutral position.
4. Ensure that the hopper control levers are in the neutral position.
5. If the engine is cold, choke the engine as needed using the engine choke control.
6. Move the engine throttle control to the slow position.
7. Turn the ignition key to the START position to start the engine.

IMPORTANT

Do not engage the starter for longer than five seconds. If the engine fails to start, wait for at least ten seconds between attempts. Excessive attempts to start the engine may burn out the starter on the machine.

8. Allow the engine to warm up before operating the machine.

COLD WEATHER START

If outdoor temperatures are below 32° Fahrenheit, store the machine indoors to keep the unit warmer and allow for the ease of starting.

1. Pull the declutch lever out to lock the pump drive idler arm in a detent.
2. Follow the starting procedure outlined in Section 4.3: "Starting the Engine."
3. Allow the machine to warm up before proceeding.
4. Push the declutch lever in to disengage the detent.

IMPORTANT

Running the engine at high speeds when the hydraulic system is cold may cause damage to the hydraulic system.

4.4 GROUND TRAVEL AND STEERING

IMPORTANT

If you are not familiar with the operation of a machine with lever steering or hydrostatic transmissions, the steering and ground speed controls of this machine should be learned and practiced in an open area away from buildings, fences, or obstructions. Practice these controls until you are comfortable with the handling of the machine before beginning work.

Do not operate this machine on slopes until you are comfortable operating on flat surfaces.

IMPORTANT

Always practice with a slow engine speed and slow rate of forward travel.

Obtain a smooth operating action by learning to feather the steering controls.

Practice operating this machine until you are thoroughly familiar and comfortable with the controls before beginning work.

FORWARD TRAVEL

To travel forward with the machine, disengage the parking brake, use the front reference bar as an anchor point for your hands, and slowly pull both steering control levers forward an equal distance. The further forward the steering control levers are pulled, the greater the forward speed of the machine will be. See Figure 4-4.

To increase the forward speed of the machine, pull both steering control levers forward. To decrease the forward speed of the machine, allow both steering control levers to return toward the neutral position.

NOTE

Smooth operation of the steering control levers will result in a smooth operation. Maintain a low and consistent travel speed while learning the operation of the steering controls.

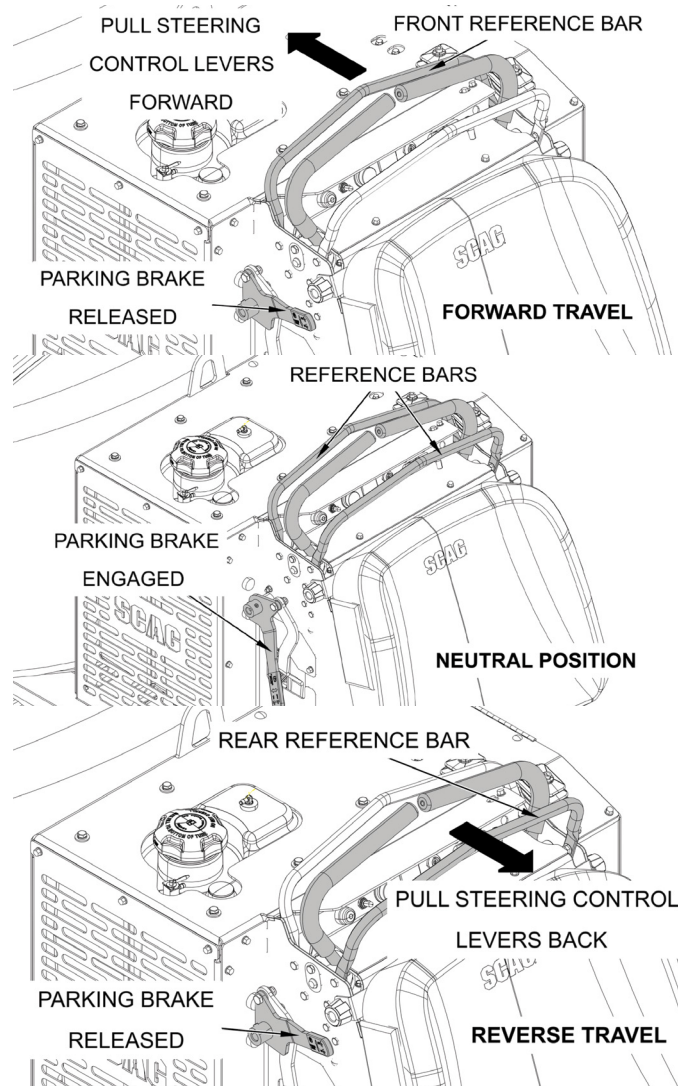


Figure 4-4. Travel Controls

To steer the machine to the left while traveling forward, allow the left steering control lever to move back toward the neutral position. The further the steering control lever is allowed to move back, the quicker the machine will turn left.

To steer the machine to the right while traveling forward, allow the right steering control lever to move back toward the neutral position. The further the steering control lever is allowed to move back, the quicker the machine will turn right.

To stop the forward travel of the machine, allow both steering control levers to return to the neutral position. Engage the parking brake if the machine is to be parked.

REVERSE TRAVEL

CAUTION

Be aware of obstacles and obstructions before traveling in reverse. Clear the area of bystanders before operating this machine. Possible injury or property damage may occur if proper precautions are not taken before traveling in reverse.

To travel in reverse with the machine, use the rear reference bar as an anchor point for your hands and slowly pull both steering control levers back an equal distance. The further back the steering control levers are pulled, the greater the reverse speed of the machine will be. Keep the travel speed low at all times when traveling in reverse. See Figure 4-4.

To steer the machine to the left while traveling in reverse, allow the left steering control lever to move forward toward the neutral position. The further the steering control lever is allowed to move forward, the quicker the machine will turn left.

To steer the machine to the right while traveling in reverse, allow the right steering control lever to move forward toward the neutral position. The further the steering control lever is allowed to move forward, the quicker the machine will turn right.

To stop the reverse travel of the machine, allow both steering control levers to return to the neutral position. Engage the parking brake if the machine is to be parked.

SLOPE OPERATION

WARNING

Never operate the machine on slopes greater than 10 degrees. See Section 2.9 or download a slope indicator app on your mobile device to determine approximate slope angles. Always follow OSHA-approved operation.

The 2500X Tracked Power Buggy has been designed for good traction and stability under normal working conditions. However, the operator must use caution when traveling on slopes or poor ground conditions, such as loose soil, sand, gravel, wet surfaces, and uneven surfaces. See Section 2.3 for additional information.

1. To prevent tipping and loss of control, avoid starting and stopping on slopes. Keep all movements on slopes slow and gradual. Avoid all unnecessary turns and maintain a reduced travel speed. If the machine loses traction, proceed slowly down the slope.
2. Always operate on slopes with the heavy end of the machine facing uphill. Weight distribution of the machine will change depending on load distribution.
3. Do not raise the hopper while operating the machine on slopes. Raising the hopper will change the load distribution of the machine and affect stability.
4. If you lose control of the machine, step off and away from the direction of travel of the machine.

4.5 HOPPER CONTROLS

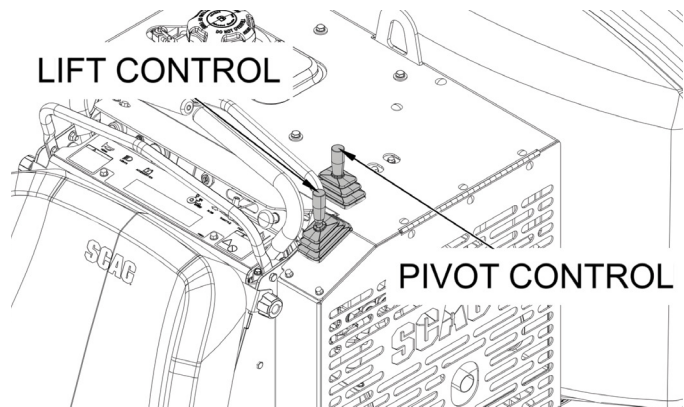


Figure 4-5. Lift & Pivot Control Levers

Use the lift control lever and pivot control lever to control the hopper attachment on the machine. See Figure 4-5.

Before beginning work, confirm the operating capacity of the hopper. Be aware of the physical characteristics and associated risks of your load. Do not exceed the hopper operating capacity, and evenly distribute your load. See Section 2.3 and Section 3 for additional information.

1. Lift the hopper by moving the lift control lever forward.

2. Lower the hopper by moving the lift control lever backward.
3. Pivot the hopper to the left by moving the pivot control lever to the left.
4. Pivot the hopper to the right by moving the pivot control lever to the right.

4.6 PARKING THE MACHINE

1. Park the machine only on flat and level surfaces. Do not park the machine on an incline.
2. Place the steering control levers in the neutral position.
3. Slow the engine to the IDLE speed.
4. Engage the parking brake.
5. Turn the ignition key to the OFF position to shut off the engine. Remove the key.

4.7 POST-OPERATION PROCEDURES

DANGER

Avoid serious injury from burns by allowing the machine to cool before performing any post-operation procedures. Do not remove the fuel tank cap and refuel while the machine is running or immediately after stopping. Do not touch the engine or muffler while the machine is running or immediately after stopping.

1. Wash the machine after each use. Do not use a high-pressure washer or spray directly onto electrical components.

IMPORTANT

Do not wash a running or hot engine. Cold water will damage the engine. Use compressed air to clean the engine.

2. Clean dirt and debris from drives, mufflers, and the engine after each use. Prevent fires by cleaning all oil and fuel spills.
3. Ensure the entire machine is clean to inhibit serious heat damage to the engine or hydraulic oil circuit.

4. After the machine has cooled down, fill the fuel tank with fresh, clean fuel. See the Engine Owner's Manual for proper octane requirements.
5. Check all belts for proper alignment and signs of wear. Adjust and replace as necessary.
6. Check track tension and adjust as necessary. See Section 5.3.

4.8 MOVING AN INOPERABLE OR STUCK TRACKED POWER BUGGY

If the tracked power buggy becomes stuck, pull the machine back into a stable position using both front tie-down points or both rear tie-down points simultaneously. See Figures 4-7 and 4-8.

WARNING

Never use the lift point to pull a machine that is inoperable or stuck. This may cause the machine to tip over.

IMPORTANT

Do not pull the machine without loosening the dump valves into bypass, otherwise damage to the hydraulic drive or track system will occur.

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Remove the foot guard from the machine.
4. Loosen the dump valves on the hydraulic pump. See Figure 4-1. Do not loosen more than two full turns.
5. Disengage the parking brake.
6. Only use tow chains, ropes, or straps that are rated at least 1.5 times the weight of the machine.
7. Pull the machine from the front tie-down points or the rear tie-down points at a speed of 1-2 MPH. High-speed towing will damage the machine.
8. Tighten the dump valves on the hydraulic pump after repairs on the machine have been completed.

4.9 TRANSPORTING THE MACHINE

1. Transport the machine using a heavy-duty trailer or truck with a load rating greater than the weight of the machine. Ensure the trailer or truck complies with all legal requirements for lighting and markings. Refer to local ordinances for specific trailer and tie-down requirements before use.
2. Only use a full-width ramp to transport the machine. The ramp angle should be no more than 10 degrees. See Section 2.9.
3. Always load and unload the machine with the heavy end of the machine facing up the ramp. See Figure 4-6 and Section 2.4 for more information.

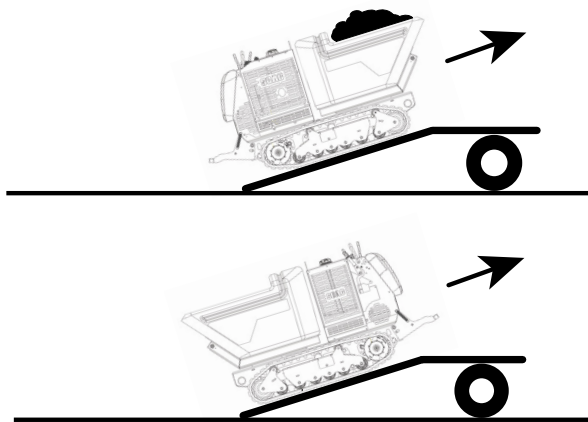


Figure 4-6. Loading Trailer

4. When transporting the machine, ensure the steering control levers are in the neutral position, the parking brake is engaged, and the engine is off with the key removed. Block the tracks before transporting.
5. Do not transport the machine with the hopper raised.
6. Use metal tie-down loops to secure the machine to the trailer or truck. Tie the machine down securely using straps, chains, or cables. Both the front and rear straps must be directed down and outward from the machine. Refer to local ordinances for tie-down requirements before use. See Figure 4-7 and 4-8.

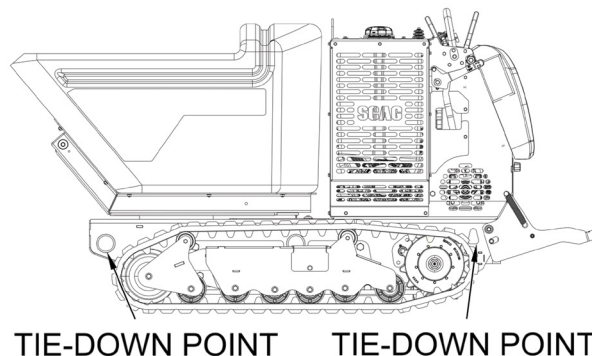


Figure 4-7. Main Tie-Down Points

4.10 LIFTING THE MACHINE

The 2500X Tracked Power Buggy has been designed with a lift point that can be used to lift the machine. Please read the following instructions and safety points before attempting to lift the machine.

DANGER

Do not lift the machine with material in the hopper. The weight of the load will change the weight and center of gravity of the machine, which may result in unsafe lifting conditions.

1. Secure chains or lifting straps rated for the weight and size of the machine to the lift point. See Figure 4-8.

LIFT POINT

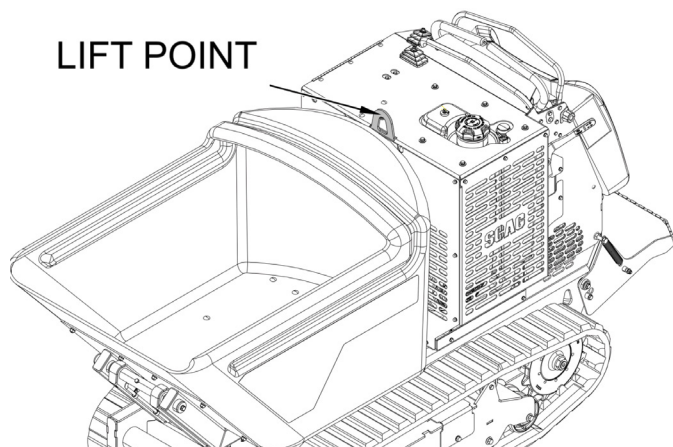


Figure 4-8. Lift Point

2. Attach the chains or lifting straps to an overhead hoist. Inspect all attaching hardware for wear and damage. Replace as necessary.
3. Remove slack from the chains or lifting straps using the hoist before attempting to lift the machine.
4. Slowly lift the machine only as high as required to reach the desired location.
5. Slowly move the machine to the desired location.

DANGER

- Do not lift the machine if it exceeds the maximum rated capacity of the hoist and attaching hardware.
- Read the specifications for attaching hardware and choose hardware suitable for the weight, size, and configuration of the machine.
- Inspect the attaching hardware (chains, hooks, straps, and master links) before every use. Do not use any worn or damaged attaching hardware.
- Ensure the attaching hardware (chains, hooks, straps, and master links) are fully strong enough to withstand the load being lifted.
- Do not use attaching hardware (chains, hooks, straps, and master links) in extreme temperatures or other environmental conditions that exceed the manufacturer's specifications.
- Assess the center of gravity of the machine. Lift the machine so that it remains horizontal.
- Ensure all hooks or other master link devices use safety latches.
- Machine disengagement can cause severe injury or death. The use of a hook or other master link device does not preclude inadvertent detachment of a slack sling load from the hook or master link. Visual verification of proper hook or shackle engagement is always required.
- Comply with Federal, State, and Local regulations, ordinances, and safety standards when lifting the machine.
- Assess the center of gravity of the machine. Lift the machine so that it remains horizontal.
- Do not allow bystanders to enter the working area near the suspended machine. Never walk under or move the suspended machine above people.

ADJUSTMENTS

5.1 PARKING BRAKE ADJUSTMENT

WARNING

Do not operate the machine if the parking brake is inoperable. Severe injury may result.

Adjust the parking brake whenever the engaged parking brake does not hold the machine properly, or whenever the disengaged parking brake does not allow the machine to move freely. If the parking brake cannot be adjusted properly, contact your Authorized Scag Dealer for further brake adjustments.

1. Park the machine on a level surface and lower the hopper. Do not engage the parking brake.
2. Shut off the engine and remove the key.
3. With the parking brake disengaged, check the brake shaft pin on each track. Ensure that the brake shaft pins clear the track sprockets. See Figure 5-3.

NOTE

Ensure the parking brake pin area is clean of dirt and debris. Grease the pins as needed.

4. Engage the parking brake.
5. Start the machine. Move slightly forward until the tracks are stopped by the brake shaft pins. Move slightly in reverse until the tracks are stopped by the brake shaft pins. Visually confirm. See Figure 5-2.
6. Disengage the parking brake. If the brake shaft does not clear the track sprocket, adjust as needed.
7. Support the machine with jack stands rated for the weight of the machine.
8. Loosen the nuts on the parking brake cable adjuster. Turn the adjuster until the cable is taught, not tight. See Figure 5-1.
9. With the parking brake engaged, confirm that the adjustment is correct. Repeat as needed.
10. Tighten the parking brake cable adjuster nuts.

NOTE

Ensure the parking brake adjustment is correct on both sides of the machine.

