



# Instructions

## Chain Mulcher

### M1650 STORM



**Important!**  
Read through the owner's  
manual before Use



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# SAFETY SYMBOLS

NB! This warning symbol can be found throughout this instruction manual and should draw your attention to safety instructions for yourself, your employees and other persons who come into contact with the machine. Neglecting these instructions can cause serious injury and even death.

This symbol means the following:



**WARNING!**  
**LOOK UP!**  
**YOUR SAFETY IS AT RISK!**

## Words of warning

Pay attention to the words **WARNING!** and **ATTENTION!** in security texts. The words have been chosen based on the following guidelines:



**WARNING!:** Highlight dangerous situations that, if not avoided, could result in serious injuries and even death. These also include hazards that can happen when protective equipment and/or protective screens are removed. The warning words can also be used to warn of dangerous use.



**NB!:** Mark risky situations where light or minor injuries could result if not avoided. Also used to warn that machine damage may occur if the instructions are not followed.

Dear customer !

We thank you for choosing a TREJON OPTIMAL product and hope you will be satisfied.

By reading the manual and following its recommendations, you ensure that you get the longest possible service life and efficient use of the machine.

We have made this manual so that you can get a good overview of how the machine works and what safety and maintenance regulations must be followed when working with the machine.

If any questions arise when using the machine or when reading this book, you are always welcome to contact us.

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Checklist for delivery control:

Check for any transport damage. Report to the transport company	
Check that the PTO axis is included and is the correct length	
Check that 13mm chains are mounted on the chain cassette	
Check the oil level in the gearbox and bearing housing. See sections 4.6 and 4.8	
Check the oil level in the hydraulic oil tank. See section 4.10	
Perform function check	
Fill in the Warranty Certificate together with the customer and register on <a href="http://trejon.se">trejon.se</a>	

Fill in the serial number of the machine in the field on the right	S/N:
--	------

# 1 Introduction

## 1.1 Introduction

We thank you for choosing this TREJON OPTIMAL Chain Shredder. We have concentrated on manufacturing a powerful and good machine that will last for many years. Since the service life of the machine depends not only on us, but also on you, we have compiled an operating manual in which we describe the correct care and use of the machine. Therefore, read this entire instruction carefully. Always contact the dealer where you bought the machine, when you need to order spare parts or need other service. When ordering spare parts, always find out the correct model, type and serial number see the machine plate located on the chassis.

## 1.2 Description

This machine is designed to keep roadsides, ditches, arable land and other surfaces free of grass, brushwood and bushes. The M1650 STORM model is intended to be mounted on agricultural tractors with a cat. II or cat. III three-point lift. The chain mulcher is mounted at the rear of the tractor (pulling). The transmission is driven by the tractor's 540 rpm and 12V PTO.

The machine's movements are operated with an integrated valve package and a proportional joystick, oil for this valve package is taken from a hydraulic outlet on the tractor and with free return.

The machine's integrated side shift makes for a relatively light machine, and the hydraulic drive combined with the design of the arm makes it possible to mow on the other side of the trench. The head is mounted on a telescopic stick which also is hydraulically tiltable 90°.

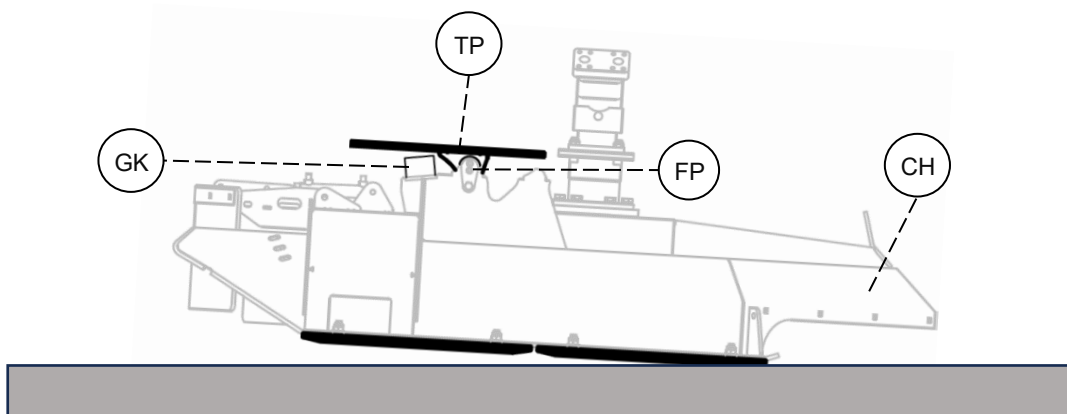
### Articulated Mounting Plate

The cutting head (**CH**) is equipped with an articulated attachment plate (**TP**). The function of this with means that the cutting head can move and more easily follow the contour of the ground. The attachment (**FP**) of the plate is located in front of the center of gravity of the cutting head. This means that the cutting head leading edge will always be lifted first.

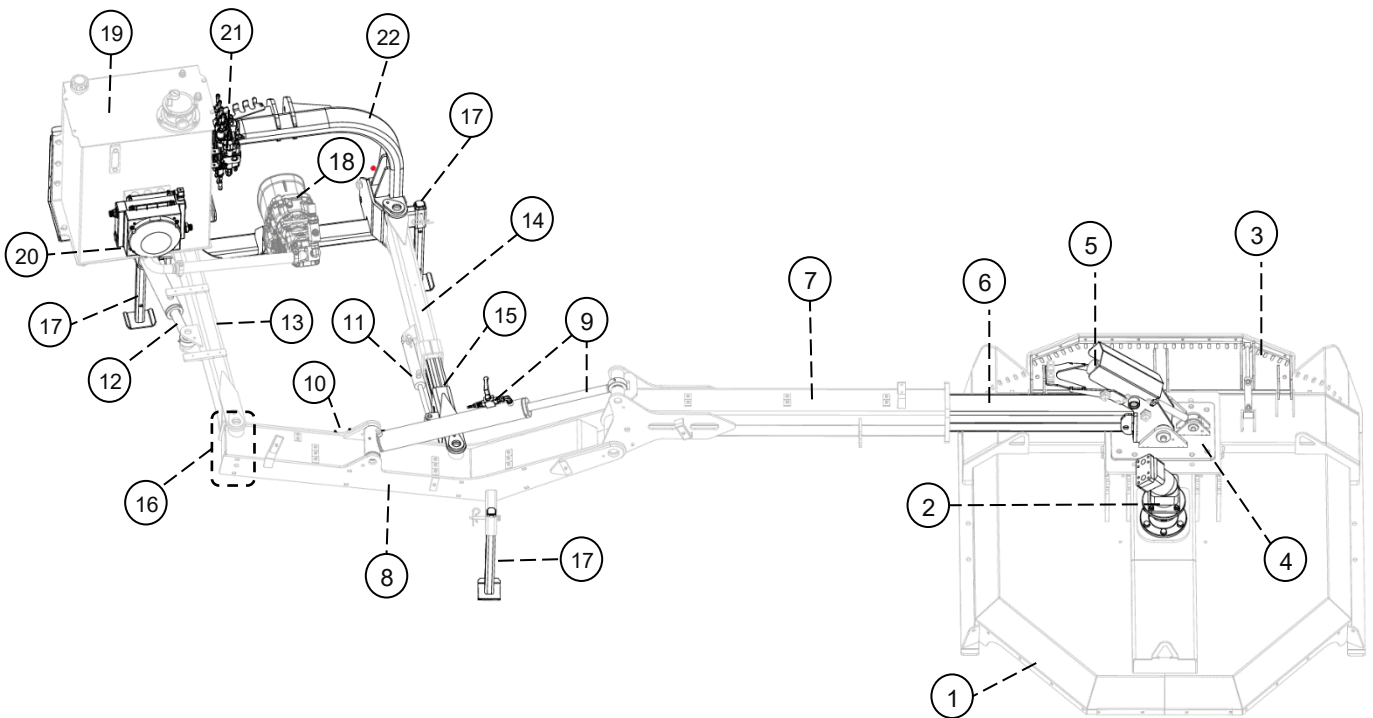
Make sure that the rear edge of the cutting head is always dragging on the ground while the front edge of the machine is always "floating" in the air. When the entire cutting head is lifted up, the attachment plate will lie against the rubber pads (**GK**).

During operation, the machine should then be as close to the ground as possible, to get a good reprocessing of brushwood and bush residues.

Do not force the machine through dense or coarse vegetation. Try to find a suitable speed so that the processing is as efficient as possible.



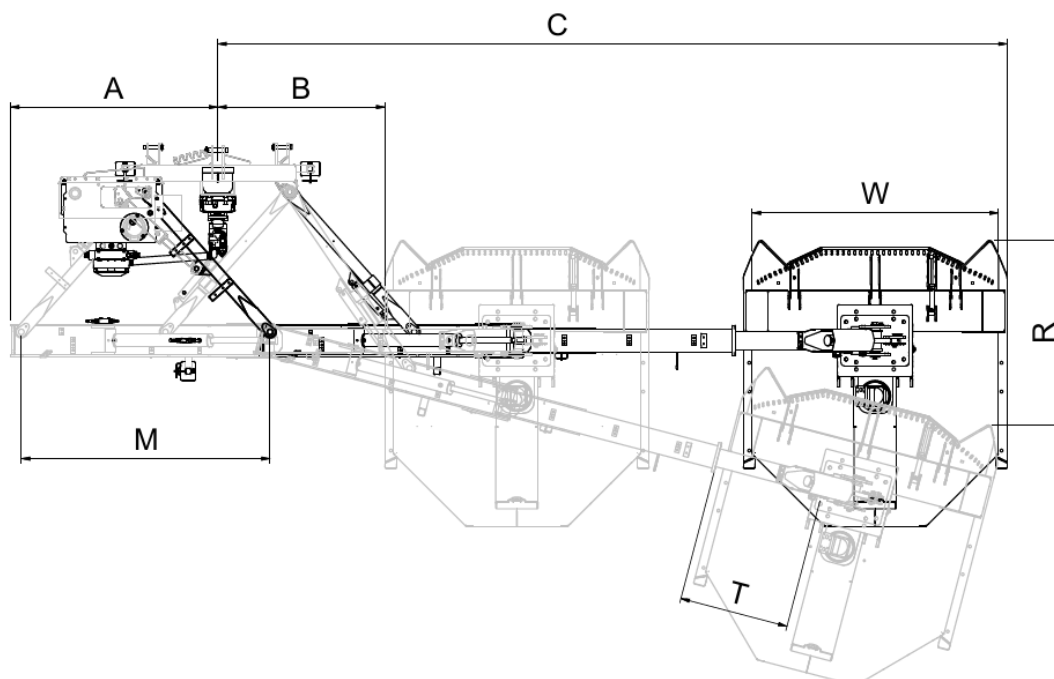
**1.3 Detail description M1650 STORM**

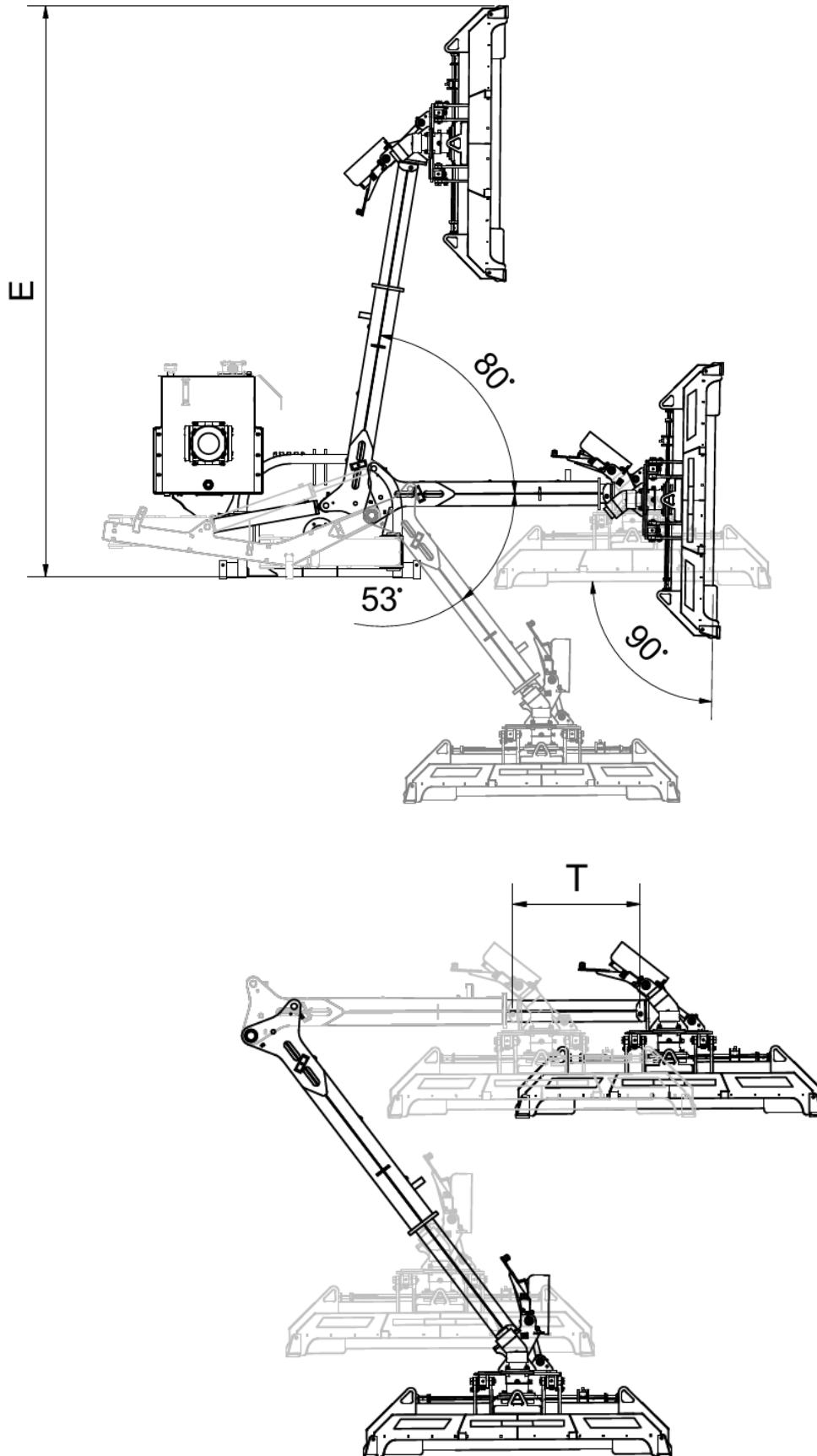


1. Cutting head with chain blade	12. Swing cylinder
2. Hydraulic motor	13. Swing arm left
3. Service hatch	14. Swing arm right
4. Articulated attachment plate	15. Telescope arm collision device
5. Articulating cylinder	16. Reflective (vit, orange, röd)
6. Telescope arm cutting head	17. Support leg (3pcs)
7. First boom, moveable	18. Hydraulic pump and gearbox
8. Lifting arm, machine frame	19. Hydraulic tank
9. Lifting cylinder (tap to be closed during transport or maintance)	20. Oil cooler
10. Valve collision device	21. Hydraulic valve
11. Cylinder collision device	22. Three point frame