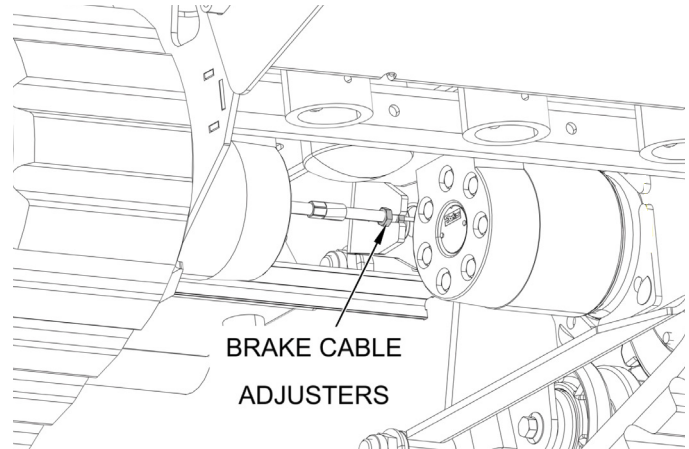


Figure 5-1. Brake Adjustment Location

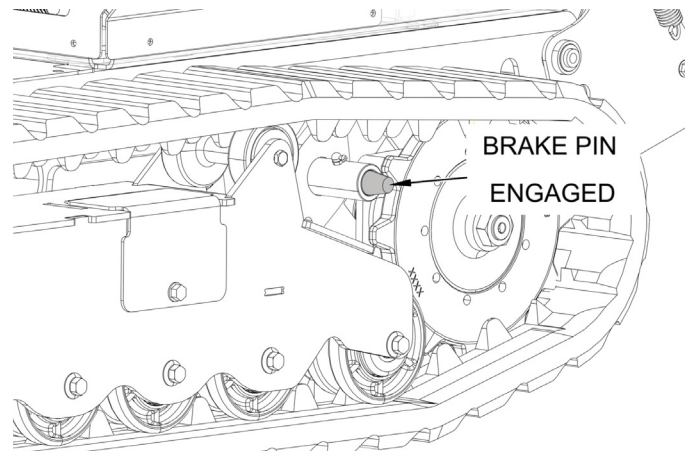


Figure 5-2. Parking Brake Engaged

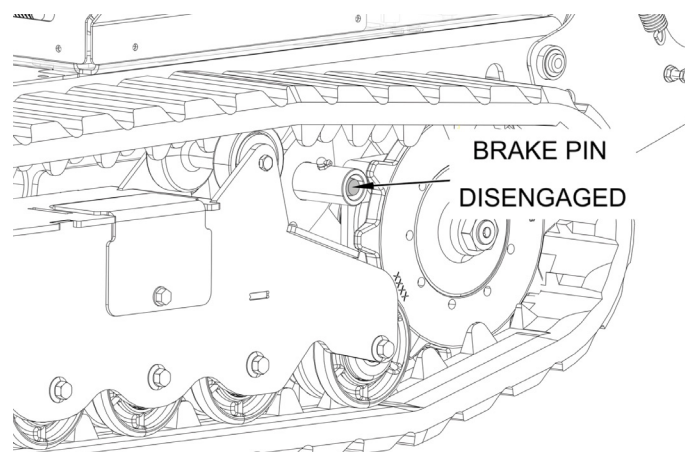


Figure 5-3. Parking Brake Disengaged

5.2 THROTTLE CONTROL ADJUSTMENT

Throttle control adjustments must be performed by an Authorized Scag Dealer to ensure proper and efficient running of the engine. Should your throttle control need an adjustment, contact your Authorized Scag Dealer.

5.3 TRACK TENSION ADJUSTMENT

To check and adjust track tension, you must lift the weight of the machine off the tracks. Lift and support the machine with jack stands rated for the weight of the machine when adjusting track tension. The proper sag from the bottom of the track should measure 3/8" from the bottom of the track pad to the bottom of the middle track roller.

IMPORTANT

The following procedure should be performed with the machine on a level surface, the engine shut off, and the hopper lowered.

11. Support the machine with jack stands rated for the weight of the machine.
12. Measure the sag in the middle of the track using a tape measure. See Figure 5-4.

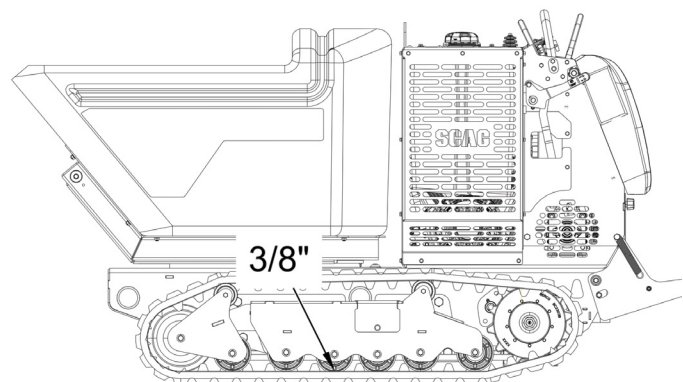


Figure 5-4. Track Tension Adjustment

13. If the track sag is more than 3/8", follow Procedure A: "Tightening the Track Tension" to tighten the track. See Figure 5-5.
14. If the track sag is less than 3/8", follow Procedure B: "Loosening the Track Tension" to loosen the track. See Figure 5-5.

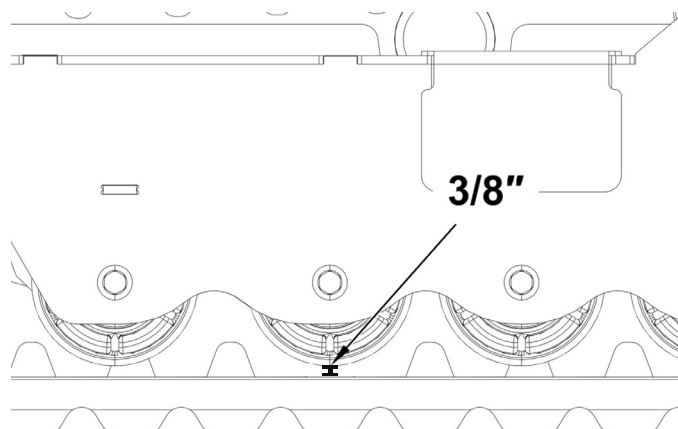


Figure 5-5. Track Sag Measurement

A. TIGHTENING THE TRACK TENSION

1. Remove the bolts on the track support cover and remove the cover. See Figure 5-6.

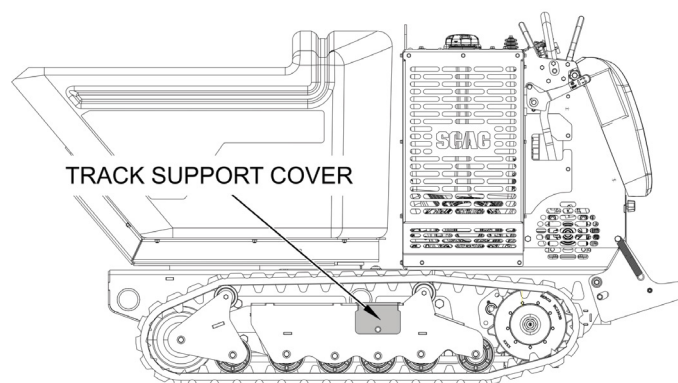


Figure 5-6. Track Support Cover

2. Wipe the grease zerk clean with a rag.
3. Pump grease into the grease zerk until the sag in the track measures 3/8". See Figure 5-7.
4. Clean excess grease from the machine.
5. Repeat the procedure for the other track as needed.
6. Install the track support cover and tighten the bolts.

B. LOOSENING THE TRACK TENSION

1. Remove the bolts on the track support cover and remove the cover. See Figure 5-6.

2. Use a 3/4" wrench to turn the large hex insert on the cylinder tensioner counterclockwise. This process will loosen the track and extract grease. See Figure 5-7.
3. Check the track for a 3/8" sag and adjust as needed.
4. Clean excess grease from the machine.
5. Repeat the procedure for the other track as needed.
6. Install the track support cover and tighten the bolts.

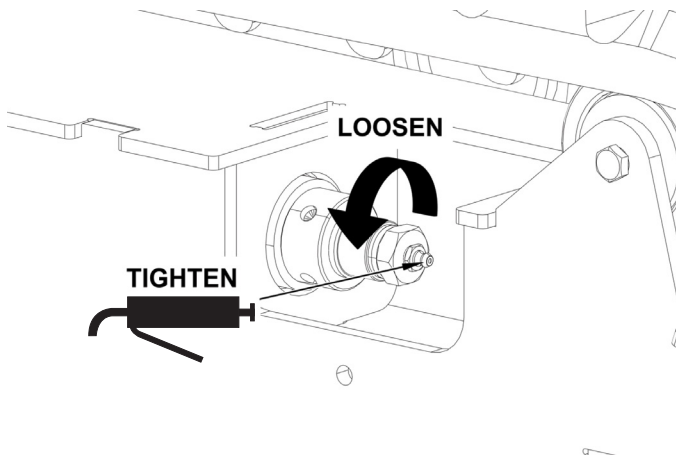


Figure 5-7. Tightening & Loosening Track

5.4 OPERATOR PLATFORM ADJUSTMENT

The operator suspension platform can be adjusted to optimize the comfort and ride of the machine. Adjust the suspension rate by adding or removing rubber isolators to the operator platform. Stiffen the suspension by adding rubber isolators. Soften the suspension by removing rubber isolators. See Figure 5-8.

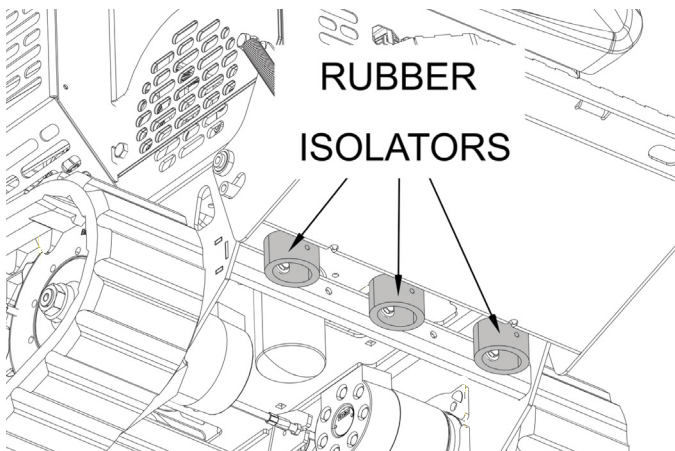


Figure 5-8. Operator Platform Rubber Isolators

MAINTENANCE

6.1 RECOMMENDED MAINTENANCE INTERVALS

HOURS						PROCEDURE	COMMENTS
BREAK-IN (FIRST 10)	8	40	100	200	500		
X						Check all hardware for tightness.	
X						Check fuel level.	See Section 6.7
X						Check hydraulic oil level.	See Section 6.5
X						Inspect drive belt for proper alignment and wear after 2, 4, 8, and 10 hours of operation.	See Section 6.5 & 6.10
See Engine Owner's Manual						Change engine oil and oil filter.	See Section 6.6
See Engine Owner's Manual						Change engine fuel filter.	See Section 6.6
	X					* Clean tracked power buggy.	
	X					Check hydraulic fittings and hoses for leaks.	Use extreme caution when checking hydraulic hoses. See Section 2.4
	X					Check engine oil level.	See Section 6.6
	X					* Clean air filter element.	See Section 6.8
	X					Lubricate grease fittings.	See Section 6.2
		X				Inspect drive belt for proper alignment and wear. Replace drive belt after 400 hours of operation or every two years, whichever occurs first.	See Section 6.5 & 6.10
		X				Inspect condition of fuel lines.	
		X				Check battery electrolyte levels. Clean battery posts and cables.	See Section 6.9
			X			Check all hardware for tightness.	
			X			Lubricate grease fittings.	See Section 6.2
			X			* Clean air filter element.	See Section 6.8
			X			Inspect drive belt for proper alignment and wear.	See Section 6.5 & 6.10
			X			Inspect condition of fuel lines.	
			X			Drain hydraulic system. Replace hydraulic oil and hydraulic oil filters.	See Section 6.5
				X		Check all hardware for tightness.	
				X		Lubricate grease fittings.	See Section 6.2
				X		Check hydraulic oil level.	See Section 6.5
					X	Lubricate grease fittings.	See Section 6.2
					X	Drain hydraulic system. Replace hydraulic oil and hydraulic oil filters.	See Section 6.5

* Perform these maintenance procedures more frequently when regularly exposed to dusty or dirty conditions.

6.2 GREASE FITTING LOCATIONS

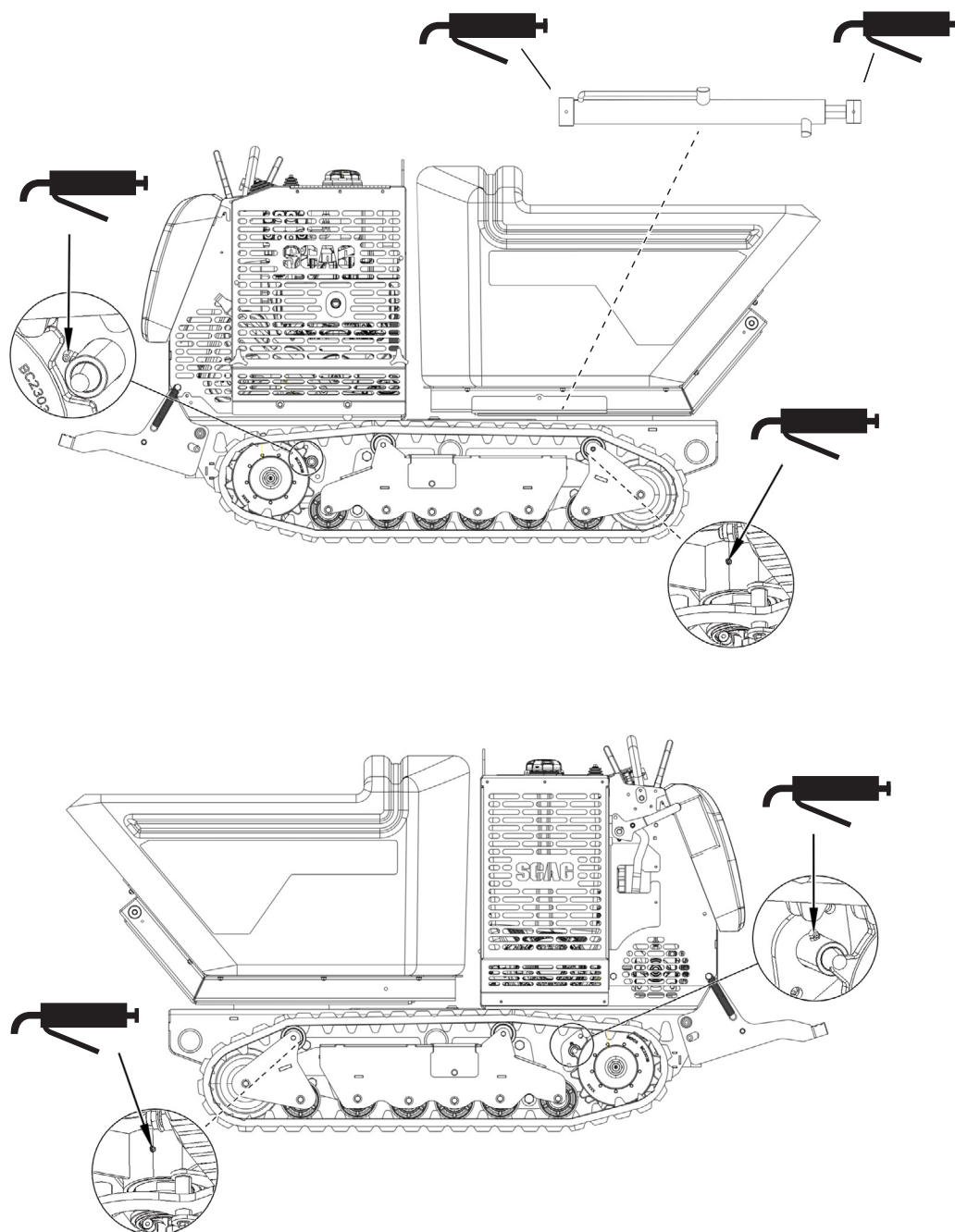


Figure 6-1. Lubrication Fitting Points

6.3 CYLINDER LOCK SUPPORT

DANGER

The machine lift cylinder may lower when in the raised position, crushing anyone under the hopper. Install the cylinder lock support before performing maintenance that requires the hopper to be raised to avoid severe injury or death.

Some maintenance procedures will require the hopper to be raised. Never perform these maintenance procedures without the cylinder lock installed in the machine.

INSTALLING THE CYLINDER LOCK

1. Park the machine on a level surface and engage the parking brake.
2. Raise the hopper to the maximum height.
3. Shut off the engine and remove the key.
4. Remove the pin securing the cylinder lock to the storage location. See Figure 6-2.

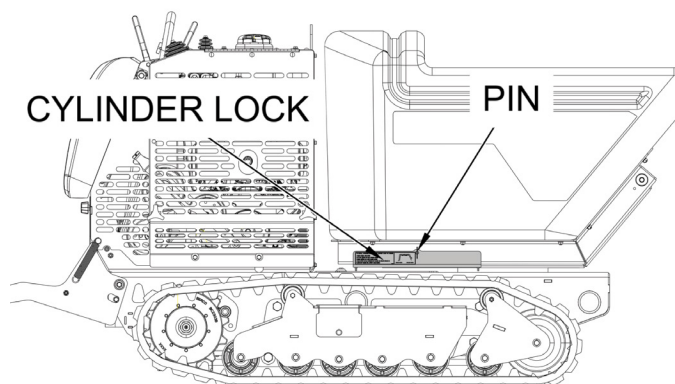


Figure 6-2. Cylinder Lock Location

5. Install the cylinder lock over the lift cylinder rod and secure in place using the pin. See Figure 6-3.

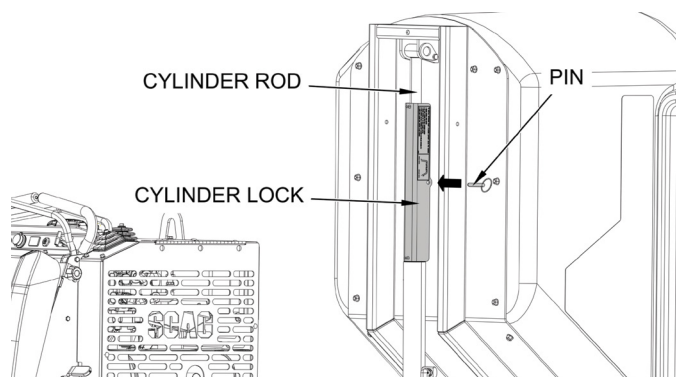


Figure 6-3. Positioning the Cylinder Lock

6. Lower the hopper until the cylinder lock is secure between the hopper and the cylinder. See Figure 6-4.

IMPORTANT

When lowering the hopper from the maximum height with the engine off, the oil reservoir may become overfilled. This results in oil escaping from the breather.

Whenever possible, lower the hopper with the engine running and the operator in the operating position. If lowering the hopper with the engine off, lower the hopper slowly to prevent oil from purging out of the breather.

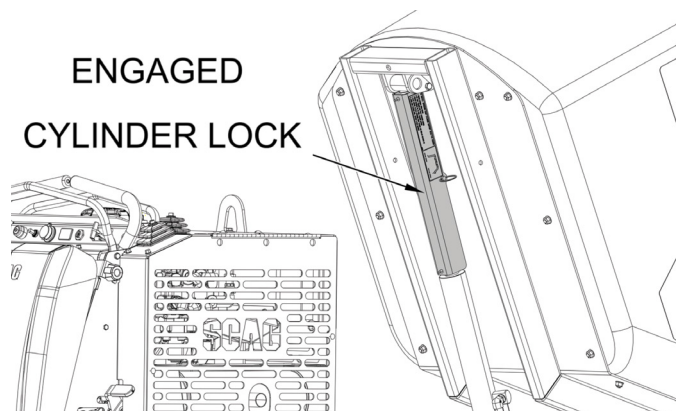


Figure 6-4. Securing the Cylinder Lock

REMOVING AND STORING THE CYLINDER LOCK

1. Ensure all maintenance procedures are complete and tools have been removed from the machine.
2. Start the engine.

3. Raise the hopper to the maximum height.
4. Shut off the engine and remove the key.
5. Remove the pin securing the cylinder lock to the lift cylinder rod. Stay clear of the hopper.
6. Place the cylinder lock in the storage location and secure in place using the pin.
7. Lower the hopper.