### 1.4 Technical data

Specification / Model	M1650 STORM
Working width <b>W</b> , [cm]	165
Max side shift movement <b>A</b> , [cm]	144
Min. reach <b>B</b> , [cm]	116
Max reach <b>C</b> , [cm]	548
Max side shift movement <b>M</b> , [cm]	0 - 173
Height <b>E</b> , [cm]	300-370
Hydraulic telescope movment <b>T</b> [cm]	0 - 76
Back swing <b>R</b> , [cm]	0 - 112
Hydraulic tilt of cuttinghead [°]	90°
Collision device	Hydraulic
Chain/knives, quantity	2
Lift of cutting head, Std. Typ	Hydraulic
Hydraulic connection for ERGO joystick	1pcs single acting with free return ( <b>max 20 Bar backpressure</b> ), oilflow 30 - 60l/min
Hydraulic connection for servicehatch	1 pcs double acting
Weight, base unit, [kg]	1350
3-Point connection	Kat. II , III
PTO speed, [r/min.]	540
Mounting to tractor,	Draged
Transmission for cutting head	1pcs PTO-shaft drives axial piston pump & motor 75hk
Hydraulic system for cutting head	100 l/min - 350 bar - 12v oil cooler
Oiltank for cuttinghead [l]	160 l (Shell Tellus S2 VX 46)
Tractor/carrier recomended weight	Min. 5 ton

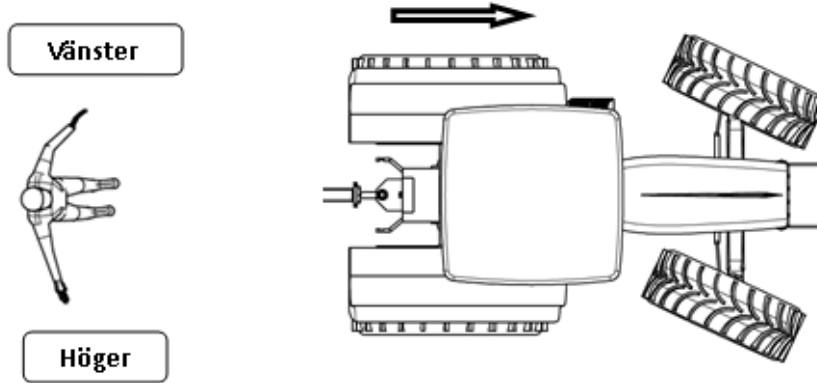




Due to ongoing product development, the technical data provided in our documents is not binding and is subject to change without notice. Given information in the table above may also show equipment that is not standard. Equipment level may vary depending on the country of use.

### 1.5 Right and left hand

In this Operator's Guide, the terms right and left hand apply as you stand behind the tractor and look ahead in the direction of the machine's travel (see Fig. 1).



Picture.1

### 1.6 Assembly of machine

Trejon Optimal M1650 STORM is delivered in a transport hedge (see Fig. 2) from the factory to the dealer who will assemble the machine. This installation may only be carried out by a person who has the necessary technical knowledge for the work.

It is important to follow the enclosed assembly instructions **art. no. 2024002**.



Picture.2

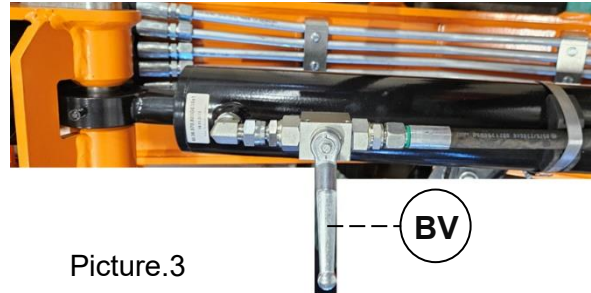
**1.7 Lifting and transport instructions for assembled machine.**



**NB!** It is important that the correct length of lifting chains is used to achieve a horizontal lift.

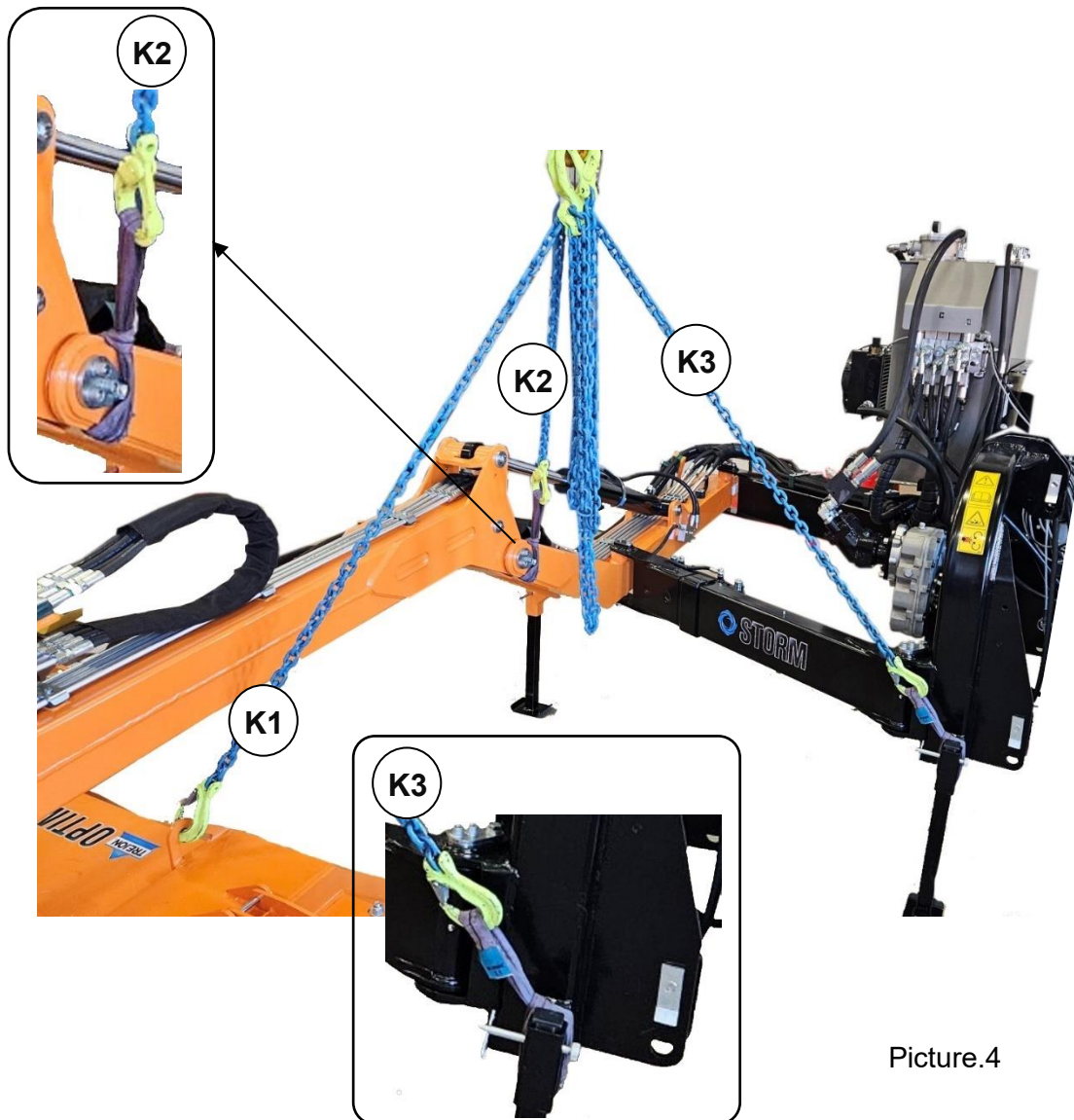
**K1** – 160cm; **K2** – 120cm (med stropp); **K3** – 175cm (med stropp).

Before starting lifting, check that the crane **BV** is switched off, (see Fig. 3).



Picture.3

Lifting points for moving the assembled machine are shown in Picture.4. For **K2** and **K3**, it is recommended to combine chain with lifting strap to avoid damage to the machine.



Picture.4

## 2 Safety Instructions

### 2.1 Safety precautions

It is necessary to observe the main safety regulations during the work, adjustment and maintenance of the machine.

If the user of the machine has not read or not followed the points below, there is a great risk that damage can occur to both people and property. The machine is intended for outdoor use only.

**WARNING!**

**NO PERSONS OR ANIMALS ARE ALLOWED TO BE CLOSER THAN 100 M FROM THE MACHINE WHEN IT IS IN OPERATION. WHEN CLEARING IN DENSELY POPULATED AREAS, THOSE WITHIN THE RISK ZONE MUST BE WARNED**

**THE DRIVER'S SEAT MUST UNDER NO CIRCUMSTANCES BE LEFT BEFORE THE POWER TAKE-OFF (PTO), THE HYDRAULICA FLOW HAS BEEN DISCONNECTED AND THE TRACTOR'S ENGINE HAS STOPPED.**

**THE ROTATING PARTS OF THE MACHINE MUST NEVER BE TOUCHED BY ANY PART OF THE BODY OR ANY PERSON WHEN THE POWER TAKE-OFF (PTO) AND TRACTOR ENGINE ARE RUNNING.**

Particular attention must be paid to the following points:

- Read and understand the contents of this entire instruction manual on the operation of the machine.
- Learn and practice the machine's operating methods and controls before using it.
- Check, adjust and maintain the machine as instructed.
- For maintenance and adjustment of the machine, it must be placed on a firm, level surface
- The machine should only be used if all the manufacturer's original movable mechanism protection is in the correct place and that no unauthorised persons, especially children, are in the working area.
- When working at night, the work area must be illuminated.
- If vibration occurs in the machine, it must be immediately switched off for further inspection.
- Use caution when lifting and lowering the cutting head.
- If the cutting head of the machine is raised for cleaning, maintenance, inspection or repair, it is necessary to prevent it from sinking/falling. A crane is located on the machine's lifting cylinder, this should be closed to lock the cutting head in the raised position.
- The machine must not be driven with a tractor that does not have sufficient weight over the front axle to affect the steering and stability of the tractor. Install ballast weights if necessary, read the tractor's owner's manual.

Attention must also be paid to the following:

- Unauthorised persons, especially children, must not be in the vicinity of the machine during work or the machine being repaired.
- It is forbidden for intoxicated or drugged people to work with the machine
- It is forbidden to work with a machine if the guards for moving parts, the guards for the PTO or the guards for the shafts have been removed.
- It is forbidden to use damaged or faulty PTO guards.
- It is forbidden to use faulty PTO shafts that do not meet specifications.
- It is forbidden to adjust the machine or remove material from the cutting head/chain rotor when the tractor engine is in operation.
- Be careful while working in uneven ground conditions, reduce the speed of work.
- Clean the machine thoroughly before repair and storage.
- Protect hydraulics and bearings if welding is to be performed.
- Make sure that no one is within the machine's working range.

For any cleaning or checking, you must:

The PTO and the tractor's engine stop.  
The tractor is braked and the cutting head is lowered to the ground.  
The emergency stops are pressed.  
Make sure that all moving parts have stopped.

The service door may only be opened during servicing/cleaning when the machine has come to a complete standstill.

When clearing in dry areas, there is a risk of fire

Use only original spare parts for the machine.

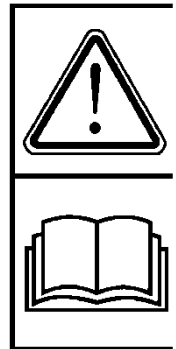
If you have any questions about the machine or its operation, please contact your dealer or TREJON AB

## 2.2 Symbol explanation

The symbol on the right shows the following:



Warning!  
Study the owner's manual carefully before use, so that the user knows the machine well.



Warning!  
Do not bring your arms or legs near the machine's moving parts. Do not be near the PTO when the machine is running. Failure to respect this can result in life-threatening injuries and even death.



Warning!  
Because flying objects such as rocks and chips can be thrown away from the machine during operation. If you are not nearby, keep a distance of at least 100 m from the machine when it is running. At the same time, the driver must have a good view in the area where the machine is working, driving where people, animals and buildings are present should be avoided.





**Warning!**  
*Risk of pinching! Keep your hands and arms away from moving parts.*



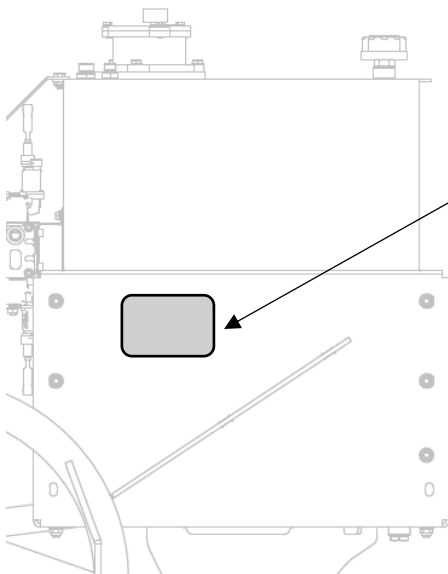
The machine will be driven by the tractor's PTO at 540 rpm.



Stop the tractor engine and apply the handbrake during cleaning, adjustment, maintenance and repair!



This is the machine sign with the CE mark. Here you will find the machine's serial number, weight and model designation. The machine sign is located on the back road of the oil tank.



### 3 Using the Machine



**NB!**

The length of the PTO shaft towards the tractor must be checked and adjusted before starting the machine, see Chapter 3.4  
A too long axle can damage both tractor and machine.

#### 3.1 Before starting the machine

Before using the machine, the following points on the machine must be checked:

The M1650 STORM is designed to be coupled to a tractor with a Kat. II all Cat. III three-point lift.

That all screws and nuts are tightened (check and retighten screws and nuts after the first 4 working hours and then every 40 working hours)

That the chains/blades are of the same dimension and length, also check the condition of the different parts.

The oil level in the gearbox and hydraulic oil tank must be checked and visible in the level glass.



**Warning!**

Any cracking or other damage that could lead to breakage during operation must be addressed before the machine is put into operation.



**Warning!**

Loose screws and bolts may break during loading. Poorly performed lubrication and low oil levels can lead to costly damage to the machine



**NB!**

Leaking hydraulic cylinders must be replaced or fitted with new seals.



**NB!**

The machine valve package is provided with pressure limiting and shock valves to protect the equipment from overload. No interventions whatsoever may be made on these.

The warranty does not apply if faults occur as a result of incorrect operation.

A doubling of the working speed means that the attachment is exposed to 4 times higher stress, does not drive faster than required.

### 3.2 Connecting the machine to the tractor

1. The machine must only be switched on on a level and level surface.
2. Adjust the lift arms on the tractor so that the frame of the three-point hitch machine is horizontal. We recommend shortening the lifting links of the lifting arms as much as possible to achieve as high a lifting height as possible on the machine.
3. Connect the tractor lift arms to the machine's 3-point frame.
4. Connect the top link and adjust the length so that the 3-point frame is vertical (vertical). The frame can tilt slightly backwards but NOT forwards.
5. The length of the PTO shaft towards the tractor must be checked and adjusted before starting the machine. A too long axle can damage both tractor and machine. Follow the instructions according to the instructions. Section 3.5.
6. When the machine is connected to the tractor, it must be locked sideways with the stabilization rods on the tractor's three-point linkage.

Check that no objects have been wrapped around the moving parts of the machine.

### 3.2.1 Hydraulic connections

**WARNING!**

**Crushing risk. When coupling, you must not be between the machine and the tractor. Always brake the tractor when leaving the cab during all connection and disconnection work.**

**WARNING!**

**The machine's valve package is adapted for a flow rate of 30-60 l/min. Practical experience has shown that about 40l/min is suitable.**

1. Switch off the tractor engine and apply the parking brake.
2. If the machine is equipped with a hydraulic service hatch, these hydraulic hoses are connected with quick couplings (male-male) to a double-acting hydraulic outlet on the tractor.
3. **Always first connect** the valve package's return hose **T** (female **T-Tank** – blue colour – with built-in non-return valve) to a pressure-free return socket – see Fig. 5. This quick coupling is equipped with an eliminator on the cone to facilitate connection if a hydraulic pressure in the hose has been created.

Picture.5



4. Connect **pressure hose P** (male **P-Pressure** – red color) to the hydraulic system's pressure outlet (which must be depressurized when connected) - see Fig. 6.

Picture.6

**WARNING!**

**Pressure and return hose must not be connected to a double-acting socket.**

**The return hose must be connected to a separate pressure-free return socket.**

Failure to observe this will damage the valve package.

**This is NOT covered by any warranty.**

**WARNING!**

When disconnecting: Turn off the hydraulic flow and stop the tractor's engine, first disconnect **pressure hose P**, then disconnect return **hose T**.

### 3.3 Connecting the joystick cabling

Connect the 3-pin plug (K) to the corresponding socket on the tractor. The socket must be secured with min. 15A fuse and must be able to deliver 12V at 15A load. It is important that the correct polarity is used. (31) Soil, (15/30) 12V.

Wiring overviews see the image below. The line (Q) represents the tractor's cab.

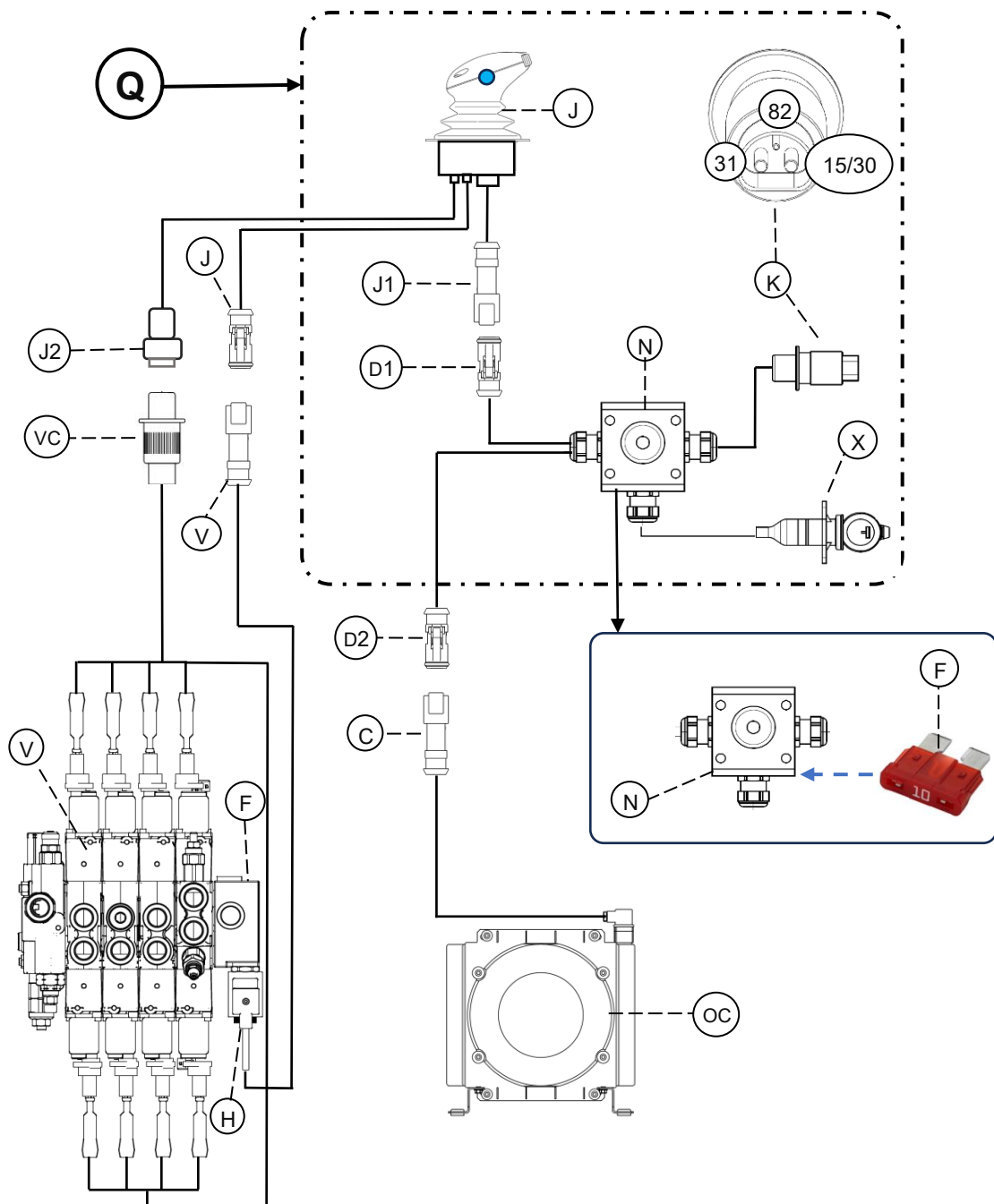
Connect connector (VC) with joystick connector (J2)

Joystick connector (J) with connector (V), floating valve.

Joystick connector (J1) with connector (D1), power supply.

Connect connector (D2) with connector (C) from the oil cooler (OC). Contact (D1) and (D2) are equivalent.

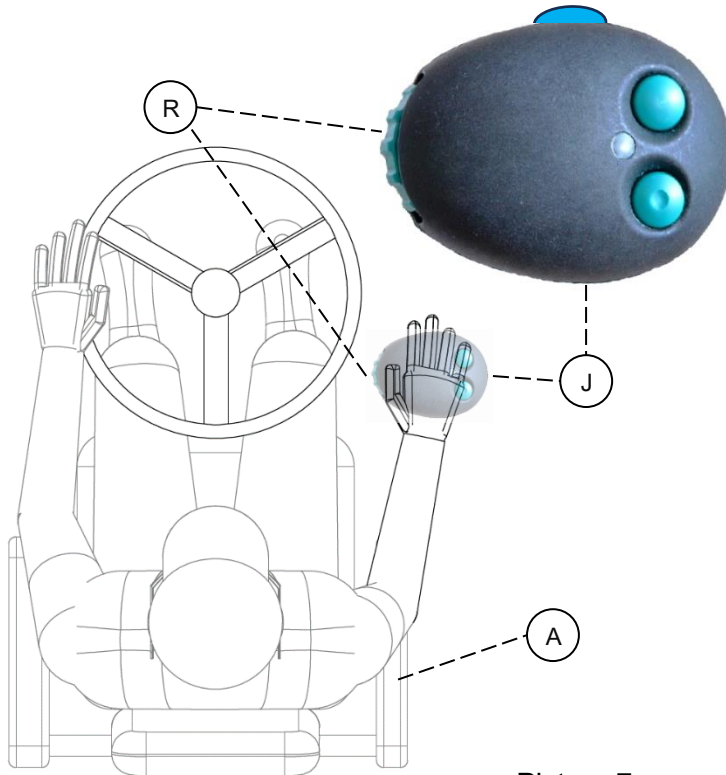
The emergency stop (N) cuts off the power supply to the machine. Inside the yellow box of the emergency stop (N) there is a 10A fuse (F). Plug (X) is not used on this machine.



### 3.4 Installing the joystick in the tractor cab

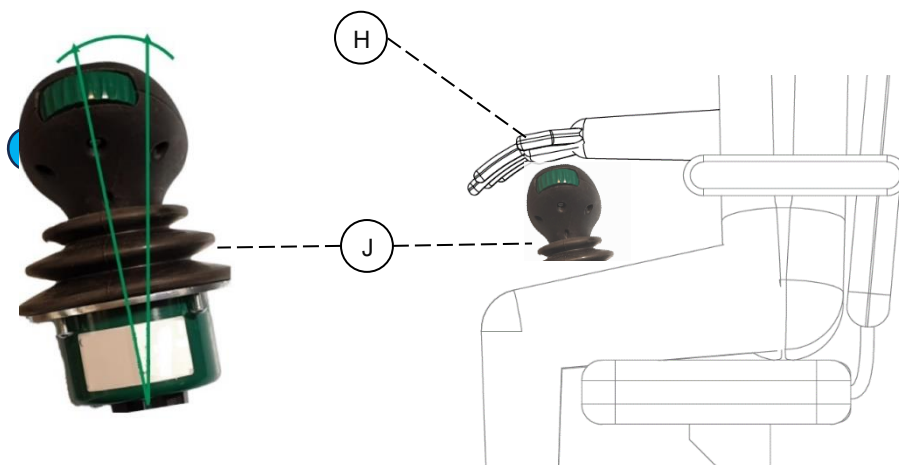
The joystick (**J**) must be mounted in the tractor's right armrest (**A**) or in a place where it is ergonomically positioned.

The joystick (**J**) must be mounted so that the roller (**R**) points towards the driver, i.e. 90 degrees towards the direction of travel according to the (Fig. 7).



Picture.7

If possible, you should also tilt the joystick (**J**) slightly forward to obtain better ergonomics for the wrist (**H**) according to the R&D Rules. (Fig. 8).



Picture.8

### 3.5 ERGO Joystick Calibration

The joystick's all functions can be individually calibrated, MIN and MAX speed as well as ramp (delay). These calibrations can be performed directly from the joystick without the need for a computer. The machine is calibrated from the factory, but if the customer wants a personal setting, these can be carried out according to the instructions. instruction below.

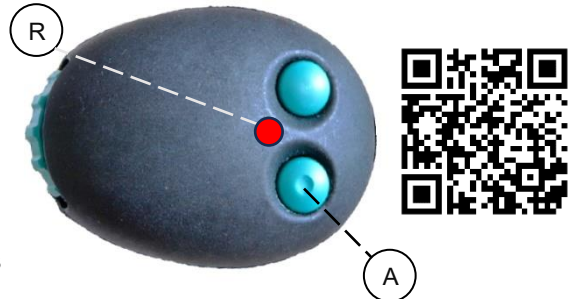


**WARNING! Before starting any calibration, the operator must check that no people or animals are in the vicinity. Machine movements can be rapid and difficult to control during calibration.**

Before starting the calibration, the tractor's hydraulic oil should come up to working temperature and it should circulate through the valve for 5-10 minutes. This is done by activating the hydraulic function that supplies oil to the red quick coupling marked **P**. **Recommended oil flow 40 l/min**, see section 3.2.1.

Video link från manufacture:  
<https://youtu.be/vQiOtPYi8KA>

Picture.9



#### 3.5.1 Adjust of speed

Initial and maximum speed for one or more directions

##### 1. Put the lever into programming mode as follows:

- Starting position: The tractor is running, the flow is activated and the power to the lever is disconnected, i.e. the emergency stop is pressed.
- Press and hold the A button (**A**) button with dimple pressed – see Picture.9.
- Activate the power, release the emergency stop, wait 5 seconds for red LED light (**R**) to light up on the joystick.
- Release the A button. Now the lever is in programming mode

##### 2. Adjust Startup Speed and Max Speed

- **Adjust Starting Speed:** Move the lever/roller in the desired direction until the desired starting speed is reached.
- Confirm by quickly pressing the (A) button (maximum 1 second), while maintaining the position.
- Move the lever/roller to the middle position, LED (R) flashes as a receipt.
- **Adjusting the maximum speed:** Move the lever/roller in the direction in which you just adjusted the starting speed until the desired maximum speed is reached.
- Confirm by quickly pressing the (A) button (maximum 1 second), while maintaining the position. The movement will now stop softly.
- Move the lever/roller to the middle position LED (R) flashes as a receipt.