IMPORTANT

Ensure the cylinder lock has been uninstalled from the lift cylinder rod and secured in the storage location before operating the machine.

6.4 ACCESSING INTERNAL COMPONENTS

WARNING

Shut off the engine and remove the ignition key before removing any covers, hoods, shields, guards, plates, or screens. Wait for all movement to stop and allow for the engine to cool to avoid personal injury.

Under no circumstances should the machine be operated without these devices in place.

OPENING SIDE ENGINE GUARD

1. Remove the two knobs securing the engine guard to the machine. See Figure 6-5.
2. Lift upward to open the engine guard.

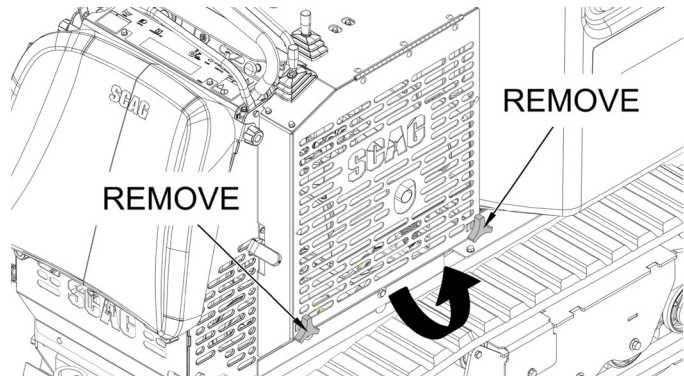


Figure 6-5. Engine Guard Removal

REMOVING THE CUSHION BRACKET

1. Remove the two knobs securing the cushion bracket to the machine. See Figure 6-6.
2. Lift the cushion bracket off the machine.

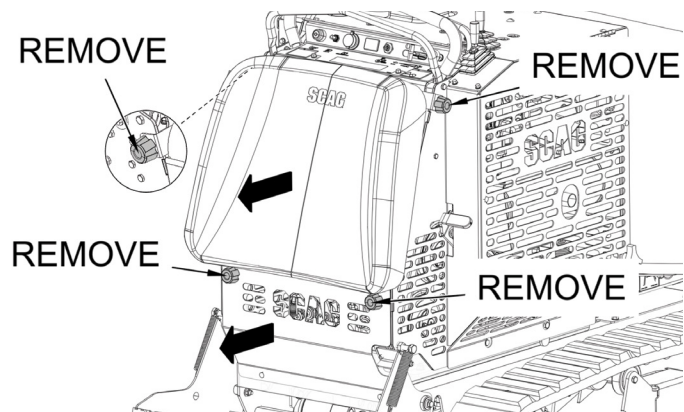


Figure 6-6. Cushion Bracket & Foot Guard

REMOVING THE FOOT GUARD

1. Remove the two knobs securing the foot guard to the cushion bracket. See Figure 6-6.
2. Lift the foot guard off the machine.

6.5 HYDRAULIC SYSTEM

WARNING

Before performing maintenance on the hydraulic system, relieve residual pressure by repeatedly engaging and disengaging the lift and pivot levers while the machine is not running.

A. CHECKING THE HYDRAULIC OIL LEVEL

The hydraulic oil level should be checked after the first ten hours of operation. Thereafter, the hydraulic oil level should be checked after every ten hours of operation.

IMPORTANT

If the hydraulic oil level is consistently low, check for leaks and correct immediately.

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine and remove the key.
3. Remove the cushion bracket from the machine.
4. Check the hydraulic oil level shown in the reservoir sight gauge. See Figure 6-7.

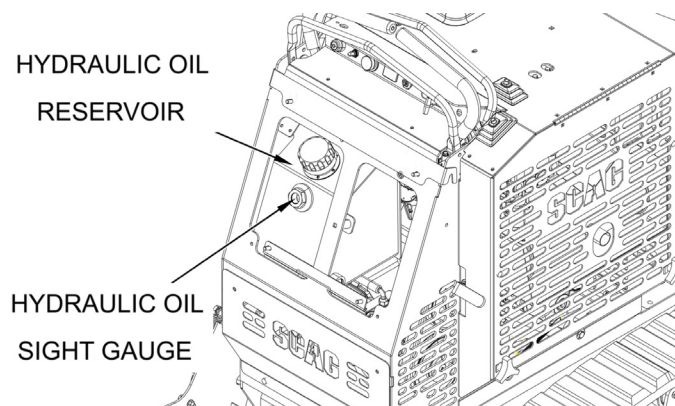


Figure 6-7. Hydraulic Oil Reservoir

5. The reservoir sight gauge must show hydraulic oil. If the oil is too low, fill to the center of the sight gauge. Remove dust and debris from the reservoir and the reservoir fill cap before proceeding.

IMPORTANT

Do not overfill the hydraulic oil reservoir with oil. Overfilling the reservoir may cause oil seepage near the reservoir cap or breather.

6. Clean the hydraulic reservoir fill cap and reinstall it onto the reservoir.
7. Clean all remaining oil residue from the machine.
8. Reinstall the cushion bracket to the machine.

B. CHANGING THE HYDRAULIC OIL

The hydraulic oil should be changed after every 500 hours of operation or annually, whichever occurs first. If the color of the oil becomes black or milky, change immediately. A black color or rancid odor indicates a possible overheating of the oil. A milky color indicates that water has mixed with the oil.

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Remove the cushion bracket from the machine.
4. Place a suitable container under the reservoir drain plug and remove the reservoir fill cap. Remove the drain plug and allow for all of the used oil to drain into the container. See Figure 6-8.

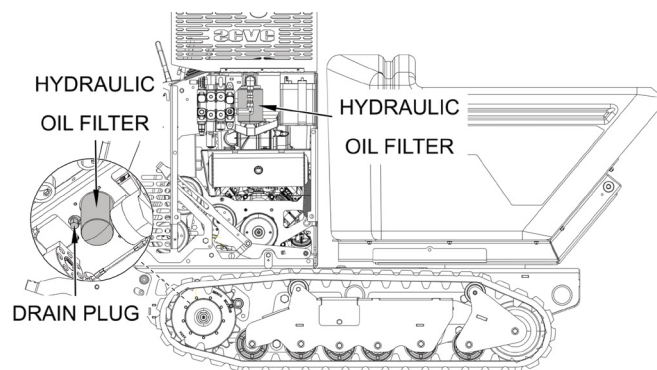


Figure 6-8. Hydraulic Oil Filters & Drain Plug

5. Properly discard of all used oil and reinstall the drain plug until tight.

IMPORTANT

Before refilling the hydraulic oil, the hydraulic oil filter should be replaced as outlined in Procedure C: "Changing the Hydraulic Oil Filter."

6. Fill the reservoir with hydraulic oil until the oil level is centered in the reservoir sight gauge.
7. Reinstall the reservoir fill cap and confirm the oil level shown in the reservoir sight gauge. If needed, add additional hydraulic oil to the reservoir.
8. Run the engine at IDLE speed with the steering control levers in neutral for five minutes.
9. With the machine parked on a level surface and the hopper lowered, confirm the hydraulic oil level shown in the reservoir sight gauge.
10. Reinstall the cushion bracket to the machine.

C. CHANGING THE HYDRAULIC OIL FILTER

The hydraulic oil filter should be replaced after every 500 hours of operation or annually, whichever occurs first.

1. Place a suitable container or rag under the hydraulic oil filter to catch used oil. Remove the oil filter and properly discard. See Figure 6-8.
2. Install the new hydraulic oil filter and torque to 10 ft-lb.
3. Run the engine at IDLE speed with the steering control levers in the neutral position for five minutes.
4. With the machine parked on a level surface and the hopper lowered, confirm the hydraulic oil level in the reservoir sight gauge.

6.6 ENGINE OIL

A. CHECKING THE ENGINE OIL LEVEL

The engine oil level should be checked after every eight hours of operation or daily, as instructed by the Engine Owner's Manual provided with this machine.

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Remove the cushion bracket from the machine.

4. Remove the dipstick and check the engine oil level. Add additional oil as needed. See Figure 6-9.

IMPORTANT

Do not overfill the engine crankcase with oil. If the oil level in the crankcase is too high and you run the machine, you may damage the engine.

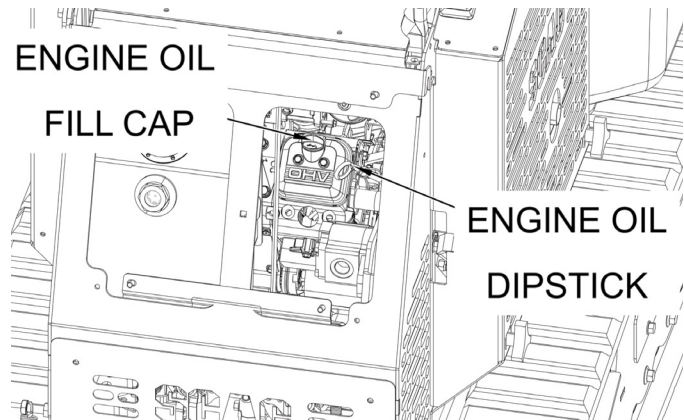


Figure 6-9. Engine Oil Cap & Dipstick

5. Reinstall the cushion bracket to the machine.

B. CHANGING THE ENGINE OIL

Before changing the engine oil, refer to the Engine Owner's Manual for the required engine oil type.

1. Run the engine of the machine for five minutes.

DANGER

Components will be hot if the machine has been running. Prevent burns by avoiding hot components while changing the engine oil and engine oil filter.

2. Park the machine on a level surface, engage the parking brake, and lower the hopper.
3. Shut off the engine and remove the key.
4. Support the machine using jack stands rated for the weight of the machine.
5. Remove the cushion bracket from the machine and open the side engine guard.

6. Place a suitable container under the engine oil drain plug. Remove the drain plug and allow for all of the used oil to drain into the container. See Figure 6-10.
7. Properly discard of all used oil and reinstall the drain plug until tight.

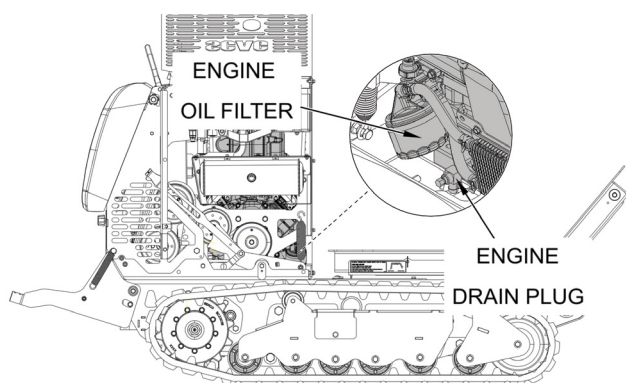


Figure 6-10. Engine Oil Filter & Drain Plug

IMPORTANT

Before refilling the engine oil, the engine oil filter should be replaced as outlined in Procedure C: "Changing the Engine Oil Filter."

8. Remove the engine oil cap and pour in fresh, clean oil as specified by the Engine Owner's Manual. Pour slowly and check the oil level to avoid overfilling. See Figure 6-9.
9. Confirm the engine oil level. If correct, reinstall the engine oil cap.
10. Clean all remaining oil residue from the machine.
11. Reinstall the cushion bracket and secure the side engine guard to the machine.

C. CHANGING THE ENGINE OIL FILTER

Read the Engine Owner's Manual for information on engine oil filter maintenance schedules.

1. Place a suitable container or rag under the engine oil filter to catch used oil. Remove the oil filter and properly discard. See Figure 6-9.
2. Clean the filter mounting surface before installing a new oil filter.

3. Lubricate the gasket of the new oil filter with fresh, clean oil before installation.
4. Install the oil filter until hand tight. Do not over tighten.

6.7 ENGINE FUEL SYSTEM

A. FILLING THE FUEL TANK

Fill the fuel tank at the beginning of each operating day with clean, fresh fuel. See the Engine Owner's Manual for fuel requirements.

DANGER

Prevent burns by allowing the machine to cool before removing the fuel tank cap and refueling.

1. Extinguish all ignition sources (cigarettes, matches, lighters, etc.) before working with fuel.
2. Only use approved containers to store fuel. Never fuel indoors or inside enclosed spaces, and clean any spillage before starting the machine.

CAUTION

If fuel is spilled on clothing, change clothing immediately and wash affected skin. Affected areas may suffer from irritation, chemical burns, and contact dermatitis.

3. Do not fill containers on a truck or trailer bed with a plastic liner. Always place containers on the ground and away from your vehicle before fueling.
4. Remove the machine from the truck or trailer and fuel on the ground. If impossible, fuel the machine with a portable container instead of a fuel dispenser.
5. Do not remove the fuel tank cap or add fuel while the machine is running. Allow for the engine to fully cool before adding fuel.
6. Clean dirt and debris from the fuel tank and remove the fuel tank cap.

7. Keep the fuel nozzle in contact with the rim of the fuel tank or approved container at all times until fueling is complete. Do not use nozzle lock devices.
8. Do not fill above the bottom of the fuel tank neck to allow for the expansion of fuel. See Figure 6-11.

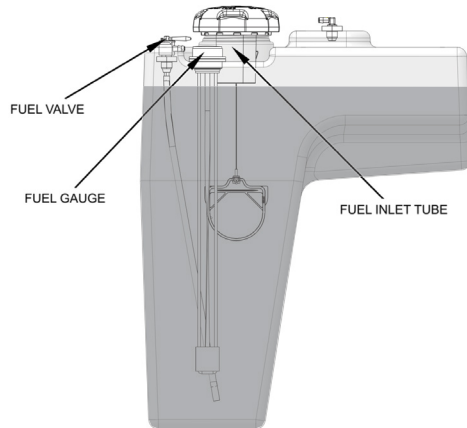


Figure 6-11. Fuel Fill Level

9. Clean the fuel tank cap and reinstall it onto the fuel tank. Tighten until secure.

B. REPLACING THE FUEL FILTER

The engine fuel filter should be replaced after every 500 hours of operation or annually, whichever occurs first.

1. Close the fuel shut-off valve. See Figure 6-12.

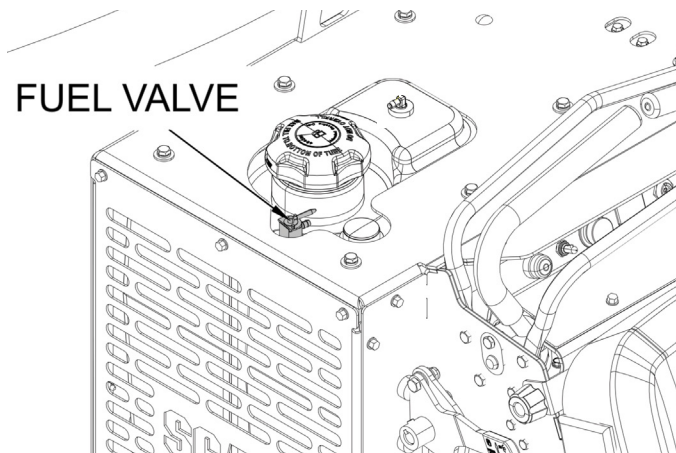


Figure 6-12. Fuel Shut-Off Valve

2. Remove the two clamps securing the fuel filter to the fuel hose line. Remove the fuel filter.

3. Install a new fuel filter. Ensure the filter is installed facing the proper direction. Secure the fuel filter to the fuel hose line using the two clamps.
4. Open the fuel shut-off valve.

6.8 ENGINE AIR CLEANER

A. CLEANING & REPLACING AIR CLEANER

The operating environment and conditions dictate the air cleaner service periods. Inspect and clean the air cleaner after every 100 hours of operation or bi-weekly, whichever occurs first. Replace the air cleaner as needed.

NOTE

In extremely dusty conditions, check the air cleaner once or twice daily to prevent dust buildup and engine damage.

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Open the side engine guard.
4. Release the two latches securing the air cleaner cover to the air cleaner assembly. Remove the cover and set aside. See Figure 6-13.

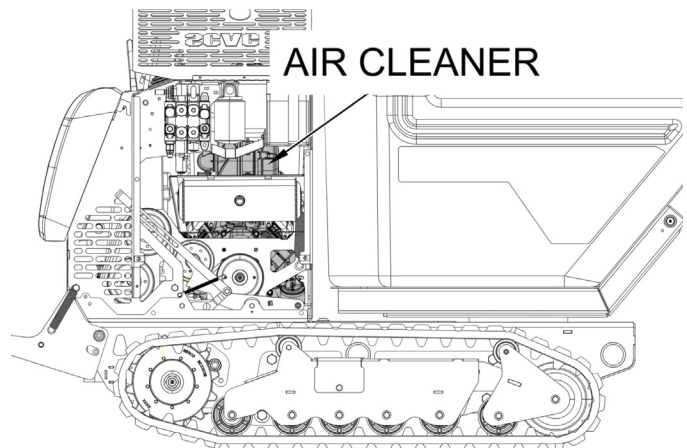


Figure 6-13. Air Cleaner Location

5. Remove and inspect the air cleaner.
6. Clean or replace the air cleaner as recommended by the engine manufacturer.
7. Reinstall the air cleaner cover and secure in place using the two latches.

6.9 BATTERY

WARNING

Batteries produce flammable and explosive gases. Work in a well-ventilated area when checking, testing, or charging the battery. Keep arcs, sparks, and flames away from the battery at all times. Always wear safety glasses, protective equipment, and use insulated tools while working with the battery. Never smoke while handling the battery to avoid personal injury.

WARNING

Battery posts, terminals, and related accessories contain lead and lead compounds, chemicals known to cause cancer and reproductive harm. Wash hands after handling.

WARNING

Battery electrolyte fluid contains sulfuric acid, a poison that can cause severe chemical burns. Avoid contact with eyes, skin, and clothing. Wear safety glasses, protective equipment, and use insulated tools when working with batteries.

If fluid contact occurs, follow the recommended first aid procedures below:

BATTERY ELECTROLYTE FIRST AID

External Contact — Flush with water.

Eye Contact — Flush with water for at least 15 minutes. Seek medical attention immediately!

Internal Contact — Do not induce vomiting. Drink large quantities of water followed by Milk of Magnesia, beaten eggs, or vegetable oil. Seek medical attention immediately!

A. REMOVING THE BATTERY

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Open the side engine guard.
4. Remove the negative battery cable from the battery.
5. Remove the positive battery cable from the battery.
6. Uninstall the battery box strap and remove the battery from the machine. See Figure 6-14.

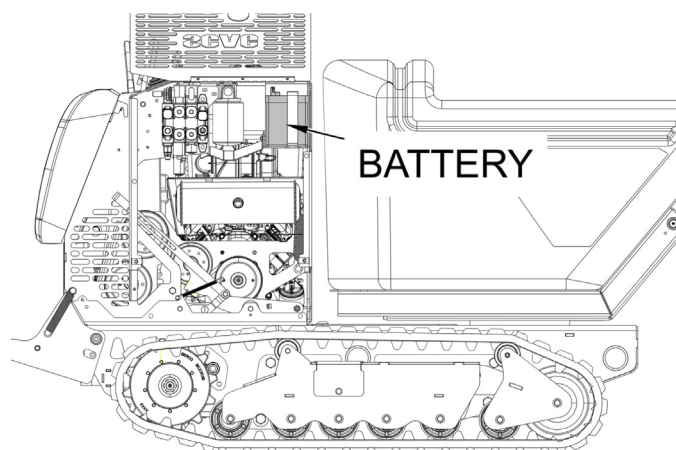


Figure 6-14. Battery Location

B. CHARGING THE BATTERY

Read the Battery Charger Owner's Manual for operation instructions before attempting to charge the battery.

Under normal conditions, the charging system will maintain a charge on the battery. However, the charging system may not be able to recharge a battery that has been discharged for a long period of time. In this case, a battery charger will be required to charge the battery.

IMPORTANT

Before charging the battery, the battery should be removed from the machine as outlined in Procedure A: "Removing the Battery."

Clean dirt and debris from the battery cell covers and ensure that the electrolyte covers all lead plates in the battery cells before proceeding.



WARNING

Batteries produce explosive gases. Charge the battery in a well-ventilated space to allow for the dissipation of gases during the charging process.



WARNING

Never charge a frozen battery. Attempting to charge a frozen battery may cause an explosion and result in personal injury. Always wait for a battery to warm up before attaching a charger.

Charging rates between three (3) and fifty (50) amperes are satisfactory if the battery does not feel excessively hot (over 125° Fahrenheit), or if excessive gassing or spewing of electrolyte does not occur. If the temperature exceeds 125° Fahrenheit, or if gassing and spewing occurs, the charging rate must be reduced or temporarily stopped to permit cooling.

When the battery is fully charged, disconnect the battery charger from its power source before disconnecting the charger leads from the battery posts.

C. JUMP-STARTING THE BATTERY

1. The booster battery must be a 12-Volt type. If using a vehicle to jump-start the machine, the vehicle must have a negative ground system.
2. Connect the positive jumper cable to the positive battery post.
3. Connect the negative jumper cable to the negative battery post.
4. Turn on the booster battery and attempt to start the machine. If using a vehicle to jump-start the machine, start the vehicle and wait five minutes to allow for the battery to charge. Attempt to start the machine. When successful, do not shut off the machine.
5. Remove the negative jumper cable from the battery.
6. Remove the positive jumper cable from the battery.

6.10 DRIVE BELTS

The 2500X Tracked Power Buggy drive belt is spring-loaded and self-tensioning. During the initial run-in of the machine, check the drive belt for proper alignment and wear after the first 2, 4, 8, and 10 hours of operation. Thereafter, check the drive belt after every 40 hours of operation or weekly, whichever occurs first.

NOTE

If you experience frequent belt wear or breakage, see your Authorized Scag Dealer service center for a belt adjustment.



DANGER

Steering control will be lost if the pump drive belt fails, which may result in serious injury or death. Replace the pump drive belt as needed, after 400 hours of operation, or every two years, whichever occurs first.

6.11 DRIVE SYSTEM MAINTENANCE

A. CLEANING THE TRACKS

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Support the machine using jack stands rated for the weight of the machine.
4. Clean the tracks using a water hose or pressure washer.

IMPORTANT

Do not use a pressure washer to clean the machine. Only use a pressure washer on the tracks. High-pressure washing can damage the electrical system and hydraulic valves, or deplete grease.

B. REMOVING THE TRACKS

1. Park the machine on a level surface, engage the parking brake, and lower the hopper.
2. Shut off the engine, remove the key, and allow for the engine to cool.
3. Support the machine using jack stands rated for the weight of the machine. Raise the machine off the ground so that the bottom of the track is at least 10.2 cm (4 inches) above the ground.
4. Remove the bolts on the track support cover and uninstall the cover to access the track tensioner assembly. See Figure 6-15.

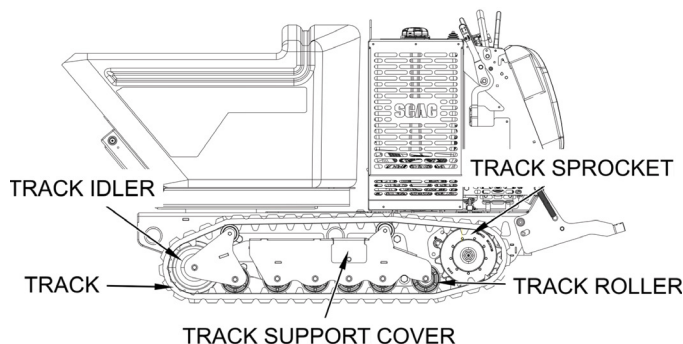


Figure 6-15. Track System

5. Loosen the cylinder tensioner until all the grease is released to release track tension. The tensioner will retract the front idler, producing slack to remove the track. See Figure 6-16.
6. Remove the track from the track frame, track sprocket, and track idler.
7. Repeat this procedure to remove the other track.

C. INSTALLING THE TRACKS

1. With the track tensioner retracted (See Step #5 of Procedure B: "Removing the Tracks"), wrap the new track around the track frame.
2. Ensure the track is aligned with the rollers, sprocket, and idlers.
3. Grease the cylinder tensioner until the front track idler creates tension on the track.
4. Install the track support cover and tighten the bolts.
5. Repeat the procedure to install the other track.

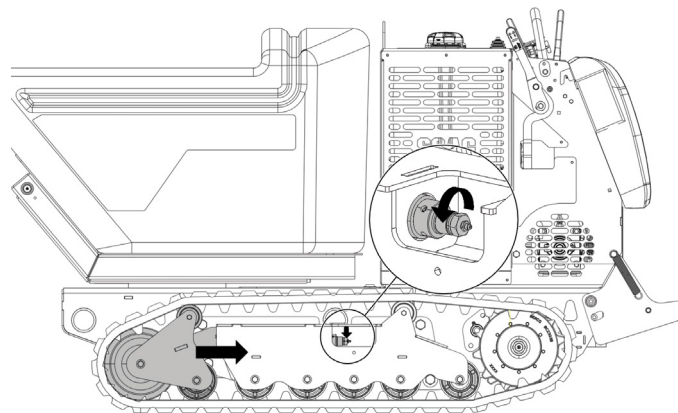


Figure 6-16. Releasing Track Tension

6. Lower the machine to the ground. Operate the machine with the new tracks.
7. Park the machine on a level surface, engage the parking brake, and lower the hopper.
8. Shut off the engine, remove the key, and allow for the engine to cool.
9. Verify that the track tension is correct. See Section 5.3: "Track Tension Adjustment."

6.12 BODY AND UPHOLSTERY

1. Wash the machine after each use. Use cold water and automotive cleaners.

CAUTION

Do not wash the machine while running or hot. Cold water will damage the engine. Clear any dirt or debris buildup on the engine with a brush, blower, or compressed air.

2. Use a mild soap solution, a vinyl cleaner, or a rubber cleaner to clean the cushions.
3. Do not spray electrical components with water or cleaners.
4. Repair damaged metal surfaces using Scag touch-up paint, available from your Authorized Scag Dealer. For maximum paint protection, wax the machine.

6.13 FLUID CAPACITIES

LUBRICANT/ FUEL	COMPONENT	CAPACITY
Hydraulic Oil	Hydraulic System	N/A
Fuel	Fuel Tank	9.25 U.S. Gallon / 35 Liters

6.14 RECOMMENDED FLUIDS

LUBRICANT	RECOMMENDATION
GREASE	Scag Premium Chassis Grease (P# 486257)
HYDRAULIC OIL	20W-50 Hydraulic Oil (Gallon – P# 486254) (Quart – P# 486255)

NOTE***Fuel***

- *All fuel used with the machine must be clean, fresh, and unleaded.*
- *A minimum of 87 octane (87 AKI, 91 RON) is a minimum standard for this machine. A minimum of 85 octane (85 AKI, 89 RON) is acceptable for elevations above 5,000 feet (1,500 meters).*
- *Gasoline with up to 10% ethanol is acceptable for use with this machine.*

ILLUSTRATED PARTS LIST

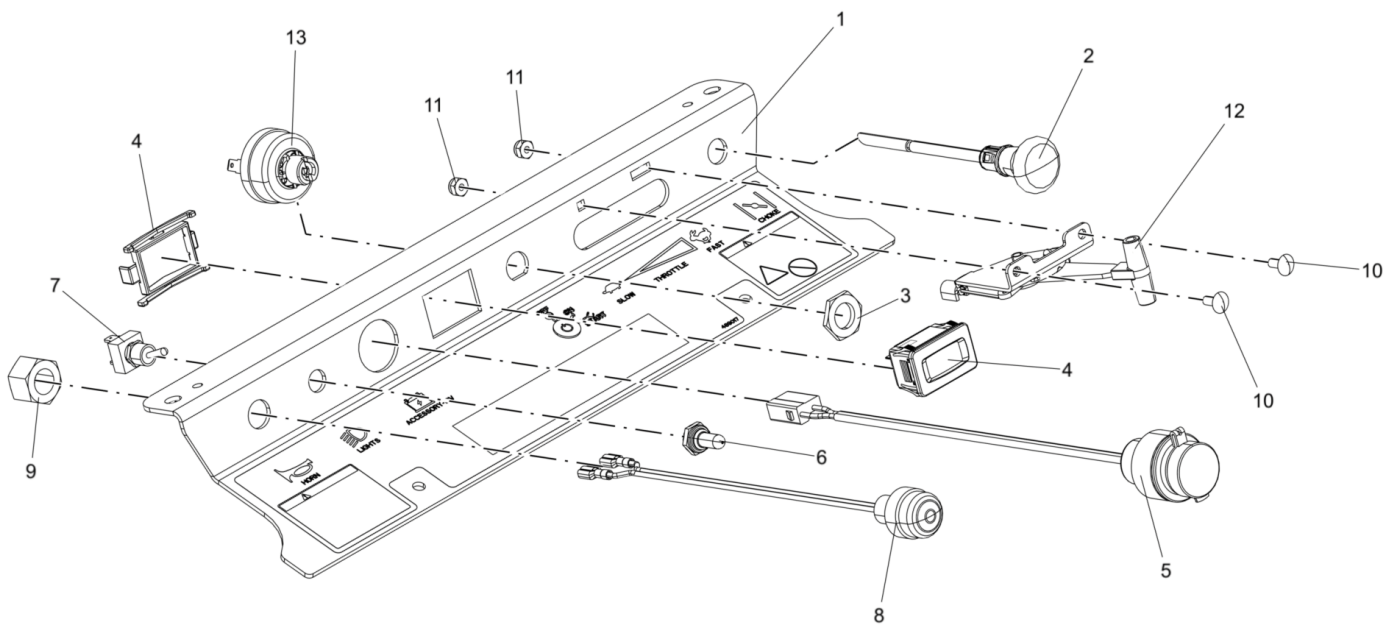
7.1 SCAG APPROVED ATTACHMENTS AND ACCESSORIES

Attachments and accessories manufactured by companies other than Scag Power Equipment or Metalcraft of Mayville must be approved for use on this machine by Scag Power Equipment. Any alterations or modifications made to the machine that change the performance, durability, or allow the use of unapproved attachments and accessories will not be covered by warranty.

<u>Accessories</u>	<u>P/N</u>	<u>Accessories</u>	<u>P/N</u>
<u>Attachments</u>		<u>Scag Premium Lubricants</u>	
Metal Hopper	9638	Chassis Grease	486257
		Hydraulic System Oil (1 QT)	486255
		Hydraulic System Oil (1 Gallon)	486254
		<u>Scag Touch-Up Paints</u>	
		Cat's Eye Gold (Bottle w/ Brush)	484540-01
		Cat's Eye Gold (Aerosol Spray Can)	48521
		Bluebird Blue (Bottle w/ Brush)	488696
		Bluebird Blue (Aerosol Spray Can)	488697
		Textured Black (Aerosol Spray Can)	486269

IPL LEGEND	
Abbrev.	Description
HH	Hex Head
SH	Socket Head
HWH	Hex Washer Head
HSH	Hex Socket Head
FLG	Flange
SERR	Serrated
ES	Elastic Stop
HD	Hardened
TT	Taptite
GR	Grade
NPT	Tapered Thread

CONTROL PANEL

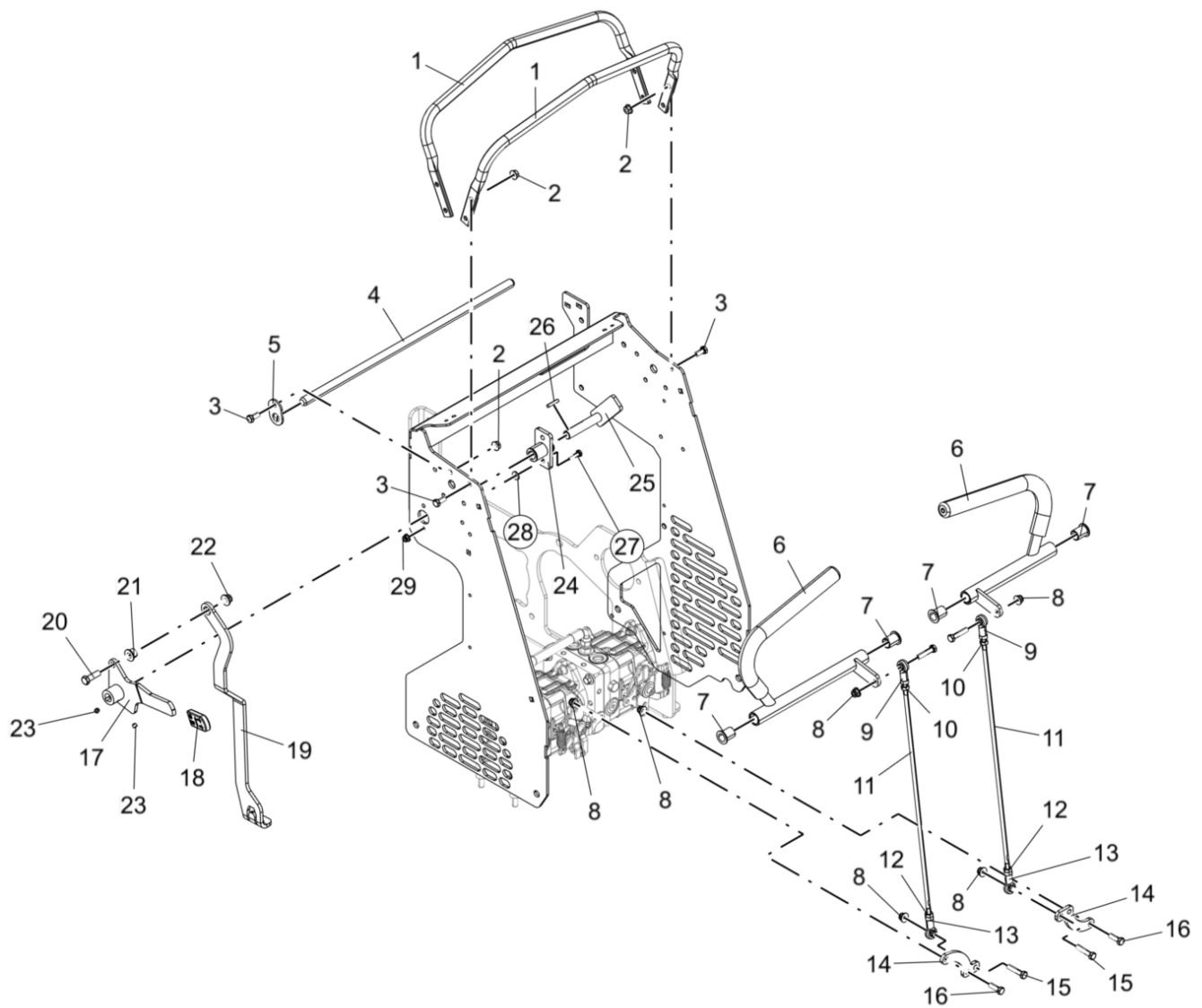


CONTROL PANEL

Ref. No.	Part No.	Description
1	463788	Instrument Panel w/ Decal (Scag Gold)
	463788-BB	Instrument Panel w/ Decal (Bluebird Blue)
2	483976	Choke Control
3	48017-04	Nut, 5/8-32 Special
4	484565	Inductive Hour Meter
5	485568	12V Power Plug
6	483121	Switch Boot
7	483120	Switch
8	488758	Momentary Switch
9	04020-43	Jam Nut, 5/8-18 UNF-2B
10	04003-43	Carriage Bolt, #10-24 x .50 LG
11	04021-26	Locknut, #10-24
12	483975	Throttle Control
13	48798	Starter Switch
*	462069	FOB Assembly w/ Key

* Item not shown.