Now, if you want to adjust additional features:

- Adjust the initial and maximum speed for a different direction: *redo point 2*
- Exit the programming mode: *go to point 3*

##### 3. Exit Programming Mode:

- Press and hold the (**A**) button (several seconds) until the LED flashes on, then release the (**A**) button. Now the lever is ready for use.

### 3.6 Adjustment of the start ramp and exit ramp

(this action SHOULD only be carried out after a contact with your dealer)

The purpose of ramps is to get a smooth acceleration and a soft stopping of selected movements. Ramps can either be inserted for (1) all directions at once, see section 3.4.1 (e.g. only lateral shift) or the same ramp setting can be inserted for (2) individual directions, see 3.4.2. When setting up ramps, count the number of LED flashes. After change of the ramps you may need to calibrate the speed again.

The number of flashes of LED (R) in programming mode means the following:

- |  |                     |
|--|---------------------|
| 1 = no ramps   | 4 = 0.6 second ramp |
| 2 = 0.2 second ramp  | 5 = 0.8 second ramp |
| 3 = 0.4 seconds ramp (recommended as STD for all directions) |                     |

### 3.7 All directions at once (1)

- Disconnect the power from the levers, i.e. the emergency stop pressed.
- Press and hold the **(B)** button – see Picture.10.
- Activate the power, release the emergency stop, wait 5 seconds for red LED **(R)** to light up on the joystick.
- Release the **(B)** button. Now the lever is in programming mode
- Quickly press the **(B)** button and count the number of LED flashes to get information about the current ramp status.
- [If you want to change the ramp setting](#): press the **(B)** button to increase the number of flashes and the **(A)** button (the button with the dimple in it) to decrease the number of flashes. Do this until you obtain the desired ramp setting.
- [Exiting and Using the Joystick](#): Exit the programming mode by moving the lever to the middle position and holding the **(B)** button until the LED **(R)** lights up. After this, you can release the **(B)** button and start using the lever.



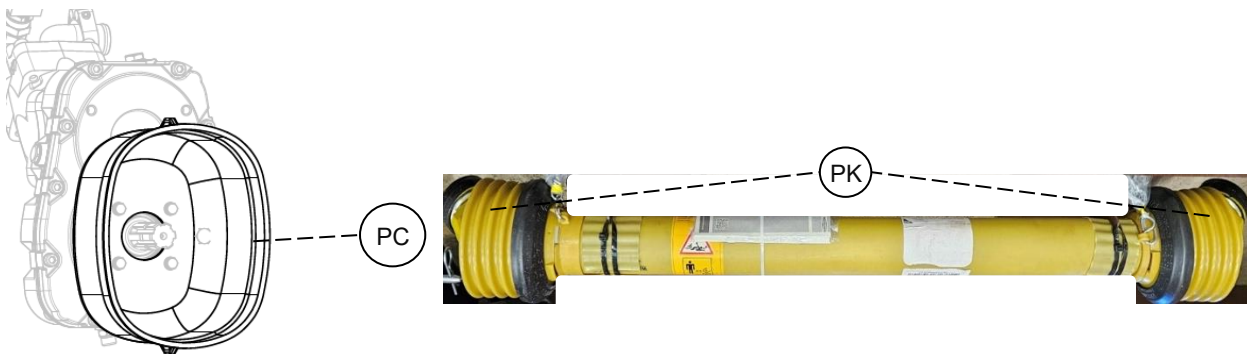
Picture.10

### 3.8 Individual Directions (2)

- Disconnect the power from the levers, i.e. the emergency stop pressed.
- Move the lever/roller as far as it will go in the direction you want to adjust the ramp settings to and press and hold the **(B)** button (without pit)
- Turn on the power, wait 5 seconds for the LED **(R)** to turn on.
- Release the **(B)** button (now the lever is in programming mode). The lever/roller still in the selected direction (as far as it goes)
- Quickly press the **(B)** button and count the number of LED flashes to get information about the current ramp status
- [If you want to change the ramp setting](#): Maintain the position of the joystick/roller. **(B)** button to increase the number of flashes and **(A)** button (the button with a hole in it) to decrease the number of flashes. Do this until you obtain the desired ramp setting.
- [Exiting and using the joystick](#): exit programming mode by moving the lever to the middle position and holding the **(B)** button until the LED light turns on. After this, you can release the **(B)** button and start using the lever.

### 3.9 Adjustment of PTO shaft length

1. The K-axis between tractor and machine must be adapted to the correct length to the customer's tractor, follow the instructions below carefully.
2. Pull apart the k-axis and attach the respective parts to the machine and tractor (make sure that the locking pins on the axle lock securely).
3. Place these next to each other.
4. Check that the shaft does not bottom out in the shortest position (at least 50mm clearance).
5. Check that the overlap of the axle halves is large enough, at least 300mm, if not cut K-axis.
6. See instructions supplied with the shaft (deburr any crosscut so that the profile pipes are not damaged during telescoping). Strive for the greatest possible overlap.
7. Pay extra attention to the maximum and minimum stroke when using the Hydraulic top bar, as the dimensions can quickly vary considerably.
8. Lubricate and install the PTO shaft. Make sure the locking pins on the shaft lock securely.
9. Attach the guards (**PK**) with the chains to the guard (**PC**) and to the tractor safety guard so that they do not rotate, shorten the chains if necessary so that they do not wind up, see Picture.11.



Picture.11



**WARNING!**

If this is not done correctly, there is a risk of damage to the machine, PTO-shaft or tractor. These damages cannot be traced to warranty.



**WARNING!**

The machine must not be used if the PTO-shaft (**PK**) or guard (**PC**) is damaged. Damaged protectors must be replaced because there is a risk of personal injury.

### 3.10 Driving the machine

**WARNING!**



No Persons or animals may be closer than 100 m from the machine when it is in operation. When clearing in densely populated areas, those who are within the risk zone must be warned.



**WARNING!**

Under no circumstances should the driver's seat be left before the power take-off (PTO) and the tractor's engine have stopped. Check/control this safety function at the tractor.



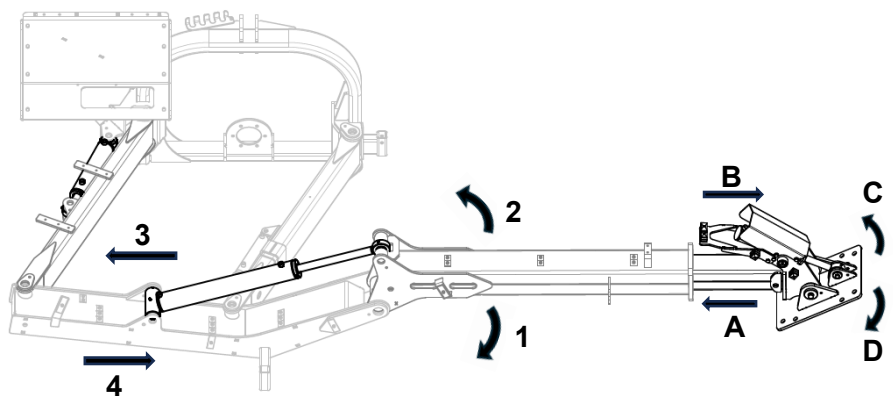
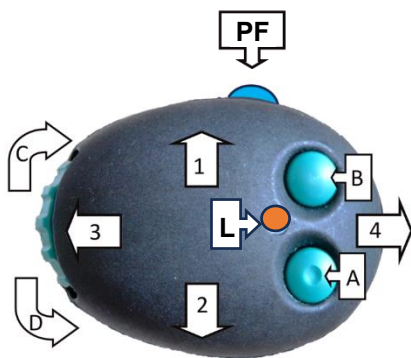
When clearing in dry areas, there is a risk of fire.

The machine is controlled by joystick according to the functions below.

Use the joystick to operate the mowing head.

Since the lifting cylinder is single-acting, the head sinks down under its own power. Therefore, it can be a problem on slopes to lower your head from the transport position. In these cases, the tractor should be driven to flat ground or turned around so that the cutting head is helped by the slope to descend.

**NB!** It is important to understand all the functions of the joystick before starting work with the machine.



- 1 – Lift arm lower
- 2 – Lift arm up
- 3 – Side shift in / left
- 4 – Side shift out / right
- A - Telescope in
- B - Telescope out
- C - Tilt up
- D - Tilt down
- PF- ON/OFF floating, cutting head (C-D)
- L - Diode

### PTO speed PTO

The machine must work with a PTO speed of 540 rpm.

### Working with the machine in ditches and roadsides

- Raise the three-point lift to a high level without excessive angles of the PTO axis occurring, this will provide a greater pattern of movement for the lifting arm and cutting head.
- Use the lifting cylinder on the lifting arm and the tilt joint on the cutting head to change the height of the machine, do not change the height of the three-point lift during work.
- Try to keep the cutting head as close to the ground as possible to get a good working of the material as possible.
- For lower wear on support runners, the machine should be carried during work and the runners should be seen as a safety to avoid contact between the ground and the rotor.
- Be careful when driving on ditch edges so that the head does not get caught and cause damage to the machine's chassis and cutting head.
- When clearing thicker bushes, it is recommended to drive in several rounds with the cutting head high off the ground. This is to get a good result and avoid the chain stopping.

### Working with the machine on arable land

- Set the three-point frame to a suitable height so that the cutting head is horizontal to the ground.
- Use the lifting cylinder on the cutting head to lift the machine, do not change the height of the three-point lift during work.
- Try to keep the cutting head as close to the ground as possible to get a good working of the material as possible.



**NB!**

**If the speed of the chain should drop a lot, the load on the machine must be reduced by reducing the forward speed.**



**NB!**

**The collision device is no guarantee that the machine will not be damaged by a collision with a solid object**

### 3.11 Cutting height and choice of tools

Depending on the work to be performed, the cutting head can be equipped with different types of chains sizes.

- Art. nr. **46504** (25 links) Chain 13 mm, harded (Included in delivery)
- Art. nr. **46505** (50 links) Chain 10 mm, harded (Option)
- Art. nr. **46701** Distance for lower cutting height (Option)

The table below provides guidance for choosing tools.

Type av material	Tools		
	Chain 10mm	Chain 10mm + distance <b>46701</b>	Chain 13mm
Fallow land, arable land	o	+	-
Old arable land	o	+	o
Old arable land with smaller bushes	+	o	+
Bush and brushwood	o	o	+
Roadsides and ditches	+	+	+
<b>Rocky/uneven terrain</b>	+	-	+

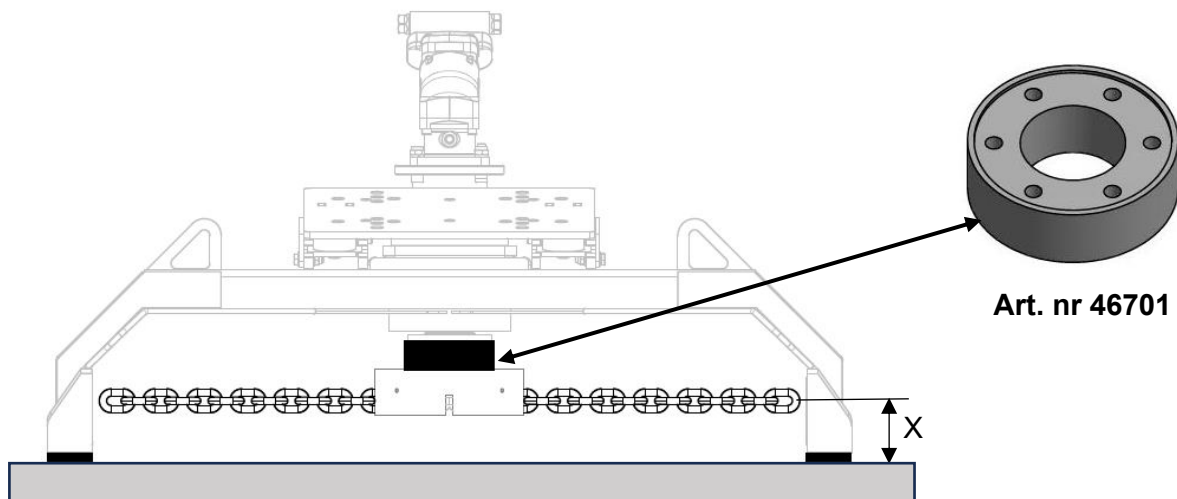
**+** (Recommended), **o** (Works), **-** (Not recommended)

When using a 10mm chain and it bursts, it is too heavy vegetation that is driven. Switch to 13mm chain.



**NB!**  
When driving on stony ground, always use a chain.

Cutting height (X): Chain 10/13mm X ca. 12cm  
Knives X ca. 12cm



Picture.12

Distance Art. nr. **46701** Can be used with a 10mm chain to get a better cutting result on grass. This is an option that can be ordered.  
The spacer gives 50mm lower cutting height – see Picture.12.

### 3.12 Cutting head - chain

The machine comes with a 13mm chain mounted in the chain magazine.

The chains must be of the same length out of the chain magazine. In the case of new chains, the chain magazine can keep a number of spare links inside the magazine. If one or more links are missing on a chain, the chain must be repositioned in the magazine to reach the same length of the two chains. When there are no more links to take out from the magazine, new chains must be installed.

When the chains are worn, you have to reduce the number of protruding links so that they do not touch the chassis. When the length of the chain (**W**) becomes too long, it takes the inside of the chassis. This is noticeable when the chain link starts to hit inside the cutting head – see Picture.13. This will cause an INCREASED and abnormal wear on the cutting head. **The wear and tear of the cutting head is NOT covered by any warranty.**

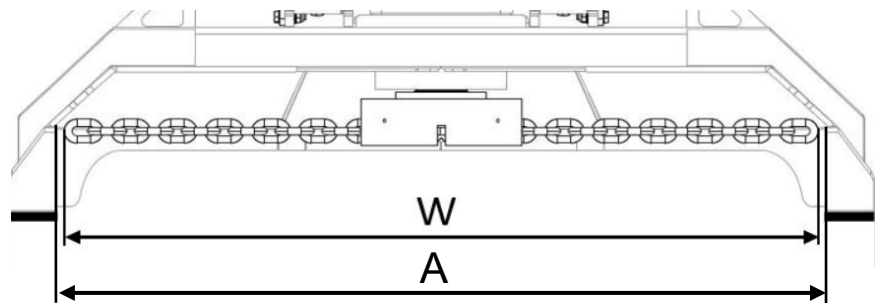
**Warning!**



**Chain length (W) must never exceed the internal dimensions of the cutting head (A),  $W < A$  – see Picture.13.**

**If the chain takes inside the cutting head, work must be stopped immediately!**

A [mm]	1700
W [mm]	1645



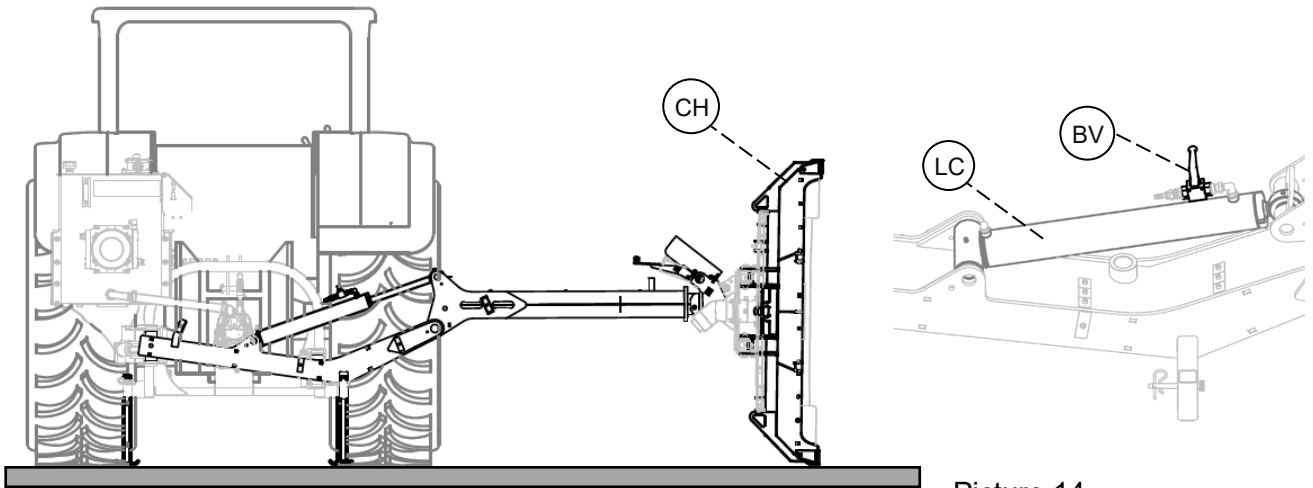
Picture.13

The measurement (**W**) can be customized in 2 ways:

1. Cut off the outermost chain link with a cutting disc.
2. Loosen the cover cap of the magazine, detach the chain from the magazine and shorten 1 link on each chain (**see chapter 3.9**)

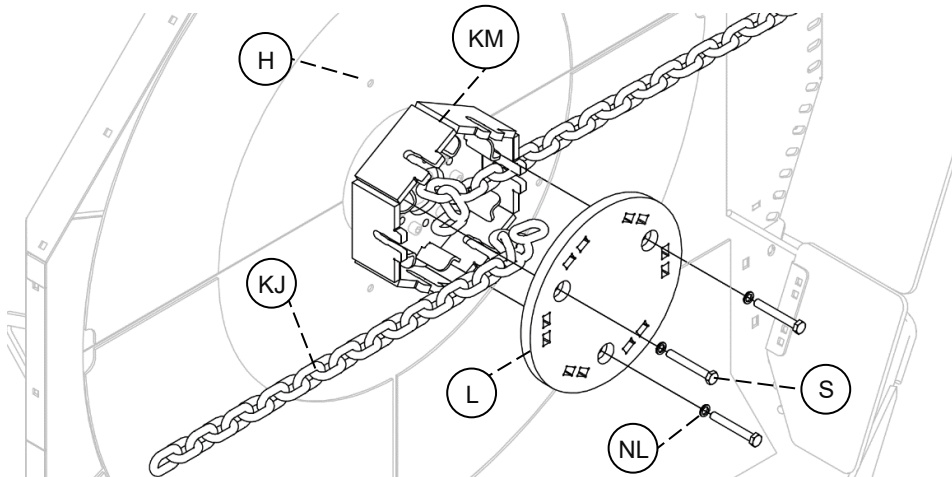
### 3.13 Adaption and replacement of chains

Fold up the cutting head (CH) upright according to the instructions. Picture.14 and close the tap (BV) on the lift cylinder (LC). Make sure the machine cannot fall down. Stop the tractor and apply the parking brake.



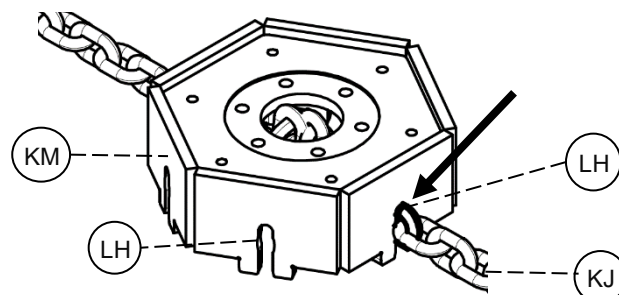
Picture.14

1. Unscrew the 3 M12 screws (SK) with a key width of 19 mm and washers (NL) holding the cover (L), if necessary lock rotation by attaching the chain (KJ) using a screwdriver or pipe in one of the holes (H) – see Picture.15.



Picture.15

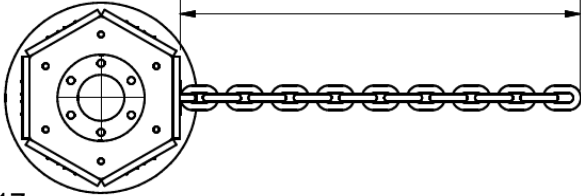
2. Lift off the cover (L) of the chain feeder (KM), tap with a hammer on the reverse side if it is stuck.
3. Lift the chain (KJ) out of the slotted hole (LH) in the chain feed (KM). When the machine is in use, it is normal for a wear to be created in the chain groove (LH) (see arrow on Picture.16). In this case, a hammer may be needed to knock out the chain's link (KJ), grind away events. degrees. A wear in the slot (LH) is normal, it depends of the rotation speed and type of use.



Picture.16

- Adjust the correct number of chain links outside the magazine according to. Picture.17.

Number of links outside the chain magazine	
Chain 13mm	Chain 10mm
17	22



Picture.17

- Move new links forward until the chains are the same length or change to new chains – read section 3.8.
- Fit the lid (L) with 3 new Nordlock washers (NL) Art. nr. **102840**
- Torque tightening screws (SK) with 100Nm – se Picture.18.
- After adjusting the chains, check that they run freely from the machine's chassis.



**NB!**

**Check the condition of the chain feeder parts when adjusting or changing chains. Worn and damaged parts must be replaced with new ones.**



**WARNING!**

**The chains must be the same length, change chains when there are no spare links in the chain magazine. Use only chains approved by the manufacturer.**



**WARNING!**

**Never reassemble used Nordlock washers!  
Always use new Nordlock washers – Art. nr. 102840.**

**Correct mounting of Nord Lock washer**

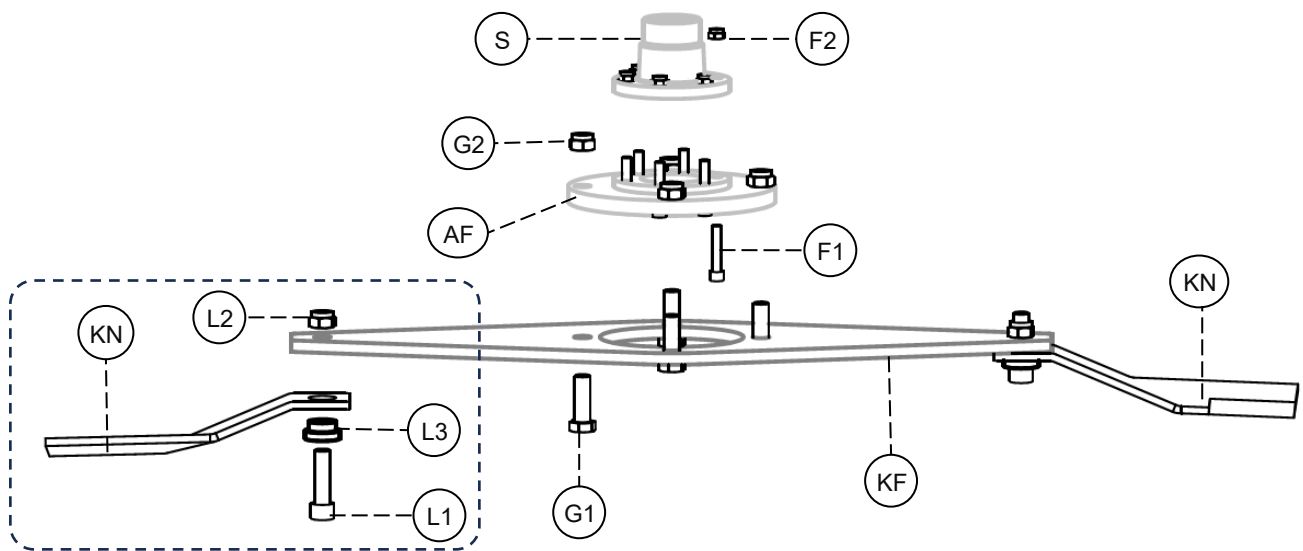


### 3.14 Assembling the knife set

The machine can be equipped with a blade set as an accessory for mowing green areas Art. no. **320347**. This is used for mowing guaranteed stone-free surfaces.

The knife set is installed as follows:

- Remove the cover (L) of the cutting head and remove the chains (KJ), also remove the chain magazine (KM) – see section 3.9 and Picture.15.
- First, mount adapter flange (AF) to spline flange (S) with 6pcs MC6S12x60 screws (F1) and M12 Nyloc nuts (F2) – see Picture.19.
- Then mount the knife holder (KF) to the adapter flange (AF) with 4pcs M6S20x60 (G1) and M20 Nyloc nut (G2) – see Picture.19.



Picture.19

#### Changing knives:

When the knives (KN) Art. no. **46722** or bushing (L3) Art. no. **46723** are worn so that the cutting result has deteriorated they should be replaced, if a blade is missing, a new one must be installed immediately.

Tighten all M6S 20x70 (L1) and M20 Nyloc nut (L2) fastening screws – see Picture.19. Check that the fixing screws (L1) and nuts (L3) of the knives are properly tightened.



**WARNING!**  
Knife set may only be used on guaranteed stone-free surfaces.



**NB!**  
Check the condition of the knife holder's constituent parts when changing blades. Worn and damaged parts must be replaced with new ones.

Use only original knives approved by the manufacturer Art. nr. **46722**.

### 3.15 Collision device

The machine is equipped with a hydraulic collision device that allows the mower head to move backwards when the cutting head hits an obstacle (R = Max 130cm – see Picture.21) while oil from the impact cylinder (**OC**) via a safety valve (**SV**) is transferred to the lifting cylinder (**LC**) which allows the rocker arm (**VA**) with the cutting head raised – see Picture.20. The device is designed to return to the previous working position after the obstacle has been passed or when the cutting head is lifted.

**It is important that the swing arm (S) and telescopic arm (T) are lubricated in accordance with section 4.12.**

The driver must continuously monitor the collision protection during the work. If it is pulled out, the load forward must be reduced by lifting the head up and at the same time checking that the impact protection returns.

If the operator does not have time to stop before the stroke (180mm – see Picture.21) on the cylinder runs out, the cylinder's ear/piston rod may also burst. This is a deliberate design solution to provide less mechanical impact on the machine's other components and parallel arms (swing arms).



**NB!**

**Collision protection is no guarantee that the machine will not be damaged by a collision with solid objects. The forward speed must always be adjusted to prevent damage to the machine and tractor. Collision protection only works in the event of a frontal collision.**

### 3.16 Service hatch

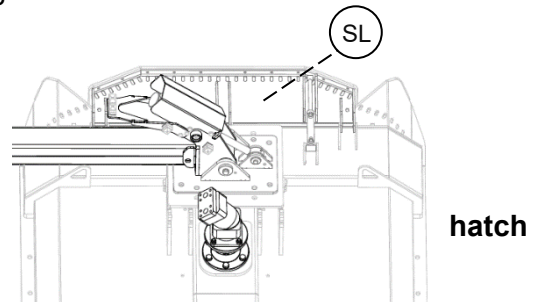
The machine is equipped with a service door (**SL**) that can be opened hydraulically using the tractor's double-acting hydraulic outlet – see Picture.22. When servicing with the hatch open, stop the tractor's engine and mechanically secure the hatch.

When this gap is raised, the chain becomes visible and can be inspected. Closed door is designed to reduce the risk of material being ejected from the cutting head.



**WARNING!**

**The machine should not be operated with the service open.**



### 3.17 Transporting the chain mulcher

- Turn off the power take-off (PTO) so that the chain does not rotate before starting transport.
- The cutting head must be raised to the transport position and secured by closing the tap (BV) on the lifting cylinder (LC) (see Picture. 23).
- Pull in telescopic arm.
- Position the lift arm (side shift) so that it does not protrude more than 20cm (see Picture.24)
- Turn off the hydraulic flow to the chain cutter's valve package.
- Lower the tractor's 3-point to reduce the overall height.
- Adjust the height of the chain mulcher when transporting on the road so that the tractor's rear lights are not covered/obscured so other trafficant's can't see them.