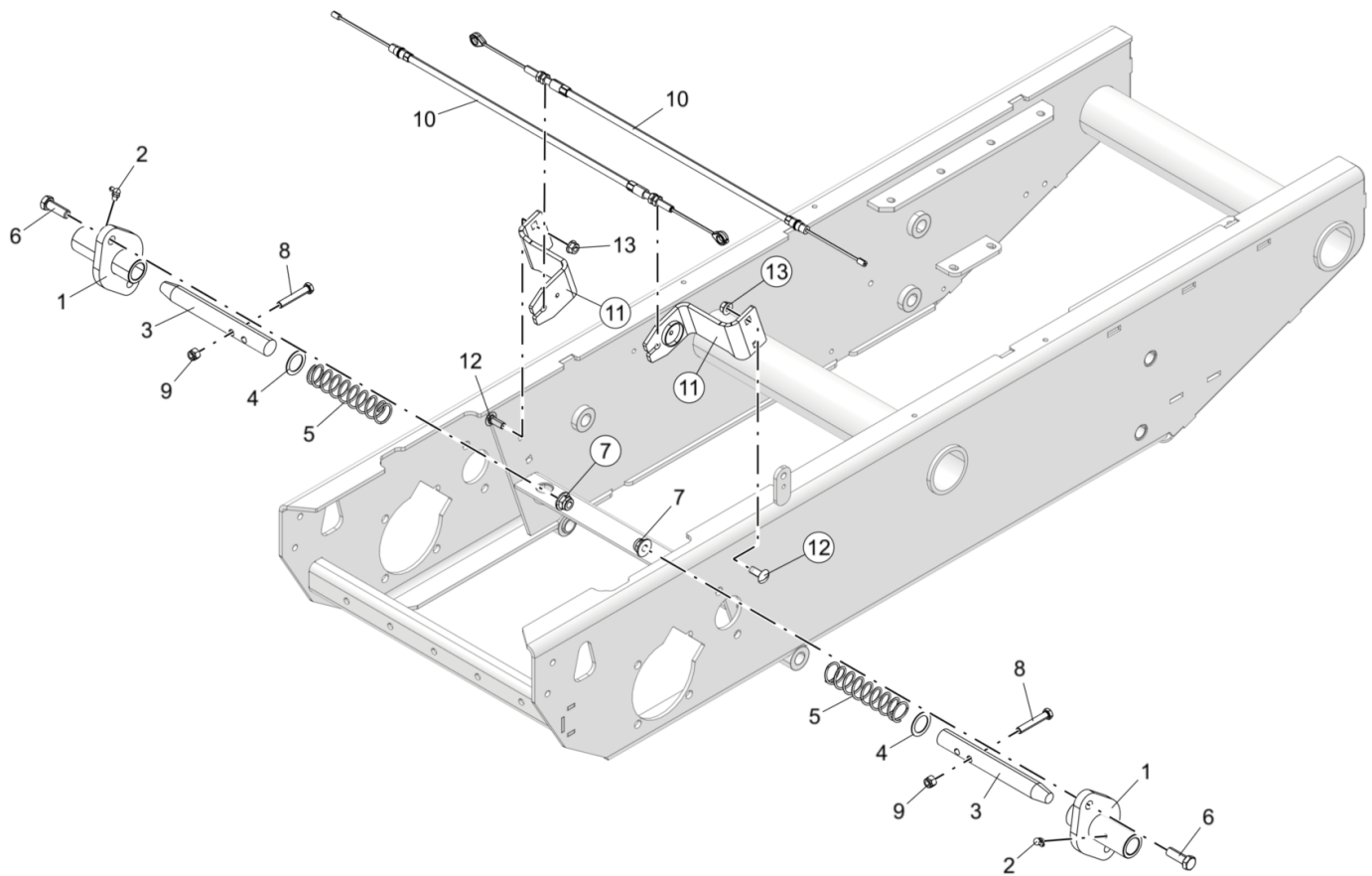
STEERING CONTROLS



STEERING CONTROLS

Ref. No.	Part No.	Description
1	427189	Reference Bar
2	04019-03	Nut, 5/16-18 SERR FLG
3	04001-08	Cap Screw, 5/16-18 x .75 HH
4	453850	Control Arm Shaft
5	4201684	Control Tab
6	463782	Handle Bar Assembly (LH)
	463783	Handle Bar Assembly (RH)
	484092	Grip, Control Lever
7	483453-14	Bearing, Plastic
8	04117-01	Locknut, 5/16-18 HH FLG ES
9	488903	Rod End, 5/16-24 (LH)
10	04020-30	Jam Nut, 5/16-24 UNF (LH)
11	488745	Steering Linkage (Incl. #9, #10, #11, #12, #13)
12	04020-31	Jam Nut, 5/16-24 UNF (RH)
13	488902	Rod End, 5/16-18 (RH)
14	4201395	Retention Arm
15	04001-11	Cap Screw, 5/16-18 x 1.50 HH
16	04001-09	Cap Screw, 5/16-18 x 1.00 HH
17	463864	Brake Lever w/ Grip
18	486696	Grip, Brake Lever
19	4201312	Linkage, Brake Engage
20	04001-32	Cap Screw, 3/8-16 x 1.25 HH
21	48100-30	Bushing, Bronze .376 ID x .627 OD
22	04117-02	Locknut, 3/8-16 HH FLG ES
23	04012-03	Setscrew, 5/16-18 x .25
24	463830	Plate, Pivot Mounting
25	453860	Plate, Neutral Lock
26	04063-17	Key, 3/16 x 3/16 x 1.00
27	04001-14	Cap Screw, 1/4-20 x 1.00 HH
28	04040-03	Washer, 1/4-.281 x .625 x .065 (ANSI Plain Type A)
29	04117-03	Locknut, 1/4-20 HH FLG ES

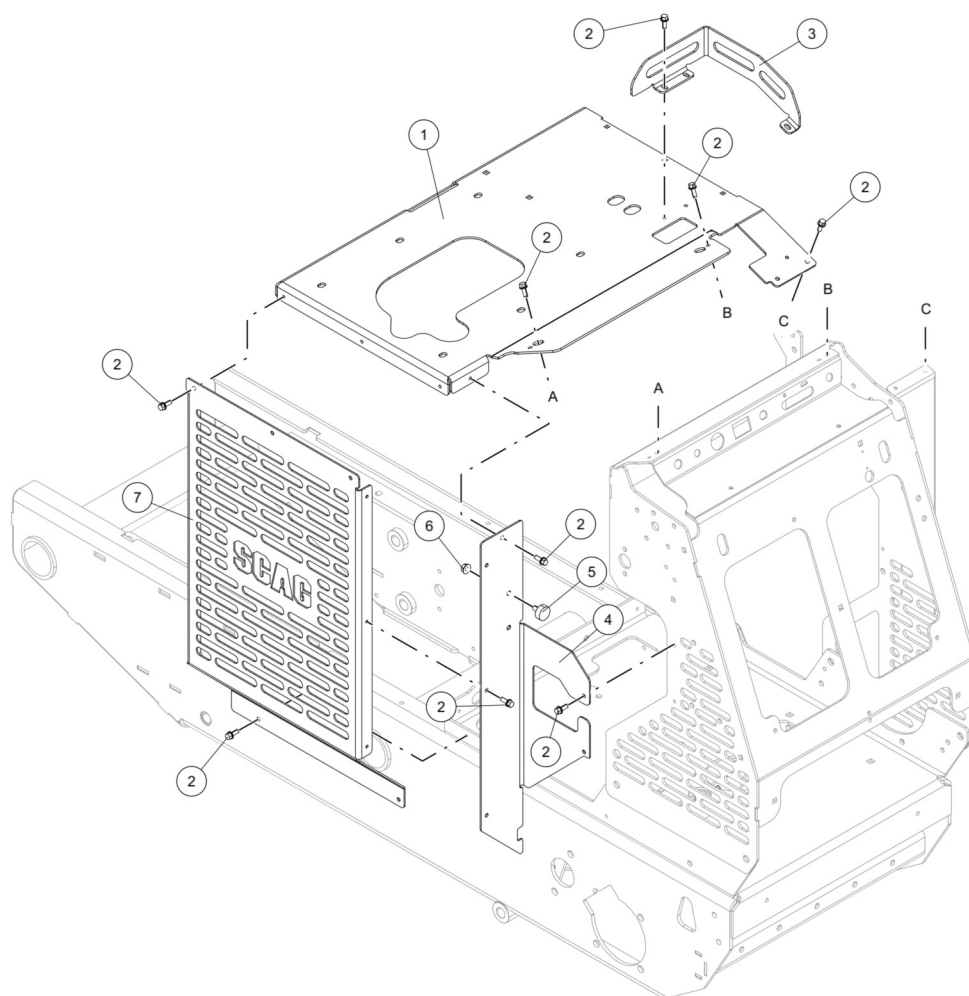
BRAKE SYSTEM



BRAKE SYSTEM

Ref. No.	Part No.	Description
1	453512	Brake Hub Weldment
2	48114-08	Grease Fitting
3	431407	Shaft, Brake
4	04041-14	Flat Washer, 1-1.062 x 1.50 x .0478
5	487644	Spring, Brake
6	04001-71	Cap Screw, 1/2-13 x 1.50 HH
7	04117-04	Locknut, 1/2-13 HH FLG ES
8	04001-46	Cap Screw, 3/8-16 x 2.25 HH
9	04021-09	Locknut, 3/8-16 ES
10	483341	Cable Assembly, Brake Cable
11	453837	Bracket, Brake Cable
12	04003-23	Carriage Bolt, 3/8-16 x 1.00
13	04019-04	Nut, 3/8-16 SERR FLG

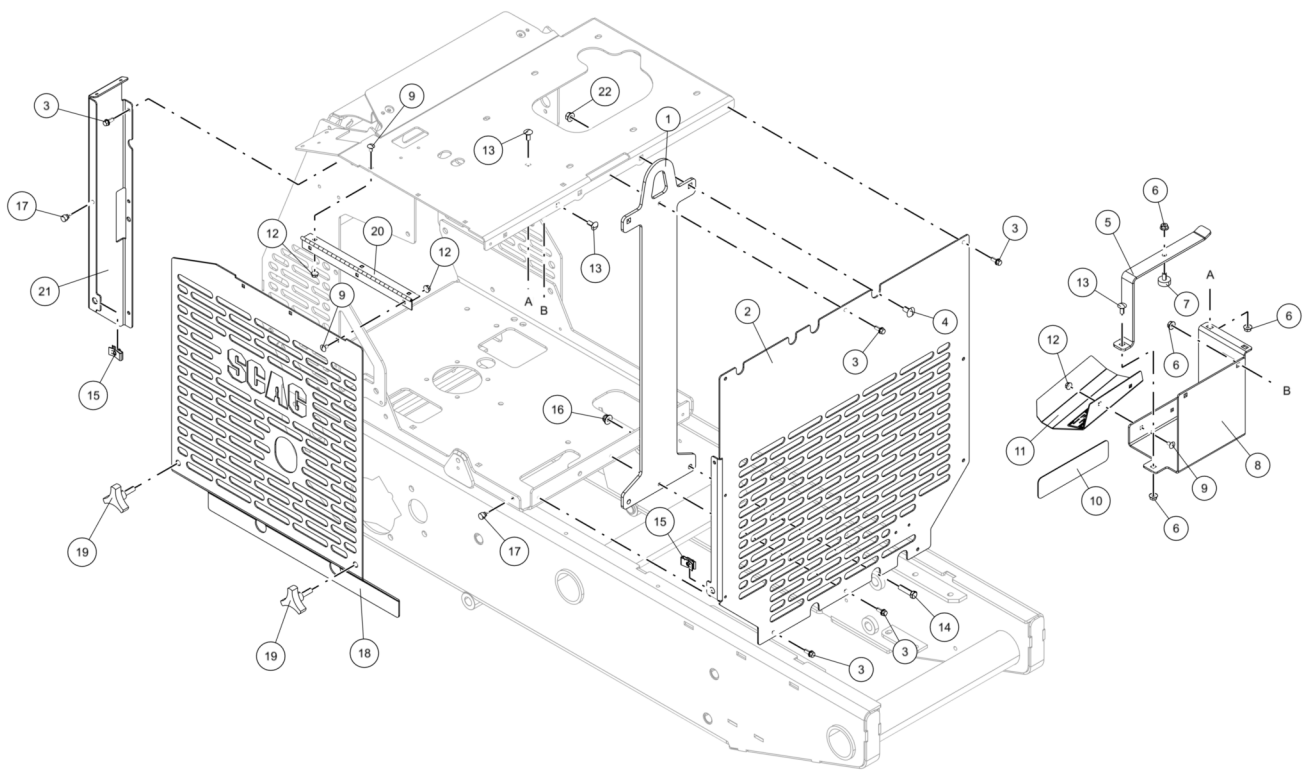
UPPER SHEET METAL COMPONENTS (LEFT)



UPPER SHEET METAL COMPONENTS (LEFT)

Ref. No.	Part No.	Description
1	463846	Top Guard w/ Decal (Scag Gold)
	463846-BB	Top Guard w/ Decal (Bluebird Blue)
2	04011-14	Screw, 1/4-20 x .75 TT
3	4201972	Guard, Controls
4	4201667	Engine Guard (Rear LH, Scag Gold)
	4201667-BB	Engine Guard (Rear LH, Bluebird Blue)
5	481284	Rubber Bumper
6	04019-03	Nut, 5/16-18 SERR FLG
7	4201260	Engine Guard (LH, Scag Gold)
	4201976	Engine Guard (LH, Bluebird Blue)

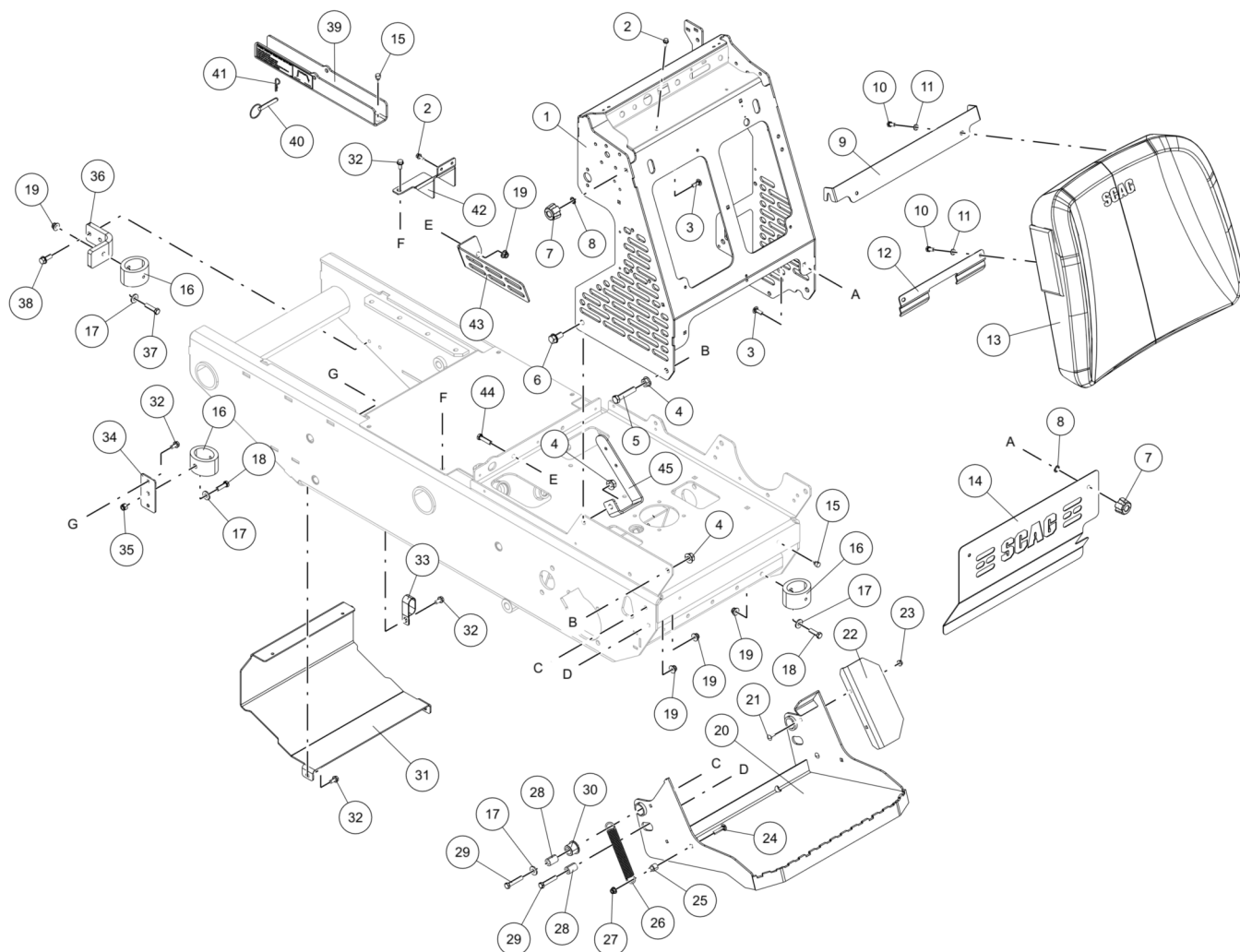
UPPER SHEET METAL COMPONENTS (RIGHT)



UPPER SHEET METAL COMPONENTS (RIGHT)

Ref. No.	Part No.	Description
1	4201554	Lift Bracket
2	4201259	Engine Guard (Front, Scag Gold)
	4201259-BB	Engine Guard (Front, Bluebird Blue)
3	04011-14	Screw, 1/4-20 x .75 TT
4	04003-31	Carriage Bolt, 3/8-16 x .75 RHSN
5	4201679	Strap, Battery Box
6	04019-03	Nut, 5/16-18 SERR FLG
7	481284	Rubber Bumper
8	4201538	Battery Tray
9	04003-07	Carriage Bolt, 1/4-20 x .50
10	483508	Battery Pad, Rubber
11	4201570	Drain Panel, Hydraulic Filter
12	04019-02	Nut, 1/4-20 SERR FLG
13	04003-12	Carriage Bolt, 5/16-18 x .75
14	04001-136	Cap Screw, 3/8-16 x 1.50 HH GR8
15	04110-03	U-Nut, 3/8-16
16	04117-02	Locknut, 3/8-16 HH FLG ES
17	485846	Bumper Plug
18	4201553	Engine Guard (RH, Scag Gold)
	4201977	Engine Guard (RH, Bluebird Blue)
19	481625-01	Knob w/ Stud
20	484143	Hinge, Belt Cover
21	463847	Engine Guard w/ Decal (Rear RH, Scag Gold)
	463847-BB	Engine Guard w/ Decal (Rear RH, Bluebird Blue)
22	04019-04	Nut, 3/8-16 SERR FLG