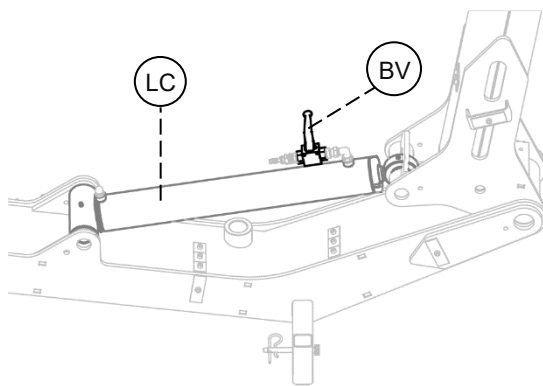


**NB!**

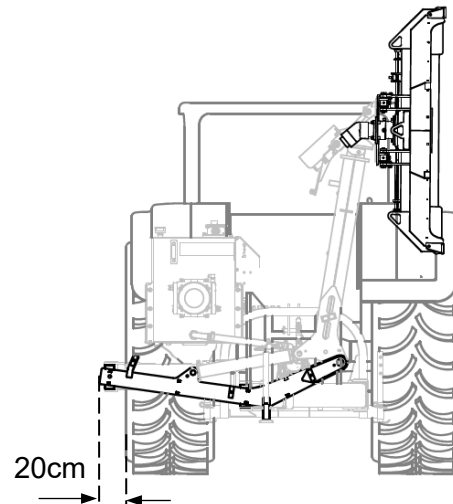
**Consider the transport height of the cutting head when it is folded up behind the tractor.**



**When the cutting head is raised behind the tractor, the tractor's centre of gravity shifts upwards, making the tractor less side-stable. Adapt your speed to the surface, drive particularly carefully in curves and slopes.**



Picture.23



Picture.24

### 3.18 Valve

Below is the proportional hydraulic valve that controls the machine's movements. The section number of the valve is counted from the side the pressure comes in, I, II, III, IV.

- I: Side shift
- II: Lift arm
- III: Telescope
- IV: Tilt function for head
- FL: Float (cutting head tilt) and end section

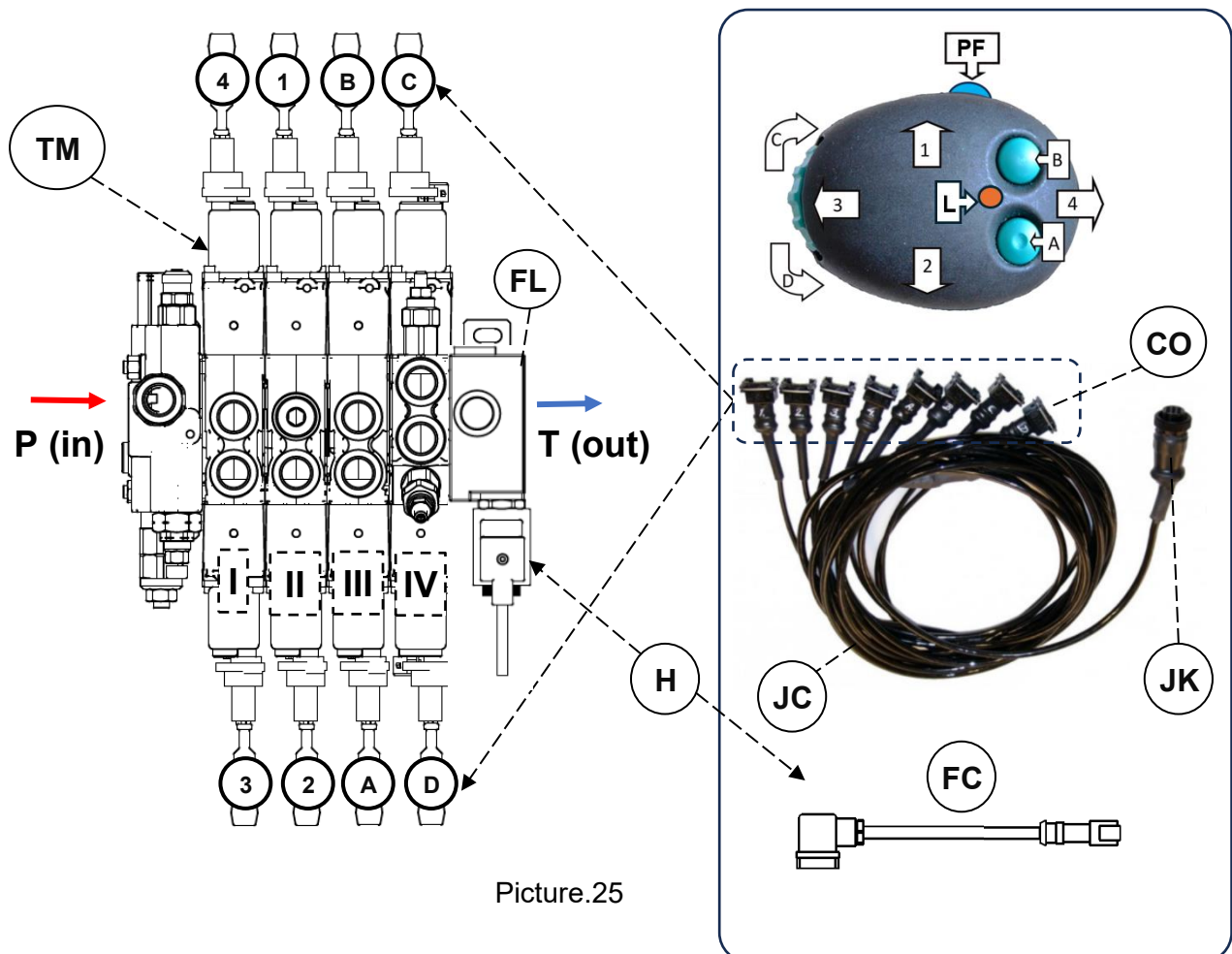
The wiring harness (**JC**) has a marking that shows where each connector should be located on the valve package. The float section has a separate cable (**FC**) from the Hirschman contact (**H**) and the joystick to the

It is important that the valve's return connection is connected to a pressure-free return connection, if there is too high return pressure, there is a high risk that the valve package's solenoid valves, Thomas magnets (**TM**) will be damaged.

**These damages are NOT covered by any warranty**

Formerly correct Hydraulic connection see section 3.2.1

This type of hydraulic valve requires a high cleanliness of the hydraulic oil. Make sure the tractor hydraulic oil is changed according to tractor service intervals. Unclean hydraulic oil will cause malfunctions during manoeuvring.

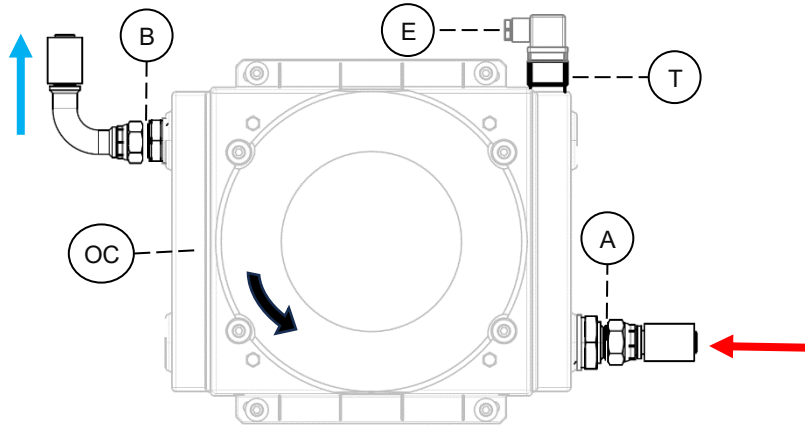


### 3.19 Oil cooler

The machine is equipped with an electric (12V) oil cooler (**OC**) mounted on the hydraulic oil tank – see Picture.26. This is intended to cool the oil when using the chain mulcher.

Previously correct electrical connection see section 3.2.2

If you **do NOT** cut or mulch the oil will not flow through the radiator, you should therefore turn off the PTO if you are not using the mower hood or during longer moves.



Picture.26

The oil cooler fan will start automatically when the temperature of the thermostat (**T**) exceeds 52°C and stop when it falls below 42°C.

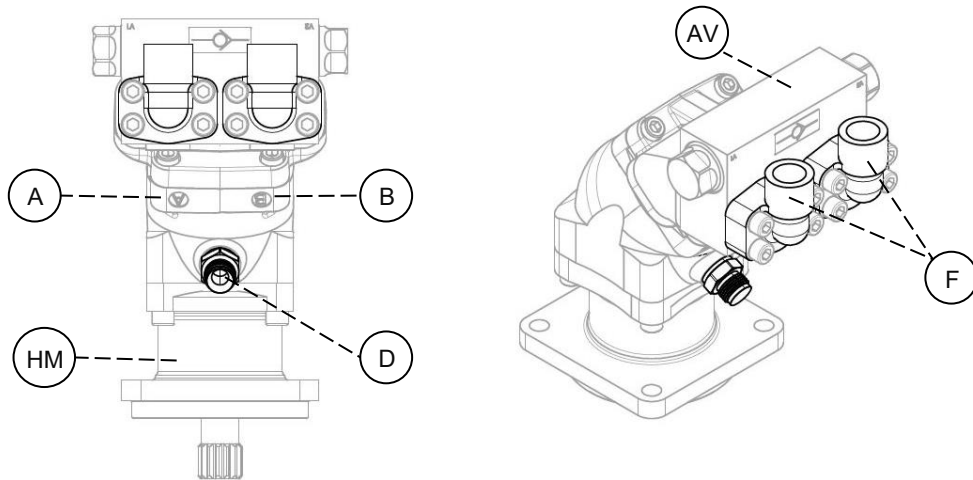
If the chain cutter is to be used at a lower temperature (0°C or lower), it is recommended to start the PTO at low speed (max. 250 rpm) – for 5 minutes to warm the oil. This is to reduce back pressure through the oil cooler at start-up.

Make sure the oil cooler is clean of dirt. A clogged oil cooler will not lower the temperature of the system. If the working temperature rises above 80°C, stop the work and clean the radiator.

Use only low pressure of air to clean the radiator. If you are going to clean it with water, it is recommended to remove the fan from the radiator. This is done by loosening 4 screws that hold the fan and pulling apart the electrical connector.

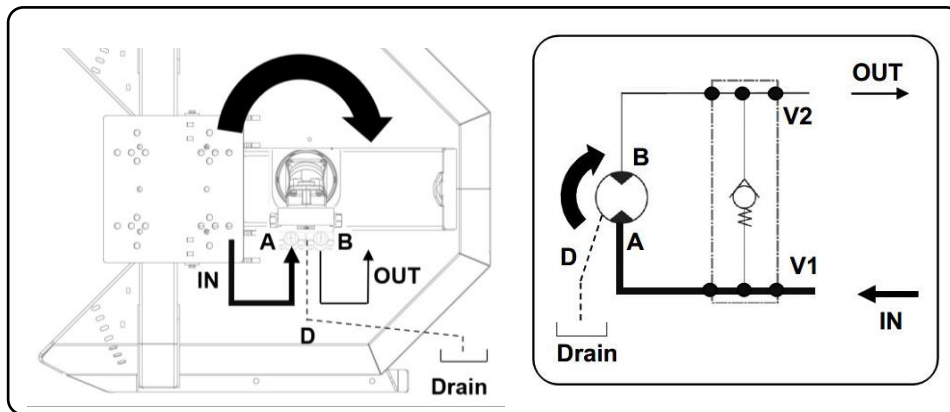
### 3.20 Hydraulic motor – mulching head

Hydraulic motor (HM) has mounting flange according to **SAE C**. Hydraulic motor has two ports marked (A) and (B). On the engine is mounted an anti-cavitation valve (AV) and 2pcs. **G3/4"** flange (F) according to SAE J518-3/4 6000 psi and a **UNF 7/8-14** to **G1/2** drain adapter (D) – see



Picture.27

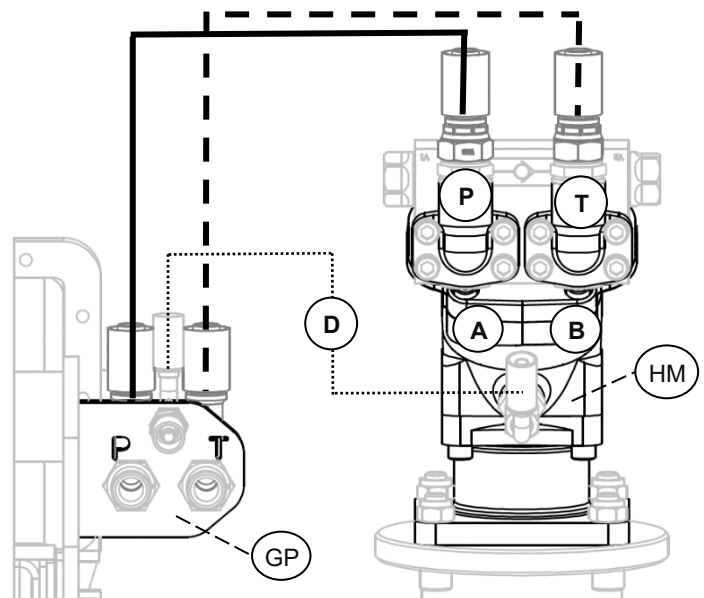
### 3.21 Hydraulic schema - mulching head



Picture.28

Hose routing between interface plate (GP) and hydraulic motor (HM) – see Picture.29.