LOWER SHEET METAL COMPONENTS

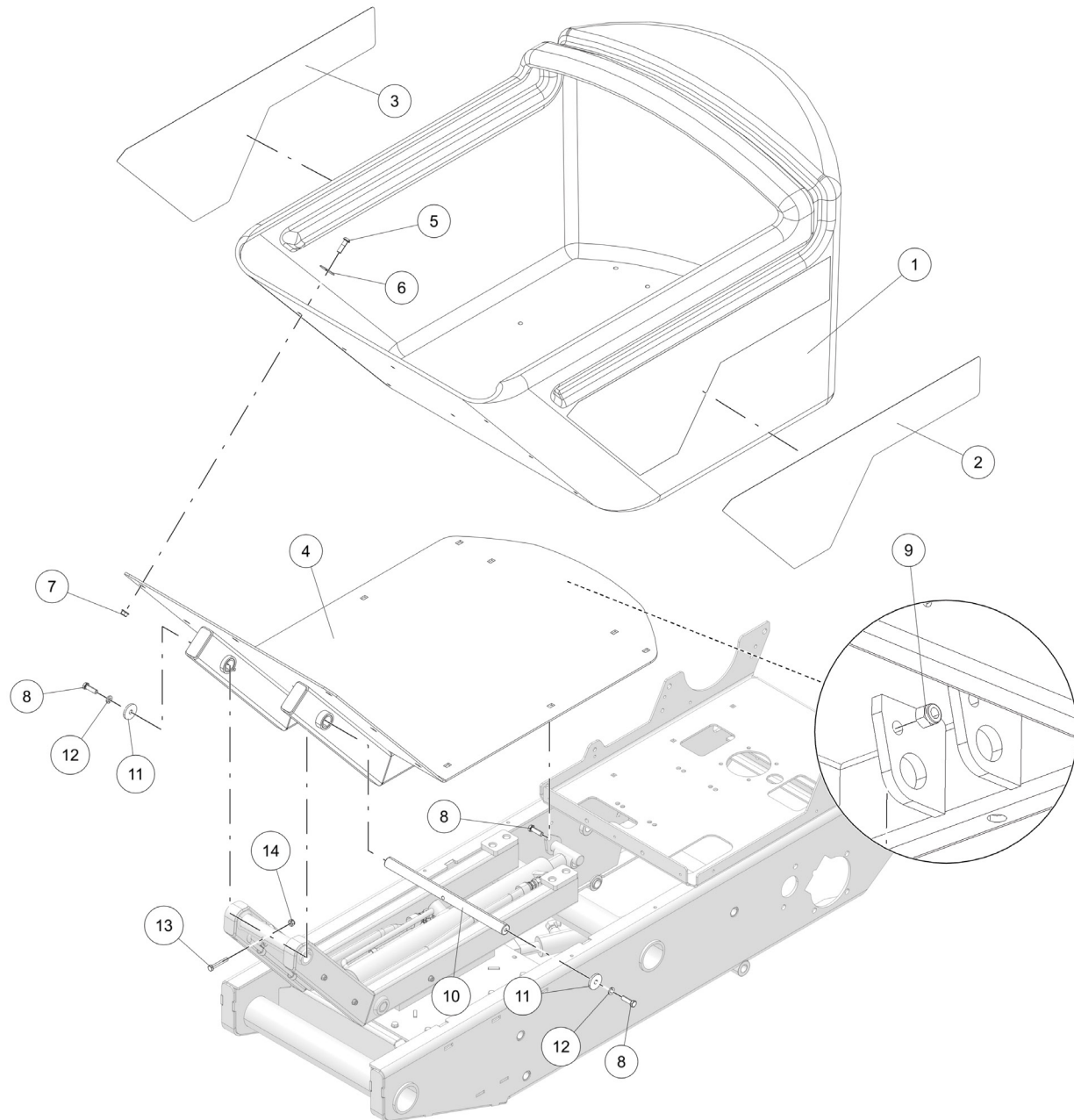


LOWER SHEET METAL COMPONENTS

Ref. No.	Part No.	Description
1	463854	Handlebar Tower w/ Decal (Scag Gold)
	463854-BB	Handlebar Tower w/ Decal (Bluebird Blue)
2	04011-14	Screw, 1/4-20 x .75 TT
3	04003-04	Carriage Bolt, 5/16-18 x 1.00
4	04112-05	Spiral Locknut, 1/2-13
5	04001-52	Cap Screw, 1/2-13 x 2.50 HH
6	04017-36	Cap Screw, 1/2-13 x 1.00 SERR FLG HH
7	481885-06	Fluted Knob, 5/16-18
8	04024-03	Nut, Push-On
9	427289	Bracket, Operator Pad
10	04001-08	Cap Screw, 5/16-18 x .75 HH
11	04030-03	Spring Lock Washer, 5/16
12	4201727	Bracket, Kneepad
13	463840	Operator Pad Assembly (Incl. #9, 10, 11, 12)
14	4201303	Foot Guard (Scag Gold)
	4201978	Foot Guard (Bluebird Blue)
15	485846	Bumper Plug
16	486758	Isolator
17	04041-07	Flat Washer, 3/8-.391 x .938 x .105
18	04001-32	Cap Screw, 3/8-16 x 1.25 HH
19	04117-02	Locknut, 3/8-16 HH FLG ES
20	463797	Footplate Assembly (Scag Gold)
	463797-BB	Footplate Assembly (Bluebird Blue)
		(Incl. #21, 22, 23, 24, 25, 27, 30)
21	04003-02	Carriage Bolt, 1/4-20 x .75
22	4201974	Fender
23	04019-02	Nut, 1/4-20 SERR FLG
24	04003-38	Carriage Bolt, 5/16-18 x 1.50
25	43602	Spacer

Ref. No.	Part No.	Description
26	48755	Spring, Operator Platform
27	04117-01	Locknut, 5/16-18 FLG HH ES
28	43572	Spacer, Lift Spring
29	04001-45	Cap Screw, 3/8-16 x 2.00 HH
30	486834	Bearing, Pivot
31	4201568	Front Shield
32	04011-12	Screw, 5/16-18 x .75
33	48030-18	Clamp, Cable
34	4202009	Guard, Hydraulic Fitting
35	04021-09	Locknut, 3/8-16 ES
36	4201811	Mount, Rotation Isolator
37	04001-20	Cap Screw, 3/8-16 x 1.50 HH
38	04011-22	Screw, 3/8-16 x 1.00 HH TT
39	463841	Cylinder Lock Support (Incl. #15, 40, 41)
40	04067-13	Ring Pin
41	04062-01	Cotter Pin
42	4202002	Guard, Hydraulic Fitting
43	4202048	Bracket, Hose Guard (Front)
44	04001-136	Cap Screw, 3/8-16 x 1.50 HH GR 8
45	4202047	Bracket, Hose Guard (Rear)

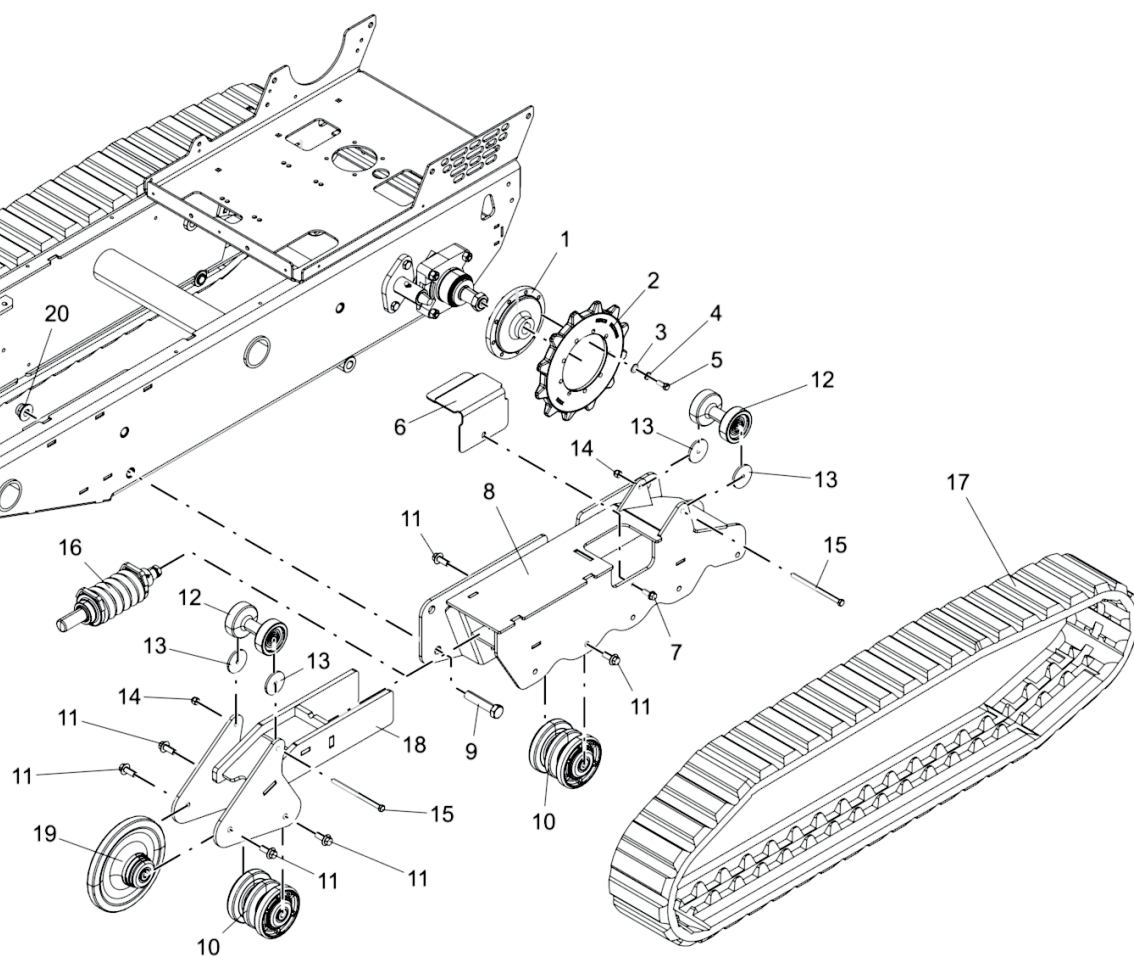
HOPPER ASSEMBLY



HOPPER ASSEMBLY

Ref. No.	Part No.	Description
1	463786	Plastic Hopper w/ Decals (Incl. #2, #3)
2	488879	Decal, Hopper (LH, Scag)
	488996	Decal, Hopper (LH, Bluebird)
3	488880	Decal, Hopper (RH, Scag)
	488997	Decal, Hopper (RH, Bluebird)
4	463839	Hopper Base w/ Bushings
5	04003-23	Carriage Bolt, 3/8-16 x 1.00
6	04041-12	Flat Washer, 3/8-.375 x 1.50 x .0598
7	04019-04	Nut, 3/8-16 SERR FLG
8	04001-32	Cap Screw, 3/8-16 x 1.25 HH
9	04021-09	Locknut, 3/8-16 ES
10	431431	Pin, Pivot
11	04041-11	Flat Washer, 3/8-.406 x 1.50 x .1793
12	04030-04	Lock Washer, 3/8 (ANSI Helical Spring)
13	04001-17	Cap Screw, 5/16-18 x 2.00 HH
14	04021-10	Locknut, 5/16-18 ES

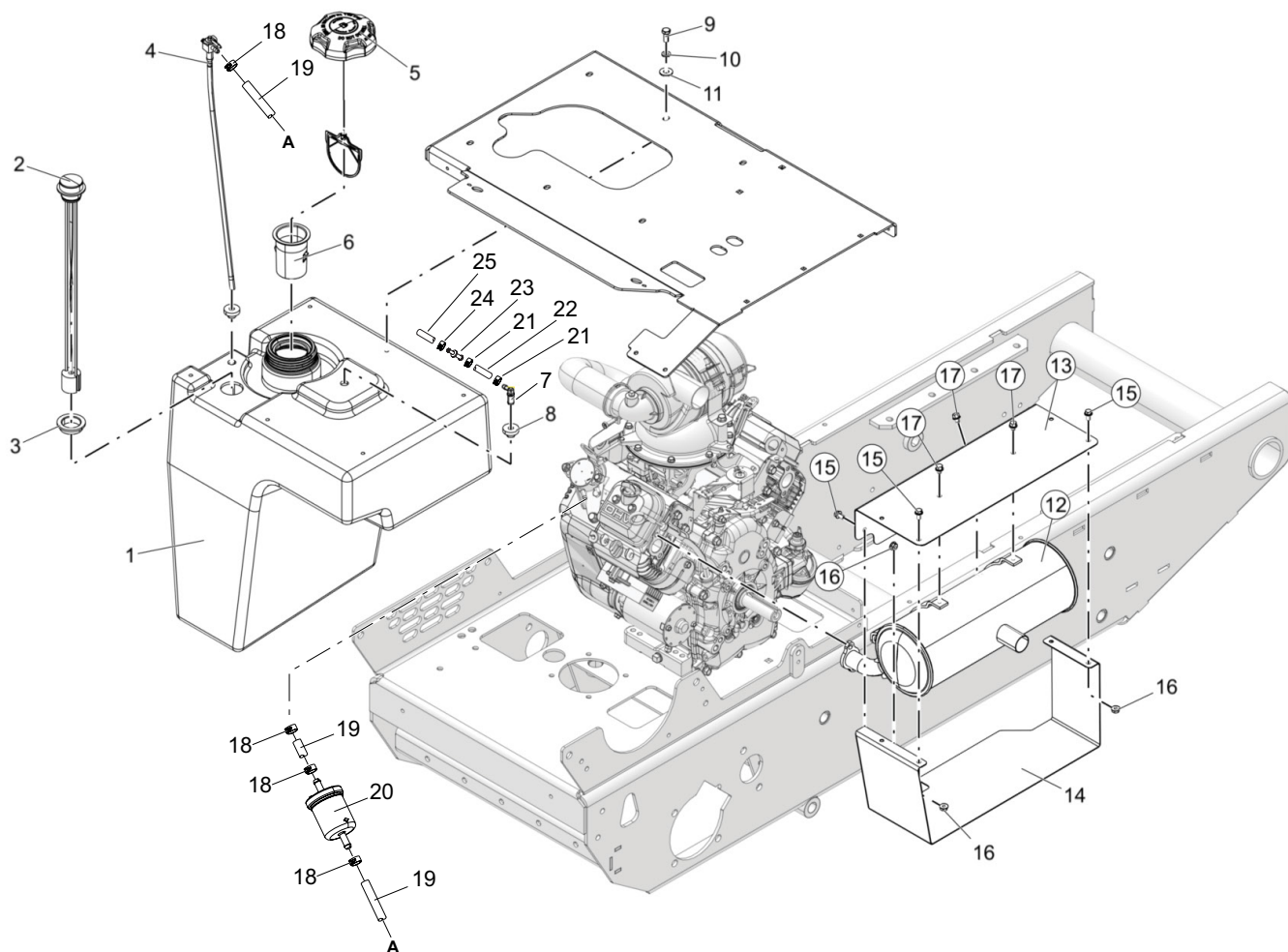
TRACK ASSEMBLY



TRACK ASSEMBLY

Ref. No.	Part No.	Description
1	431207	Sprocket Flange
2	487583	Track Sprocket
3	04040-05	Washer, 3/8-.406 x .812 x .065 (ANSI Plain Type A)
4	04030-04	Spring Lock Washer, 3/8 (ANSI Helical Spring)
5	04001-19	Cap Screw, 3/8-16 x 1.00 HH
6	4201362	Cover, Track Carriage
7	04011-22	Screw, 3/8-16 x 1.00 HH TT
8	453717	Track Carriage (LH)
	453718	Track Carriage (RH)
9	04001-241	Cap Screw, 3/4-10 x 3.50 HH
10	431341	Roller, Track
11	04018-06	Cap Screw, Metric HH SERR FLG
12	463774	Roller, Track Idler
13	04041-38	Flat Washer, 3/6-.406 x 2.25 x .1875
14	04021-09	Locknut, 3/8-16 ES
15	04001-100	Cap Screw, 3/8-16 x 6.00 HH
16	488257	Track Tensioner Assembly
17	488739	Track, 7"
18	453752	Track Tensioner Weldment
19	487559	Track Idler
20	04117-08	Locknut, 3/4-10 HH FLG ES

FUEL SYSTEM AND ENGINE EXHAUST

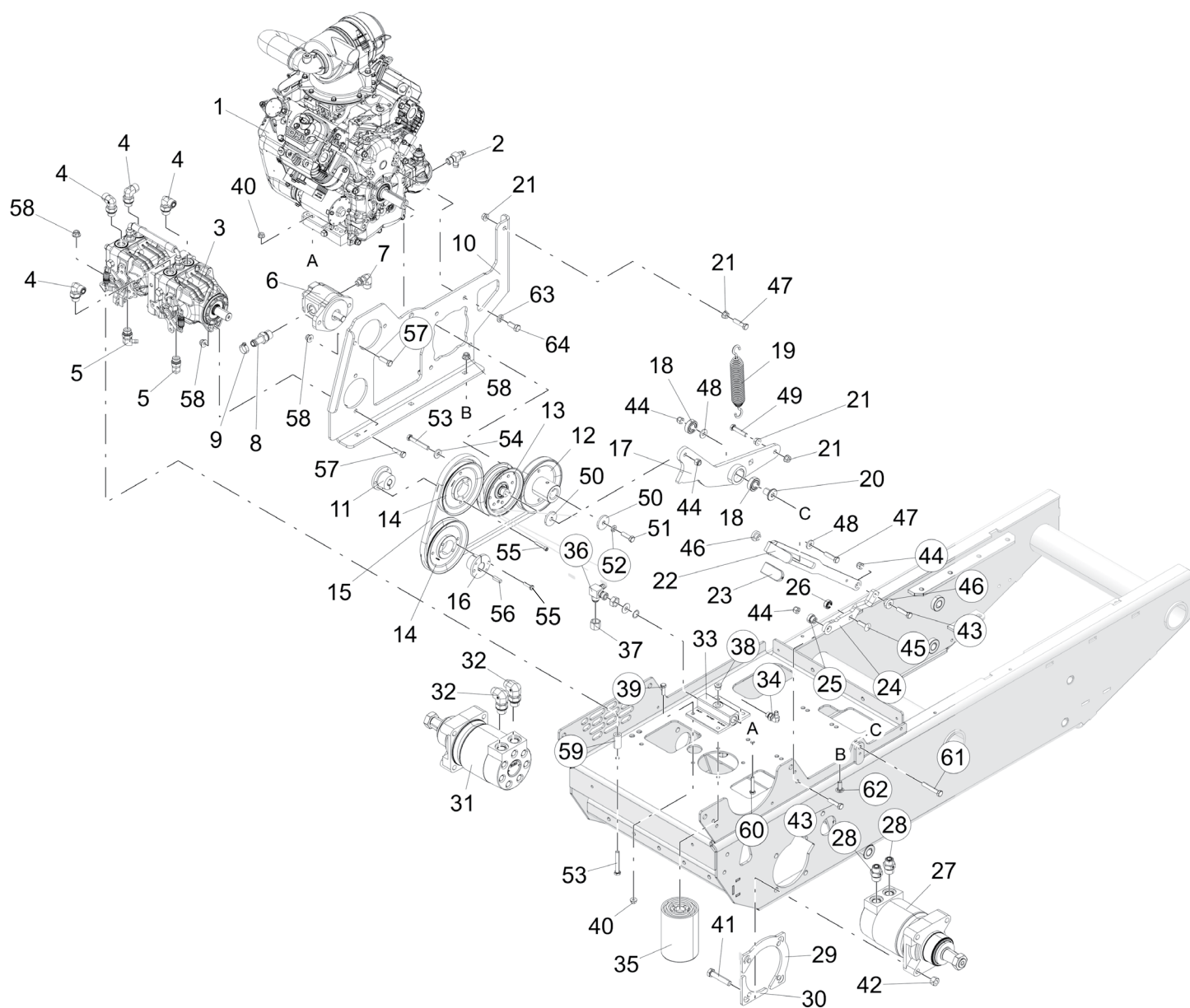


FUEL SYSTEM AND ENGINE EXHAUST

Ref. No.	Part No.	Description
1	463785	Fuel Tank Assembly (Incl. #2, #3, #4, #9, #10)
2	484246	Fuel Gauge
3	484242	Seal, Fuel Gauge
4	483896	Valve, Fuel Shutoff w/ Pickup Line
5	484286	Fuel Cap w/ Tether
6	484279-03	Tube, Fuel Inlet
7	486852	Remote Vent
8	482571	Bushing
9	04001-08	Cap Screw, 5/16-18 x .75 HH
10	04030-03	Spring Lock Washer, 5/16 (ANSI Helical Spring)
11	04040-15	Flat Washer, 5/16-.375 x .875 x .083 (ANSI Plain Type A)
12	488748	Exhaust, Briggs & Stratton 23BH
13	4201540	Heat Shield, Exhaust (Upper)
14	4201581	Heat Shield, Exhaust (Lower)
15	04017-04	Cap Screw, 1/4-20 x .50 HH SERR FLG
16	04019-02	Nut, 1/4-20 SERR FLG
17	04011-29	Screw, 1/4-20 x .375
18	48059-01	Clamp, Fuel Hose (1/4")
19	483617	Fuel Hose, 1/4" (Order by Inch)
20	*	Fuel Filter
21	48059-02	Clamp, Fuel Hose (7/32")
22	484347	Vapor Recovery Hose, 1/4" (Order by Inch)
23	48059-05	Mender, 1/4 x 3/16 w/ .020 Hole
24	484343-01	Clamp, Vapor Recovery (3/16")
25	484345	Vapor Recovery Hose, 3/16" (Order by Inch)

* Not available through Scag Power Equipment.