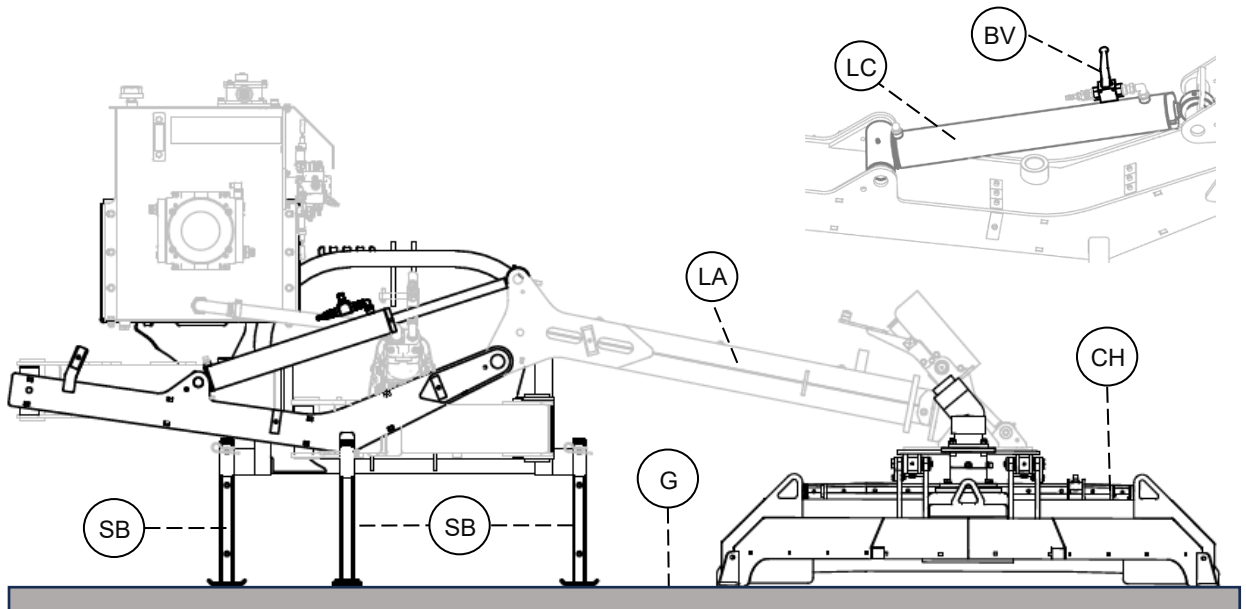
- A = Pressure (P) IN
- B = Return (T) OUT
- D = Drain



Picture.29

### 3.2.2 Parking and storage of machine

- Drop the support legs (SB), lower the three-point so that the support legs reach the ground.
- Park the machine on a flat and level surface (G).
- Retract the telescopic arm according to the Picture.30.
- Lower the lifting arm (LA) and mowing head (CH) to the ground so that both runners are resting against the ground with even pressure.
- Disengage the hydraulic flow from the tractor to the chain mulcher valve package.
- Turn off the tractor and apply the parking brake.
- Close the crane (BV) for the lifting cylinder (LC) – see Picture.30



Picture.30

- First, disconnect **pressure hose P** (male **P-Pressure** – red color) from the tractor's pressure outlet (which must be depressurized at the time of disconnection) - see Picture.31.
- Disconnect the valve package return hose **T** (female **T-Tank** – blue colour – with built-in check valve) from the tractor return socket - see Picture.32.



Bild.31



Bild.32



**NB!**

**If the disconnect of the two hydraulic hoses is made in the wrong order there is a risk that the valve get damaged!**

The machine should preferably be stored under a roof. If the machine is stored outdoors in the down position for a long time, grease should be applied to the piston rod of the hydraulic cylinder.

## 4 Service och maintenance



When any type of maintenance or service needs to be performed on the machine, make sure that the machine is stopped and the tractor's engine turned off. Remove the key from the ignition switch.

Fold the mower head down to the ground.

Make sure that no other people are nearby who could be injured.

### 4.1 Tightening torque for bolted joints

Tabell 1 - Tightening torque for bolted joints

Diameter	Class 8.8		Class 10.9	
	Nm	lb.ft.	Nm	lb.ft.
M8	25	18	35	26
M10	50	37	70	52
M12	90	66	125	92
M14	140	103	200	148
M16	215	155	305	225
M18	295	217	420	309
M20	420	302	590	438

When lock nut is used, increase torque 5%.

### 4.2 Check and service during the first hours of operation

**After the first 4 hours of operation:**

- Check and possibly re-tighten bolted joints on the machine.
- Check for oilleakages.

**After the first 8 hours of operation:**

- Perform 8 hours of service and maintenance according to the schedule below.

### 4.3 Service schedule

Servicepoint	Intervall	Greasing	*Action	Grease-lubricant	Remark
Cardan shaft PTO "Cardan joint"	8:e h	Ja	C	Grease <b>NLGI 2</b>	See inst. from PTO shaft
Cardan shaft PTO PTO "Profile tubes"	8:e h	Ja	C	Grease <b>NLGI 2</b>	See inst. from PTO shaft
Bearing hub seal	8:e h	-	C/EX	-	See chapter 4.8
Chain/chainmagasin	8:e h	-	A/C/EX	-	See chapter 3.9
Hydraulic oil	8:e h	-	C	<b>Tellus S2 VX 46</b>	Level glas See chapter 4.10
Colision protection	8:e h	Ja	A/C	Grease <b>NLGI 2</b>	
Bolt fittings	40: e h	-	A/C	-	
Hydraulic hoses	40: e h	-	C	-	Kontroll av nötning
Bearing hub oil level	40:e h	-	C	<b>ISO VG 220 API GL4/GL5</b>	See chapter 4.8
Gearbox (pump) oil level	40:e h	-	C	<b>SAE 80W90 API GL4/GL5</b>	See chapter 4.7 1,4 liter
Bearing hub	500:e h	Oil exchange	EX	<b>ISO VG 220 API GL4/GL5</b>	See chapter 4.9 0,4 liter
Hydraulic oil	First 40h then 500:e h	Oil exchange	EX	<b>Tellus S2 VX 46</b>	See chapter 4.11 160 liter
Return filter	First 40h then 500:e h	Filter exchange	EX	Trejon Art. nr. <b>HR10039</b>	See chapter 4.11
Gearbox (pump)	First 40h then 500:e h	Oil exchange	EX	<b>SAE 80W90 API GL4/GL5</b>	See chapter 4.7 1,4 liter

**\*Action code: A=Adjust, C=Check, CL=Cleaning, EX=Exchange**

For lubrication, use Grease NLGI 2 with EP properties of good quality.

Do not use so-called "graphite grease" for ball bearings. Compressed air powered grease gun must not be used for lubricating sealed bearings, the seal may come loose or be damaged.

These intervals are in normal driving, in continuous driving lubricate more often. Always lubricate after cleaning with water.

#### 4.4 Before the start of the season

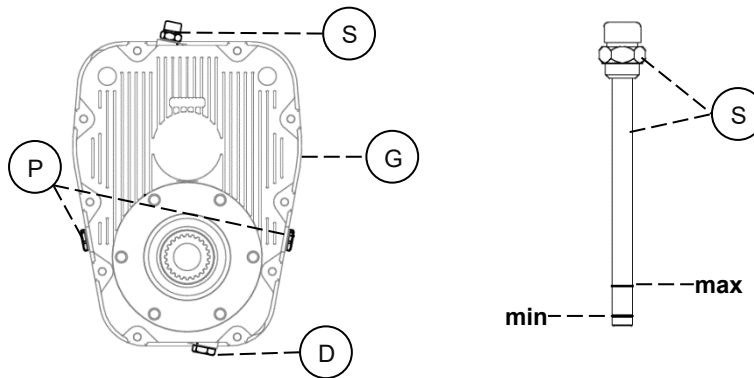
All the above points must be reviewed. If the machine is properly serviced, this will result in a significantly longer service life and a more trouble-free operation.

#### 4.5 After the end of the season

The machine is to be cleaned thoroughly, then the machine is lubricated and serviced. When the machine is dry, we recommend that you apply a thin layer of oil to the areas where the paint has worn off.

#### 4.6 Oil level pump gearbox check

The oil level is checked when the gearbox (**G**) is cold and has been stored on a flat surface. The oil level in the gearbox is checked with the dipstick (**S**) integrated with the air nipple (see Picture.33). The correct oil level is the level between **the min** and **max** mark. The gearboxes are filled with transmission fluid **SAE80W90 API GL4/GL5**. Add oil if the oil level is below **my** mark on the dipstick (**S**) (see Picture.33).



Picture.33

#### 4.7 Changing the oil pump gearbox

When replacing, about **1.4l** of oil is required. TREJON recommends oil **type SAE80W90 API GL4/GL5**.

Start the PTO and run the machine until the gearbox warms up. Turn off the machine. Unscrew the air/fill nipple (**S**) at the top of the gearbox (**G**). Drain the oil into a vessel through the drain plug (**D**) on the lower part of the gearbox (**G**), then tighten the plug (**D**). Then fill the oil from the top until the oil level reaches **the min** line on the dipstick (**S**) (see Picture.33).

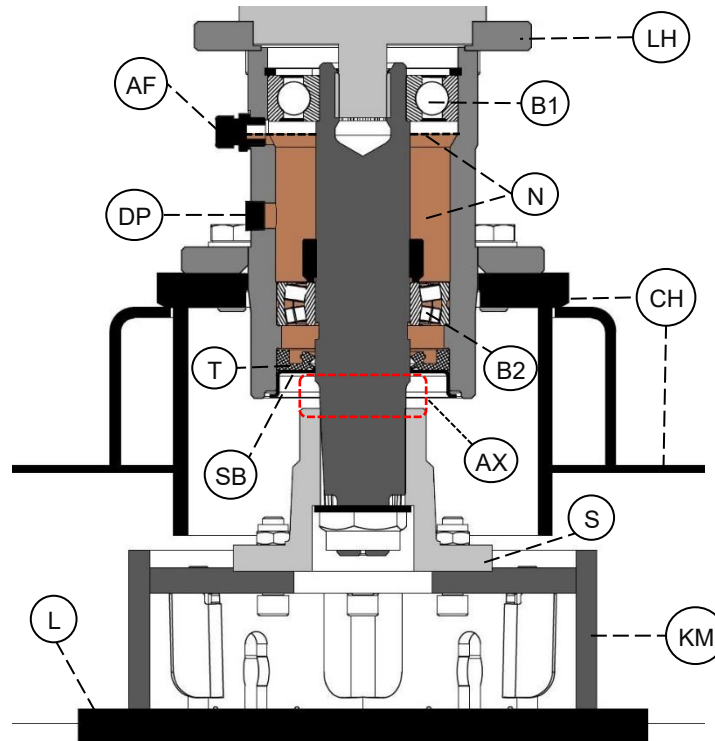
**Wait and let the oil sink into the bearings on the gearbox before reading the correct level**, when the level is correct, tighten the air/fill nipple (**S**) and wipe away any spillage.

**NB! Dispose of the old oil in an environmentally friendly way in accordance with current regulations!**

### 4.8 Oil Level Bearing Housing Control - Cutting Head

Depending on the workload, the oil level (**N**) in the bearing housing (**LH**) should be checked regularly, but at least 1 time per 40 hours. This is an important action to ensure that the bearing housing seal (**T**) and protective washer (**SB**) are not damaged. For example, if long grass or strings-fence wire is wrapped around the axle (**AX**), this seal (**T**) can be damaged, and the oil (**N**) can flow out of the bearing housing (**LH**). If the chain cutter is working with "too little" oil, the bearings (**B1**; **B2**) to take damage. This is not covered by warranty.

The oil level (**N**) is checked by placing the cutting head flat ground. Remove the breathing plug (**AF**) and use e.g. a cable tie to check the level – see Picture. 34.



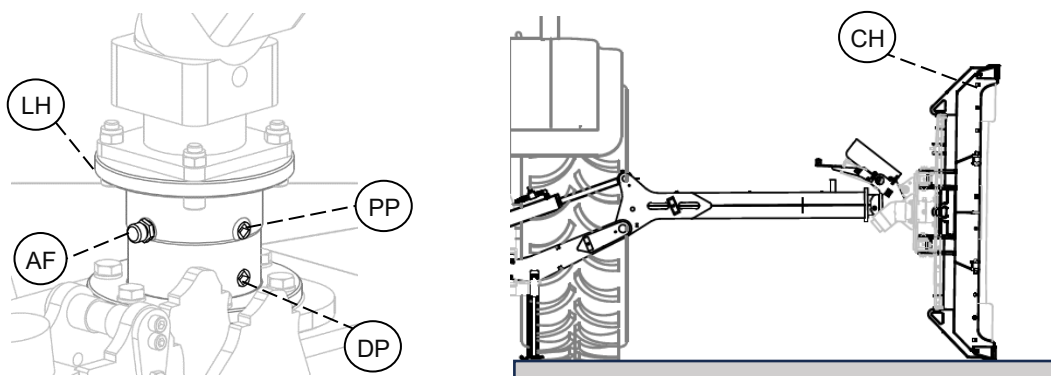
Picture.34

### 4.9 Changing the oil and maintaining the bearing housing - the cutting head

Angle the cutting head up vertically (**CH**) so that it supports against the ground, open plugs (**DP**) and (**PP**) to drain oil – see Picture.35. Angle the mowing head down horizontally toward the ground, screw in the plug (**DP**), open the breather plug (**AF**). Use a suction syringe to push the oil through the level plug (**PP**) G3/8, until the oil is pushed out through the opening of the (**AF**) plug. Reassembling Plugs (**AF**) and (**PP**) – See Picture.35.

When replacing, about **0.4l** of oil is required.

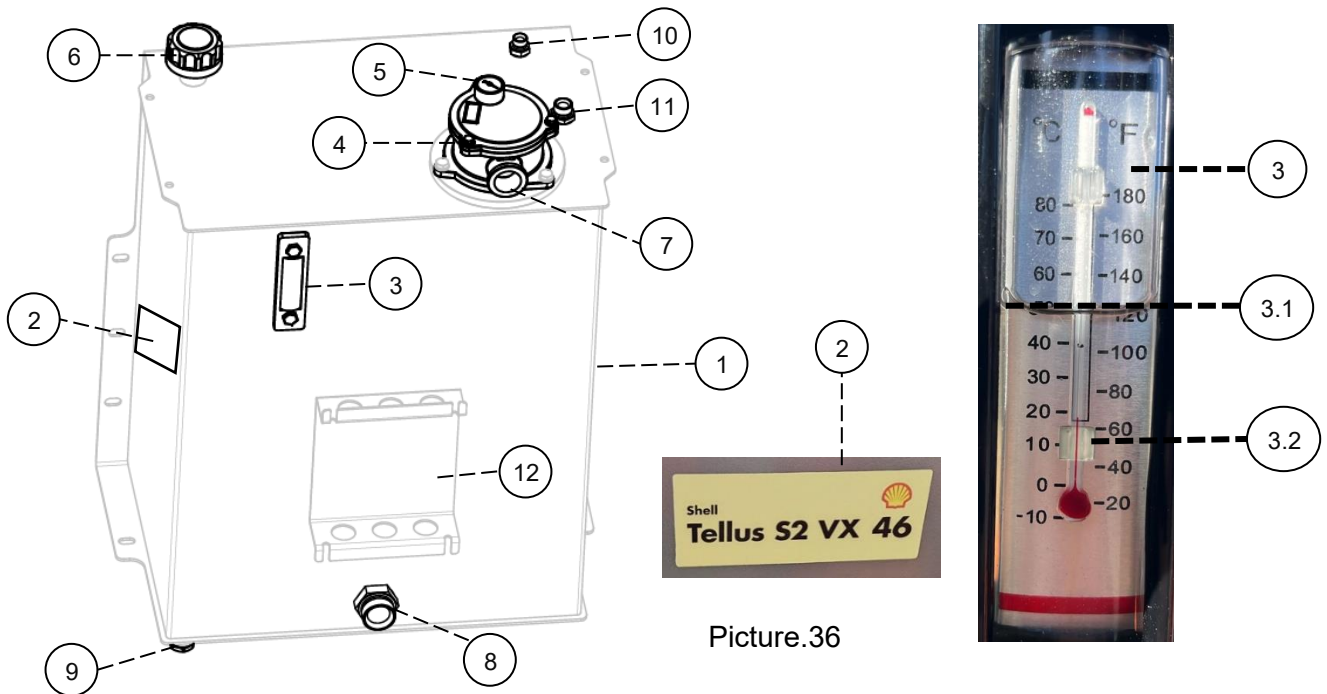
TREJON recommends oil type **ISO VG 220 API GL4/GL5**.



Picture.35

### 4.10 Oil Level and Oil Temp Check - Hydraulic Oil Tank

On the oil tank there is a sticker (2) that shows the type of oil that is filled. Oil tank (1) is equipped with level glass (3) integrated with thermometer. Oil tank consists of, among other things: oil tank base (1), decal (2), level glass (3), return filter (4), pressure indicator (5), filler cap (6) G3/4, adapter (7 return-line), adapter (8 suction-line), magnetic plug (9) G3/4, drain-line motor (10) G1/2, drain-return-line pump (11) G3/4, console oil cooler (12).



Picture.36

**The oil level** should be in the middle (3.1) of the level glass (3) – see Picture.36. When filling oil, you must clean the surfaces around the filler to prevent dirt and debris from entering the tank.

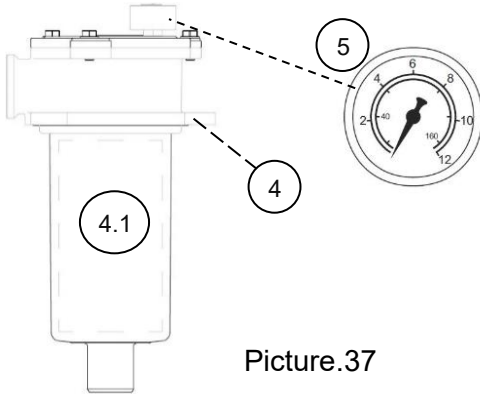
**You should never mix mineral oils with biological oils.** When changing oils, make sure that the oils are compatible with each other if you change brands.

**Oil temp**, thermometer (3.2) is built into level glass (3) – see Picture.36. It is important to check oil temperature. The oil temperature (3.2) can be read on a scale from -10°C° to +80°C. The oil temperature should NOT exceed 80 C°. At higher oil temperatures, close the tractor PTO and wait for the oil temperature to drop to 40–50°C.

**4.11 Oil change and maintenance – hydraulic oil tank.**

When replacing, about **170l** of oil is required . TREJON recommends oil type **Tellus S2 VX 46**.

The return filter (4) has a replaceable insert (4.1 – art.nr. **HR10035**) to be changed at all oil changes or when the pressure indicator (5) shows a maximum of 1.5 Bar – see Picture.37.



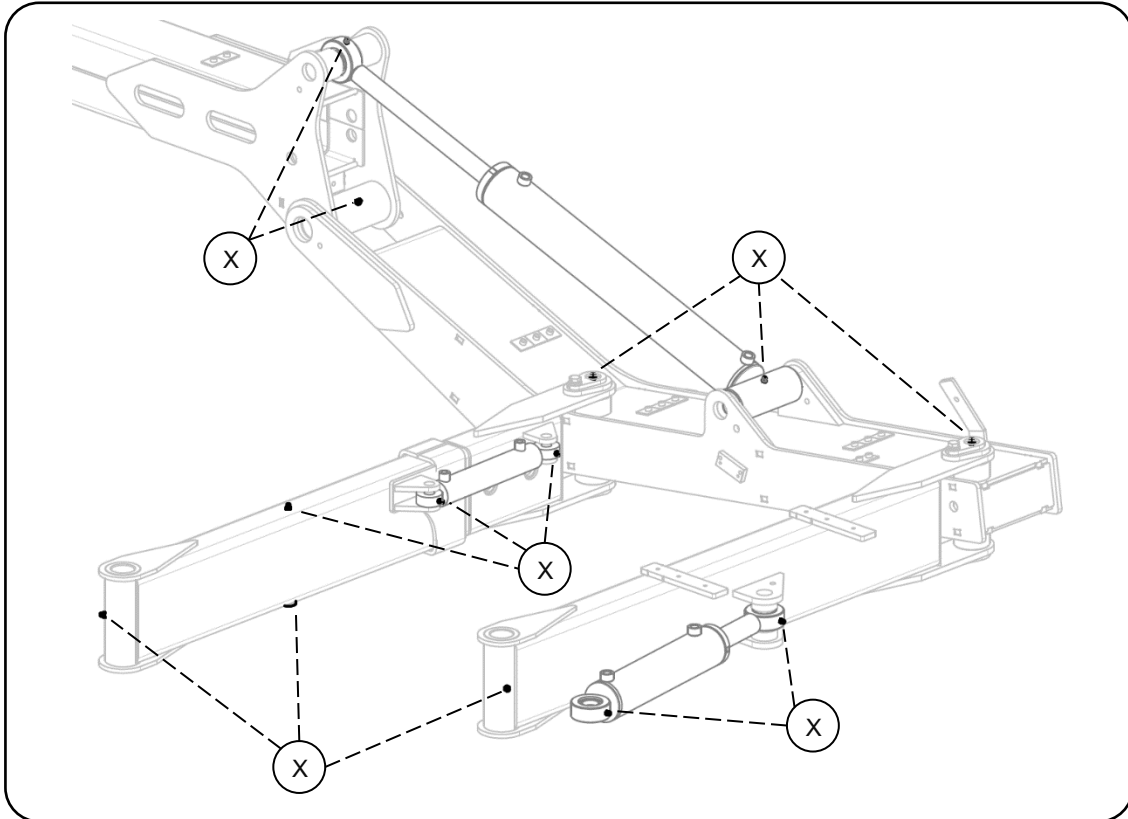
Picture.37

### 4.12 Lubrication Schedule

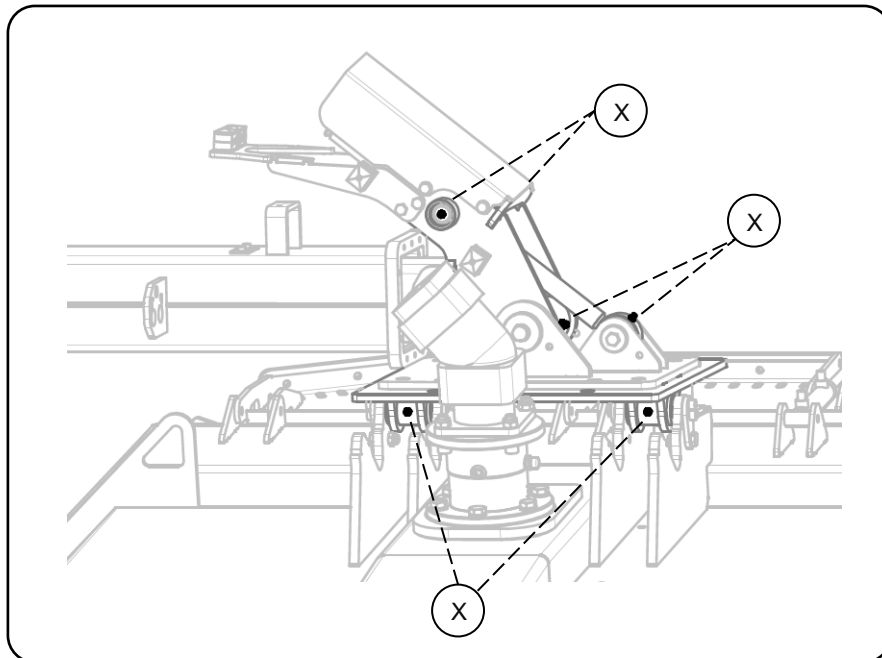
Nipples marked with (X) on Picture.38 and Picture.39 should be lubricated at 40-hour or weekly intervals. Pump the Grease into the pivot until it comes out at the side of the bearing, wiping off the excess.

Some well-known brands of Grease that can be used with advantage:

Shell - **SRS 4000**; Esso- **Thermo 30150**; Statoil - **Grease Way CAH92**; Hydro Texaco - **Hydex EP2**



Picture.38



Picture.39

## 5 Fault search

Problem	Probable cause	Action
Poor cutting results with chain mounted	Too low RPM on PTO Worn chain, missing links Too light chain in relation to vegetation Too high a working/travelling speed	Keep PTO at 540 RPM Change the chain or adjust the length. See section 3.9 Use 13mm in bushes/brushwood Choose a lower gear or keep the cutting head higher and drive several times.
Poor cutting results with knives mounted	Too low RPM on PTO Worn knives, missing knife Too heavy vegetation Too high a working/travelling speed	Keep PTO at 540 RPM Change the knives, check that both are fitted. See section 3.10 Use a chain instead. Select a lower gear or hold the cutting head higher and drive several times.
Vibration during operation	The chains are of different lengths Knives are missing or broken. Too large angle et PTO shaft	Adjust the chains so they are the same length. Assemble new blades. Lower the three-point on the tractor to reduce the angle of the cross head joints.
Jerky operation for the hydraulic movements at the chain mulcher	Incorrect oil flow from tractor Incorrectly calibrated joystick	See section 3.2.1 Calibrating the joystick, see section 3.4

## 6 Spare parts

### 6.1 Use original spare parts

You are faced with the choice between "original" or "copy"! The choice is often determined by the price. A "cheap" purchase can ultimately cost you dearly.

Some reasons for choosing TREJON original parts:

- Quality and fit
- Reliable Operation
- Higher service life and thus better economic operation
- Guaranteed availability through TREJON's sales partners

TREJON's original parts and accessories are designed specifically for these machines. The assembly and/or use of non-original parts and accessories can adversely alter the technical characteristics of your machine. The manufacturer does not provide any warranty for damage that occurs due to the failure to use original parts or accessories.

The warranty does not apply to arbitrary modifications made to the machine.



Contact the dealer where you bought the machine, when you need to order spare parts or need other service.

When ordering spare parts, always find out the correct model, type and serial number see the machine plate located on the chassis.

## 7 EC certificate of conformity



### EC certificate of conformity

according to EC standard 2006/42/EC

TREJON FÖRSÄLJNINGS AB

SE – 911 35 Vännäsby, Företagsvägen 9

(Full Company Address - In case of affiliated partners with registered office within the EC, the manufacturer's company name and address are also stated)

declare with sole responsibility that the following product,

Chain mulcher  
Trejon Optimal M1650 Storm

(make, type)

for which this certificate applies, complies with the current basic safety and health protection regulations in accordance with EC Standard 2006/42 / EC,  
(if applicable)  
and also meets the requirements of other applicable EC standards.

The following standard(s) and/or technical specification(s) have provided the basis for the professional introduction of the safety and health regulations set out in the EC standards:

EN ISO 12100-1 : 2010      EN ISO 12100-2 : 2010

(



Henrik Johansson  
CEO

Vännäsby, 01.05.2024

Issued (place/date)

(Name, position and signature of authorised employee)

## 8 Warranty certificate / Proof of transfer

### Guarantee- /assignment certificate

- Guarantee terms** - Valid between retailer (Trejon AB dealer) and machine purchaser.
- General about guarantee** - In order to obtain valid guarantee terms set forth below, and the specific guarantee terms set by each provider. These are attached to the user manual for each machine, as appropriate.
- Validity of guarantee** - The guarantee is 12 months from date of purchase.  
In some cases, the guarantee can be limited by running time.
- The guarantee covers** - Damaged parts, which have broken down because of defective production operations of materials in course of normal use of the machine.  
- Only the labor cost for replacement of defective warranted part.
- The guarantee does not cover** - Transport costs applicable to the machine or the parts.  
- Travel costs.  
- Any resulting costs incurred as a result of damage to the machine.  
- If the machine has been modified by the owner.  
- Damage due to normal wear and tear of the machine – Not related to manufacturing defects, poor service, user inexperience or use of spare parts that are not original.  
- Excessive or inappropriate use of the machine.  
- The guarantee is not applicable to parts which are subject to wear, for example hoses, sealing, oil, belts, batteries, chains, knives etc.  
- The guarantee period for replaced parts during the guarantee period expires with the machine's guarantee.  
- Normal adjustments, maintenance or supervision
- Guarantee procedures** - Contact place of purchase as soon as any damage or malfunction is detected.  
Do not use the machine if the damage can be worse.  
- Guarantee repairs must be performed by Trejon AB approved workshop.

**ATTENTION!** The guarantee shall enter into force provided that the machine **GUARANTEE/ ASSIGNMENT CERTIFICATE** has been fully completed and signed by both parties (archived by the seller), and recorded on the Trejon web portal no later than 14 days from date of sale (the seller is responsible for this happening).

**Assignment certificate:**

Machine Buyer shall confirm with his signature that he had received manual containing operating instructions, and received information about the operating, security and maintenance requirements described in this and made the final inspection of the machine.



PLEASE FILL IN!

Product: \_\_\_\_\_ Serialno. \_\_\_\_\_

Salesman: \_\_\_\_\_ Company: \_\_\_\_\_

Signature of salesman: \_\_\_\_\_ Date of purchase: \_\_\_\_\_

Name of buyer: \_\_\_\_\_ Telephone: \_\_\_\_\_

E-mail: \_\_\_\_\_

Address: \_\_\_\_\_ Zipcode: \_\_\_\_\_

City: \_\_\_\_\_ Country: \_\_\_\_\_

Date: \_\_\_\_\_ Signature of buyer: \_\_\_\_\_

*We store personal data, see our privacy policy: <https://www.trejon.se/enu/Dataskyddspolicy/>*

TREJON AB reserves the right to modify or improve shown models with technical or commercial motivations without the requirement to carry out the same modifications on machines already delivered. Illustrations in this Instruction Manual do not necessarily show the machine that has been delivered.

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