DRIVE SYSTEM (ENGINE, PUMPS, AND MOTORS)



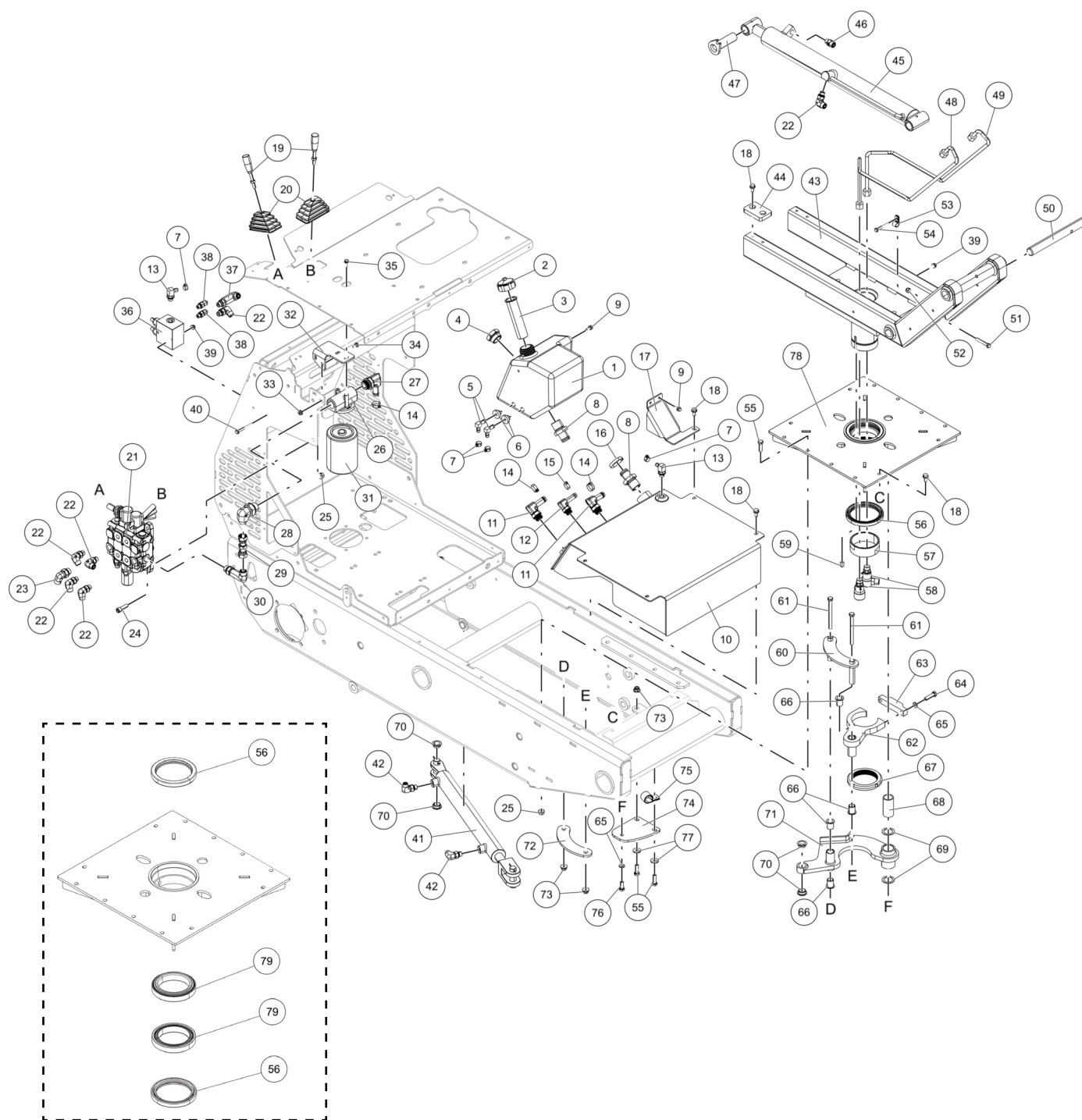
DRIVE SYSTEM (ENGINE, PUMPS, AND MOTORS)

Ref. No.	Part No.	Description
1	*	Engine, Briggs & Stratton 23BV (386447-3358-G1)
	*	Oil Filter
	*	Air Cleaner
2	482354	Oil Drain, 2.3"
3	488910	Hydro-Gear™ 16cc Tandem Pump
4	487734-21	Fitting, ORFS 90° (8 C50L0)
5	482266-02	Fitting, O-Ring Barb
6	488741	Gear Pump
7	487734-04	Fitting, ORFS 90° (8-6 C50L0)
8	487467-05	Connector, O-Ring
9	48136-16	Clamp, Hose (1.00" Max Diameter)
10	4201445	Mounting Plate, Pump
11	488906	Tapered Hub, .625 ID
12	488609	Pulley, 5.75 (1.00 Bore)
13	483213	Idler Pulley, 4.5
14	482744	Pulley, 5.75 OD (Tapered Bore)
15	488866	Belt, Pump Drive
16	488911	Tapered Hub, .875 ID
17	463800	Idler Arm w/ Bearings
18	48224	Bearing, Jackshaft
19	483112	Spring
20	43689	Pivot, Idler
21	04019-04	Nut, 3/8-16 SERR FLG
22	463845	Declutch Lever w/ Grip (Incl. #23)
23	487854	Grip, .25 x 1.00 x 2.50
24	4201720	Lever, Declutch
25	431028	Spacer
26	484035	Bearing, .375" Bore x .875 OD
27	488747	Drive Motor (RH)
28	487734-13	Fitting, ORFS Straight (8-10 F50L0)
29	4201251	Plate, Motor Backing (Primary)
30	4201252	Plate, Motor Backing (Secondary)
31	488746	Drive Motor (LH)
32	487734-34	Fitting, ORFS 90° (8-10 C50L0)
33	482417	Filter Head Assembly
34	482266-01	Fitting, O-Ring Barb
35	48758	Filter, Hydraulic Oil
36	482539	Tee, 3/4 O-Ring x JIC x 1/2 Hose
37	48571-02	Cap, JIC
38	487844-03	Plug, SAE-6

Ref. No.	Part No.	Description
39	04001-09	Cap Screw, 5/16-18 x 1.00 HH
40	04019-03	Nut, 5/16-18 SERR FLG
41	04001-52	Cap Screw, 1/2-13 x 2.50 HH
42	04021-19	Locknut, 1/2-13 (Center Lock)
43	04001-20	Cap Screw, 3/8-16 x 1.50 HH
44	04021-09	Locknut, 3/8-16 ES
45	04003-11	Carriage Bolt, 3/8-16 x 1.25
46	43086	Bushing, Decutch Lever (SPD ADJ)
47	04001-136	Cap Screw, 3/8-16 x 1.50 HH
48	04041-07	Flat Washer, 3/8-.391 x .938 x .105
49	04001-21	Cap Screw, 3/8-16 x 1.75 HH
50	04041-11	Flat Washer, 3/8-.406 x 1.50 x .1793
51	04001-60	Cap Screw, 3/8-24 x 1.25 HH
52	04030-04	Lock Washer, 3/8 (ANSI Helical Spring)
53	04001-31	Cap Screw, 3/8-16 x 2.50 HH
54	04043-04	Flat Washer, 3/8-.391 x .938 x .105 HD
55	04015-47	Cap Screw, 1/4-20 UNC x 1.25 SH
56	04063-20	Key, 1/4 x 1/4 x 1.00
57	04001-32	Cap Screw, 3/8-16 x 1.25 HH
58	04117-02	Locknut, 3/8-16 HH FLG ES
59	43805	Spacer
60	04001-12	Cap Screw, 5/16-18 x 1.75 HH
61	04001-46	Cap Screw, 3/8-16 x 2.25 HH
62	04003-23	Carriage Bolt, 3/8-16 x 1.00
63	04030-05	Lock Washer, 7/16 (ANSI Helical Spring)
64	04001-27	Cap Screw, 7/16-14 x 1.00 HH
65	488999-02	Fitting, ORFS to ORFS 90° (8 C6LO-S)

* Not available through Scag Power Equipment.

HYDRAULIC SYSTEM (LIFT & TILT)



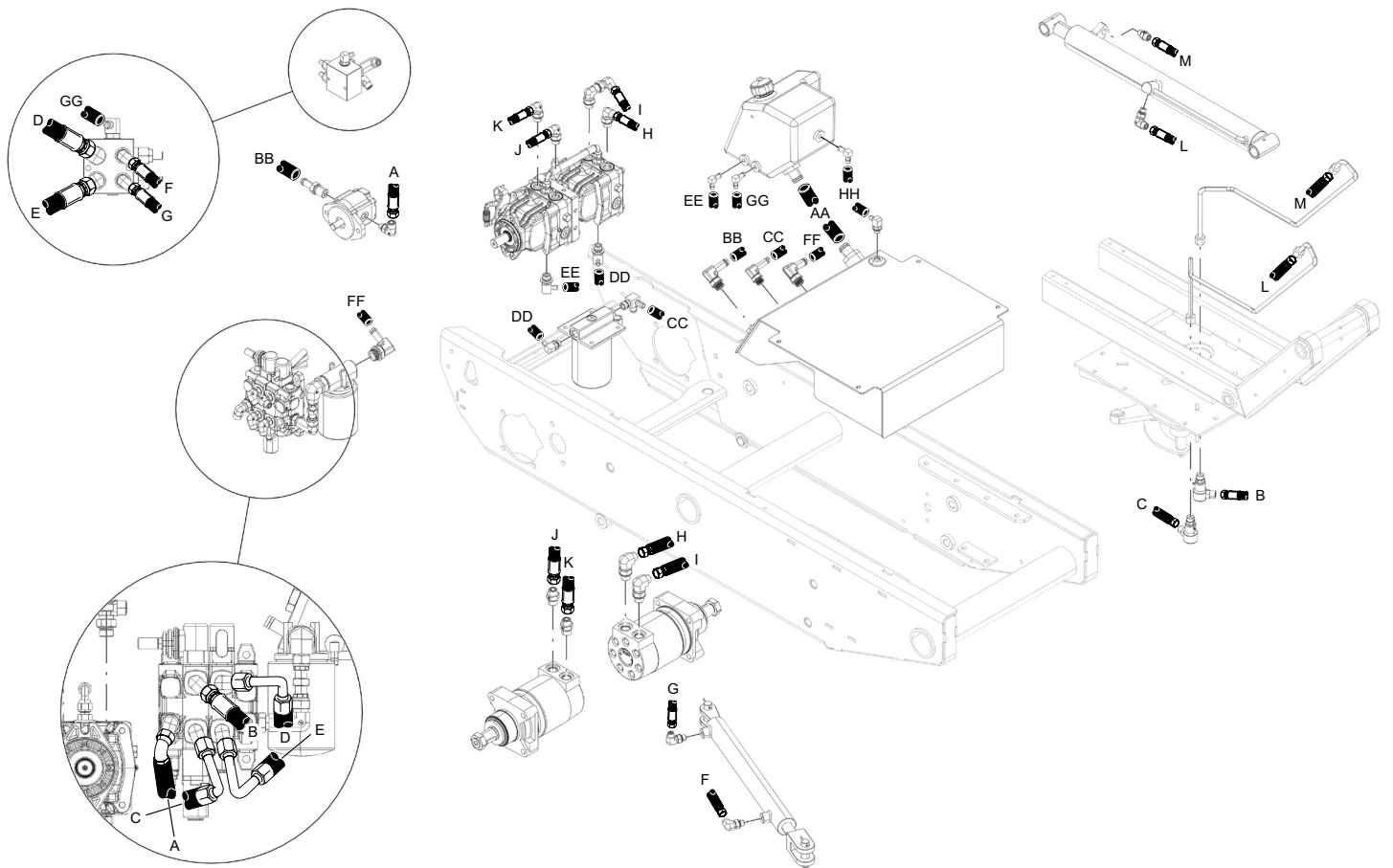
* Ref. No. 78

HYDRAULIC SYSTEM (LIFT & TILT)

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	463887	Hydraulic Tank Assembly (Incl. 2, 3, 4, 5, 6, 8)	40	04001-206	Cap Screw, 1/4-20 x 2.50 HH
2	481164	Cap, Hydraulic Tank	41	488591	Cylinder, 1.5" x 14"
3	481507	Filler Neck Insert	42	487734-40	Fitting, ORFS 90° (4-6 C50L0)
4	487745	Sight Glass w/ Reflector, SAE 16	43	453823	Rotator Weldment
5	482572	Fitting, 90°	44	488664	Rest, Bucket Rotator
6	482571	Bushing, .59" Viton	45	488590	Cylinder, 2" x 20"
7	48136-13	Clamp, Hose (.69" Max Diameter)	46	487734-09	Fitting, ORFS Straight (6 F50L0)
8	481467-07	Connector, O-Ring to Hose Barb	47	488977	Pin Weldment, Cylinder
9	04011-14	Screw, 1/4-20 x .75 TT	48	488847	Tube, Hydraulic (RH)
10	463843	Hydraulic Tank Assembly (Incl. 11, 12, 8, 13)	49	488846	Tube, Hydraulic (LH)
11	482266-06	Elbow, 90° O-Ring Barb	50	431201-23	Pin, Pivot
12	482266-10	Elbow, 90° O-Ring Barb	51	04001-17	Cap Screw, 5/16-18 x 2.00
13	482266-01	Elbow, 90° O-Ring Barb	52	04021-10	Locknut, 5/16-18 ES
14	48136-16	Clamp, Hose (1.00" Max Diameter)	53	48030-09	Clamp, Cable
15	48136-05	Clamp, Hose (.87" Max Diameter)	54	04001-03	Cap Screw, 1/4-20 x 2.00 HH
16	48136-14	Clamp, Hose (1.75" Max Diameter)	55	04001-32	Cap Screw, 3/8-16 x 1.25 HH
17	4202002	Guard, Fitting	56	488603	Seal, Lip
18	04011-12	Screw, 5/16-18 x .75 HWH Shockproof	57	431376	Debris Shield, Rotator
19	489023	Lever, Valve	58	488848	Fitting, Swivel
20	488852	Boot, Handle	59	04063-45	Key, 5/16 x 5/16 x .625
21	488744	Control Valve, Dual	60	453879	Link, Rotator Transfer
22	487734-02	Fitting, ORFS 90° (6 C50L0)	61	04001-152	Cap Screw, 3/8-16 x 4.25 HH
23	487734-21	Fitting, ORFS 90° (8 C50L0)	62	463799	Rotator Arm (Incl. 66)
24	04015-46	Cap Screw, 3/8-16 UNC x 1.25 SH	63	4201356	Cap, Rotator Arm
25	04019-04	Nut, 3/8-16 SERR FLG	64	04001-136	Cap Screw, 3/8-16 x 1.50 HH GR 8
26	488751	Filter Assembly (Incl. 31)	65	04030-04	Lock Washer, 3/8 ANSI Helical Spring
	488802	Filter Head	66	483453-14	Bearing, Plastic
27	482266-11	Elbow, 90° O-Ring Barb	67	488749	Locking Nut, Spanner
28	487734-42	Fitting, ORFS 90° (8-12 C50L0)	68	487564-11	Bushing, Fiber
29	488999-01	Fitting, ORFS to ORFS Straight (8 HL6-S)	69	04041-14	Flat Washer 1-1.062 x 1.50 x .0478
30	489000-01	Fitting, ORFS LG to SAE-ORB (8 CC50L0)	70	483453-34	Bearing, Plastic
31	488803	Hydraulic Filter	71	463801	Link, Rotator Input (Incl. 66, 68, 70)
32	4201021	Mount, Oil Filter	72	4201836	Link, Rotator Transfer
33	04019-02	Nut, 1/4-20 SERR FLG	73	04117-02	Locknut, 3/8-16 FLG HH ES
34	04003-02	Carriage Bolt, 1/4-20 x .75	74	4201815	Plate, Anchor
35	04017-05	Cap Screw, 1/4-20 x .75 HH SERR FLG	75	48030-24	Clamp, Cable
36	488969	Flow Regulator	76	04001-229	Cap Screw, 3/8-16 x 1.00 HH GR 8
37	489000-02	Fitting, ORFS LG to SAE-ORB (6 CC50L0)	77	04041-07	Flat Washer, 3/8-.391 x .938 x .105
38	487734-01	Fitting, ORFS 90° (4 C50L0)	78	463798	Rotator Pivot Assembly (Incl. 56, 79)
39	04117-03	Locknut, 1/4-20 FLH HH ES	79	488599	Bearing w/ Race (110x80mm)

* Item not shown.

HYDRAULIC HOSES

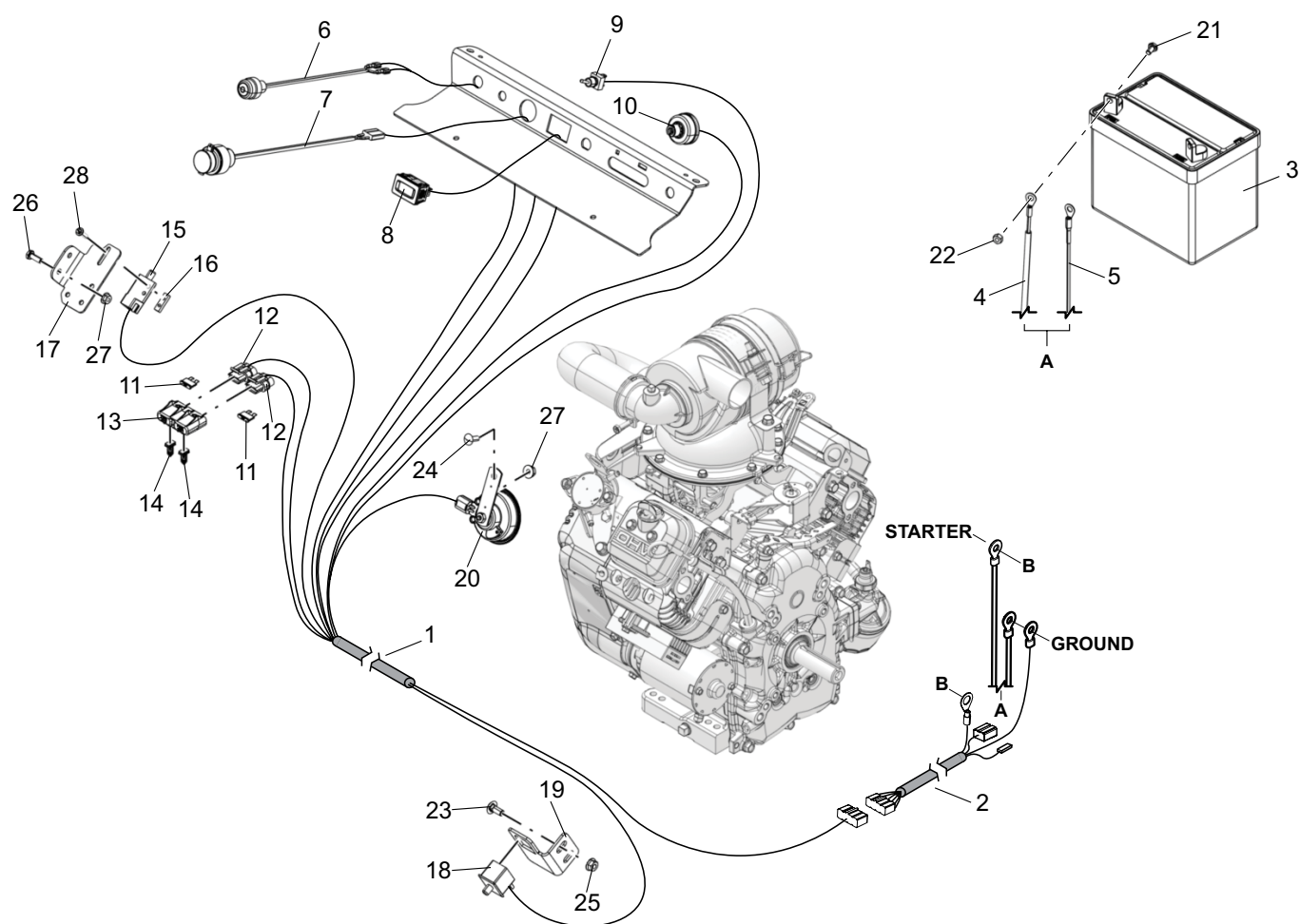


HYDRAULIC HOSES

Ref. No.	Part No.	Description
A	489054	Hose Assembly, Valve
B	488974	Hose Assembly, Rear Swivel
C	488973	Hose Assembly, Swivel
D	488614	Hose Assembly, Flow Control
E	488614	Hose Assembly, Flow Control
F	488972	Hose Assembly, Rotator Front
G	488971	Hose Assembly, Rotator Rear
H	489142	Hose Assembly, Pump
I	489143	Hose Assembly, Pump
J	489142	Hose Assembly, Pump
K	489143	Hose Assembly, Pump
L	489022	Hose Assembly, Tilt Cylinder
M	489021	Hose Assembly, Dump Cylinder
AA*	489007	Hose, Hydraulic Reservoir Link (23")
	48136-14	Clamp, Hose (1.75" Max Diameter)
BB*	48504	Hose, 5/8" Pushlock (58")
	48136-16	Clamp, Hose (1.00" Max Diameter)
CC*	48351	Hose, 1/2" Pushlock (21.50")
	48136-05	Clamp, Hose (.87" Max Diameter)
DD*	48811	Hose, 3/8" Pushlock (14")
	48136-13	Clamp, Hose (.69" Max Diameter)
EE*	48811	Hose, 3/8" Pushlock (20")
	48136-13	Clamp, Hose (.69" Max Diameter)
FF*	48504	Hose, 5/8" Pushlock (22")
	48136-16	Clamp, Hose (1.00" Max Diameter)
GG*	48811	Hose, 3/8" Pushlock (16")
	48136-13	Clamp, Hose (.69" Max Diameter)
HH*	48811	Hose, 3/8" Pushlock (N/A)
	48136-13	Clamp, Hose (.69" Max Diameter)

* Order by inch.

ELECTRICAL SYSTEM



ELECTRICAL SYSTEM

Ref. No.	Part No.	Description
1	488750	Wire Harness
2	487609	Harness Adapter, Briggs & Stratton 23BH
3	*	Battery (12V, 350 CCA)
4	48029-12	Battery Cable, Red (36")
5	48029-57	Battery Cable, Black (44")
6	488758	Momentary Switch
7	485568	12V Power Plug
8	484565	Inductive Hour Meter
9	483120	Switch
10	48798	Starter Switch
11	48298	Fuse, 20 Amp
12	483629	Fuse Holder
13	483571	Fuse Cover, Double
14	482588	Clip, Wire
15	481545	Switch, Interlock
16	422373	Plate, Threaded
17	427269	Bracket, Neutral Switch
18	483473	Switch, Double Pole
19	4201248	Bracket, Operator Presence
20	488759	Horn, Electric
21	04001-44	Cap Screw, 1/4-20 x .50 HH
22	04020-02	Nut, 1/4-20 UNC
23	04003-12	Carriage Bolt, 5/16-18 x .75
24	04003-02	Carriage Bolt, 1/4-20 x .75
25	04019-03	Nut, 5/16-18 SERR FLG
26	04001-01	Cap Screw, 1/4-20 x .75 HH
27	04019-02	Nut, 1/4-20 SERR FLG
28	04010-12	Screw, #10-32 x .75 HH Washer

* Not available through Scag Power Equipment.

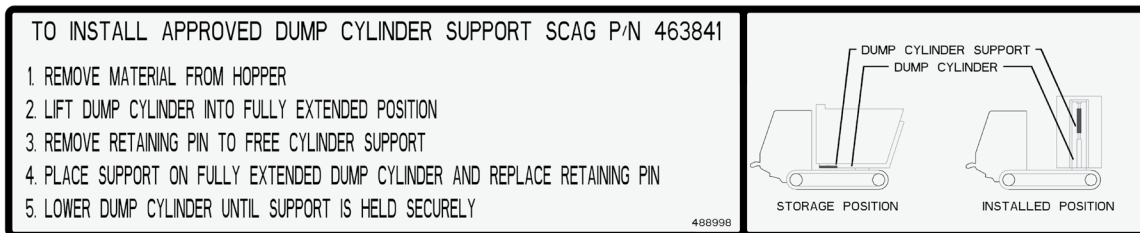
REPLACEMENT DECALS



1 - 489017



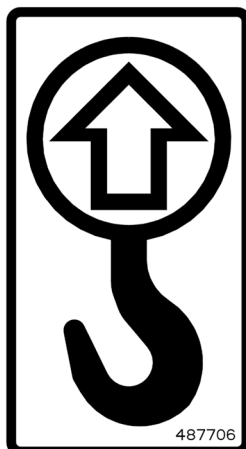
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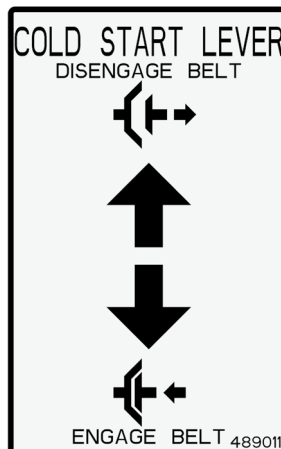
3 - 488988



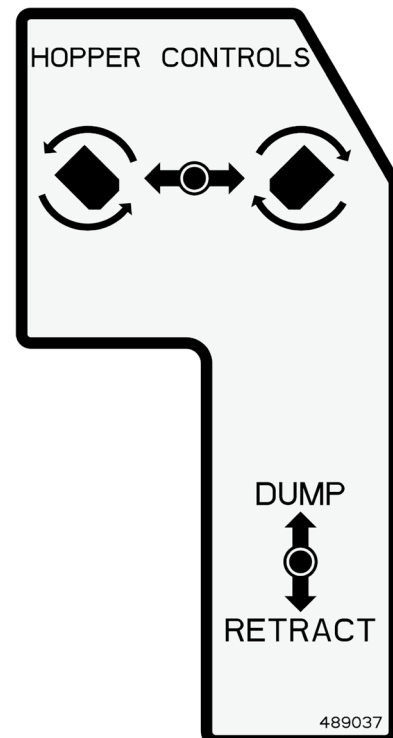
4 - 484591



5 - 487706



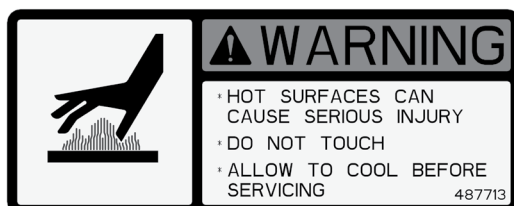
6 - 489011



7 - 489037

REPLACEMENT DECALS

Ref. No.	Part No.	Description
1	489017	Decal, Instrument Panel
2	489018	Decal, Warning
3	488998	Decal, Dump Cylinder Support
4	484591	Decal, Pinch Warning
5	487706	Decal, Lift Point
6	489011	Decal, Clutch Lever
7	489037	Decal, Hopper Controls
8	487713	Decal, Hot Muffler
9	483402	Decal, Belt Cover
10	481099	Decal, Spring Loaded Idler
11	489124	Decal, Hopper Danger
12	489125	Decal, Crush Hazard
13	485667	Decal, Fuel Tank



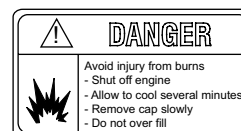
8 - 487703



12 - 489125



9 - 483402



13 - 485667

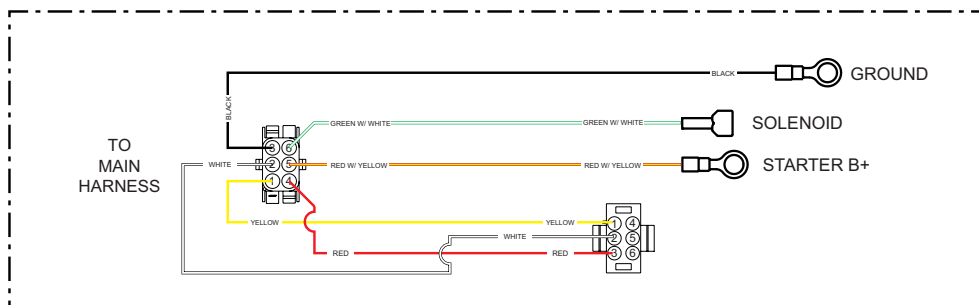
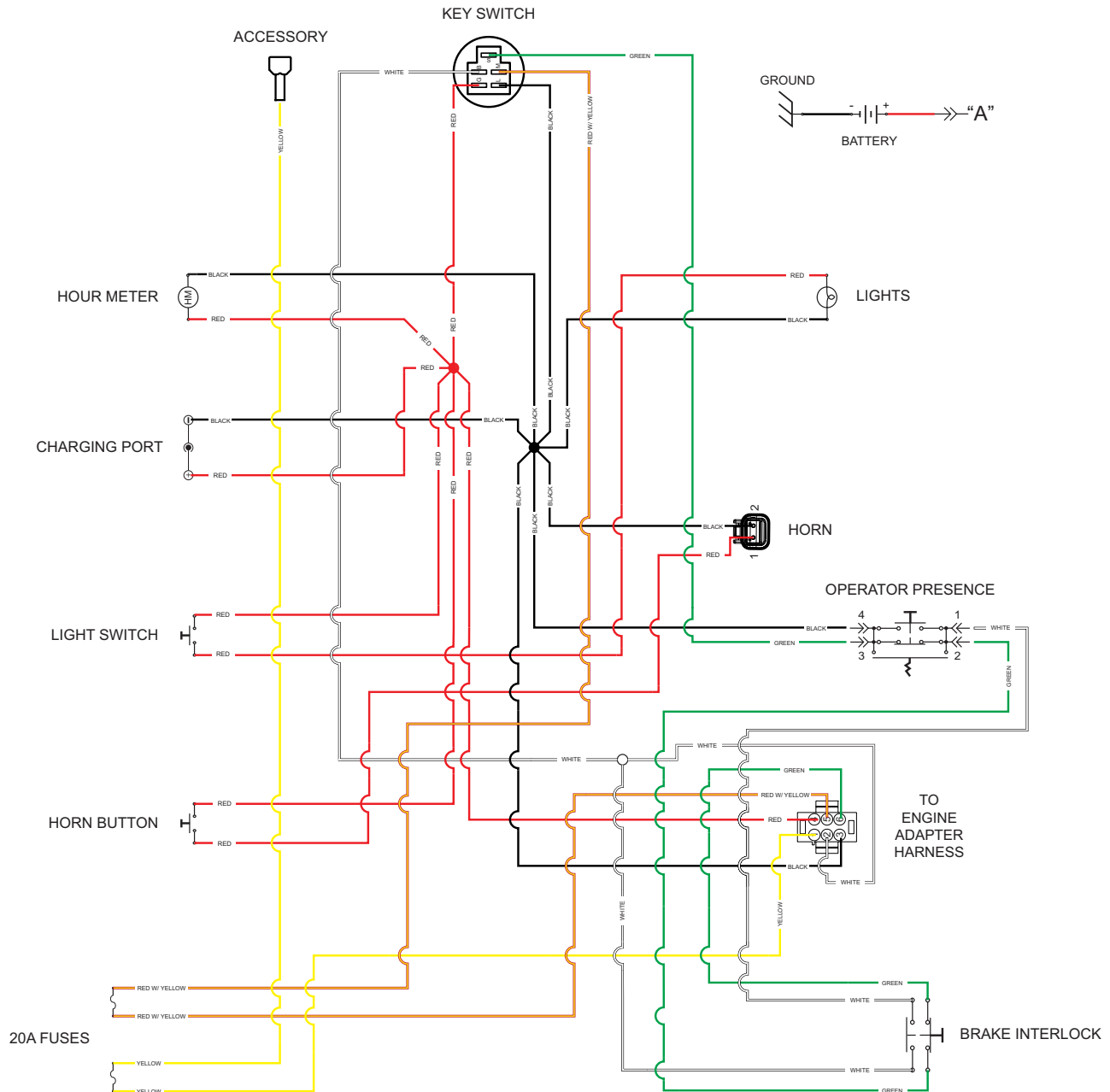


10 - 481099



11 - 489124

ELECTRICAL SCHEMATICS



LIMITED WARRANTY – TRACKED POWER BUGGY

Any part of the Scag 2500X Tracked Power Buggy manufactured by Scag Power Equipment and found, in the reasonable judgment of Scag, to be defective in materials or workmanship, will be repaired or replaced by an Authorized Scag Service Dealer without charge for parts and labor during the periods specified below. This warranty is limited to the original purchaser provided the product was purchased from an Authorized Scag Power Equipment Dealer and is not transferable. Proof of purchase will be required by the dealer to substantiate any warranty claims. All warranty work must be performed by an Authorized Scag Service Dealer. The replacement of any part of this product by other than the manufacturer's authorized replacement part may adversely affect the performance, durability, or safety of this product. Use of other than original Scag replacement parts will void the warranty.

This warranty is limited to the following specified periods from the date of the original retail purchase for defects in materials or workmanship:

- Wear items including drive belts and tracks are warrantied for ninety (90) days.
- Batteries are covered for ninety (90) days.
- Hydraulic hoses are covered for one (1) year.
- Frame and structural components, including oil reservoirs and oil coolers, are warrantied for two (2) years or 2,000 Hours (whichever comes first) (parts and labor), one (1) year or 1,000 Hours (whichever comes first) (parts and labor) for Rental use. This warranty does not cover any tracked power buggy that has been subject to misuse, neglect, negligence, accident, or that has been operated in any way contrary to the operating instructions as specified in the Operator's Manual.
- Engines and electric starters are covered by the engine manufacturer's warranty period.
- Major drive system components are warrantied for two (2) years or 2,000 Hours (whichever comes first) (parts and labor), one (1) year or 1,000 Hours (whichever comes first) (parts and labor) for Rental use by Scag Power Equipment. The repair or replacement of the hydraulic pumps, hydraulic motors, hydraulic cylinders, hydraulic manifolds or hydraulic valves will be at the option of Scag Power Equipment. This warranty does not cover any tracked power buggy that has been subject to misuse, neglect, negligence, accident, or that has been operated in any way contrary to the operating instructions as specified in the Operator's Manual.

The Scag 2500X Tracked Power Buggy, including any defective part, must be returned to an Authorized Scag Service Dealer within the warranty period. The expense of delivering the tracked power buggy to the dealer for warranty work and the expense of returning the tracked power buggy to the owner after repair will be paid for by the owner. Scag's responsibility is limited to making the required repairs and no claim of breach of warranty shall be cause for cancellation or rescission of the contract of sale of any Scag 2500X Tracked Power Buggy.

This warranty does not cover any tracked power buggy that has been subject to misuse, abuse, neglect, negligence, accident, or damage or deterioration due to normal use or that has been operated in any way contrary to the operating instructions as specified in the Operator's Manual. The warranty does not apply to any damage to the tracked power buggy that is the result of improper maintenance, or to any tracked power buggy or parts that have not been assembled or installed as specified in the Operator's Manual. The warranty does not cover any tracked power buggy that has been altered or modified, changing performance, durability, or allowing the use of improper or unapproved attachments or accessories. In addition, the warranty does not extend to replacements or repairs made necessary due to normal wear, or by the use of parts or accessories which, in the reasonable judgment of Scag, are either incompatible with the Scag 2500X Tracked Power Buggy or adversely affect its operation, performance, or durability.

Scag Power Equipment reserves the right to change or improve the design of any tracked power buggy without assuming any obligation to modify any tracked power buggy previously manufactured. All other implied warranties are limited in duration to two (2) years or 2,000 Hours (whichever comes first) (parts and labor), one (1) year or 1,000 Hours (whichever comes first) (parts and labor) for Rental use. Accordingly, any such implied warranties including merchantability, fitness for a particular purpose, or otherwise are disclaimed in their entirety after the expiration of the two (2) years or 2,000 Hours (whichever comes first) (parts and labor), one (1) year or 1,000 Hours (whichever comes first) (parts and labor) for Rental warranty period. Scag's obligation under this warranty is strictly and exclusively limited to the repair or replacement of defective parts and Scag does not assume or authorize anyone to assume for them any other obligation. Some states do not allow limitations on how long an implied warranty lasts, so the above limitation may not apply to you.

Scag assumes no responsibility for incidental, consequential, or other damages including, but not limited to: expense for fuel; expense of delivering the tracked power buggy to an Authorized Scag Service Dealer and expense of returning the tracked power buggy to the owner; mechanic's travel time; telephone or communication charges; rental of a like product during the time warranty repairs are being performed; travel, loss, or damage to personal property; loss of revenue; loss of use of the machine; loss of time; or inconvenience. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

For additional questions regarding the warranty terms and conditions, contact Scag Power Equipment online at:

<https://www.scag.com/company/contact-us/>



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