Extreme Duty Brush Cutter
(Open front High Flow)
Operation and Maintenance Manual
Jan 2016 and newer High Flow Models
26 to 40 GPM

MAKE SURE TO REGISTER YOUR WARRANTY WITHIN 30 DAYS OF PURCHASE.
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Publication Date: December 2019
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

Document History
The table below lists all revisions of the Brush Cutter Operation and Maintenance Manual.

<table>
<thead>
<tr>
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<th>Summary of Changes</th>
<th>Publication Date</th>
</tr>
</thead>
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<tr>
<td>First publication</td>
<td>First revision</td>
<td>1/1/2016</td>
</tr>
<tr>
<td></td>
<td>Warranty Revision</td>
<td>1/1/2019</td>
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Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

About this Manual
This manual contains information about the usage and maintenance required for the equipment. This document must be available for review by the operator before using the attachment to ensure proper safety, maintenance, and usage.

Hazard Notices Used in this Manual
The following hazard notices are used in this document:

**NOTE**: Notes are used to indicate important information. This information may be repeated in other areas of the manual.

**CAUTION**: Cautions are used to indicate a potentially hazardous situation, which, if not avoided, may result in damage to the equipment or other property.

**WARNING**: Warnings are used to indicate a potentially hazardous situation, which, if not avoided, could result in serious injury or death.

**DANGER**: Danger is used to indicate a potentially hazardous situation, which, if not avoided, will result in serious injury or death.

Terminology

**Prime Mover**: The Brush Cutter can be attached to many different pieces of equipment; therefore, the term “prime mover” will be used. A prime mover is any equipment, tractor, or skid steer providing power to the attachment.

Safety

**Safety Notices**
Before operating or conducting maintenance on this equipment, it is important to wear proper protection. Recommended safety equipment when operating and maintaining includes earplugs, eye protection, and a hard hat.

**NOTE**: Additional safety equipment may be required depending on the operating environment and worksite conditions.

Only qualified and trained personnel should operate, maintain, and service this attachment. Blue Diamond recommends that you inspect this equipment regularly for leaks, cracks, or other conditions that may impair proper usage of the equipment. Verify that all repairs have been completed and inspected prior to using the attachment under load.

It is the responsibility of the user to follow all local, state, and federal safety regulations. Improper use of this equipment may result in personal injury, property damage, and/or damage to the equipment.

**NOTE**: Fasten the safety chain to your machine with very little slack.

**DANGER**: DO NOT RAISE THE BACK OF THE CUTTER MORE THAN 12” OFF THE GROUND WHILE OPERATING THE ATTACHMENT. RAISING THE CUTTER DURING OPERATION MAY RESULT IN SERIOUS INJURY OR DEATH. BE AWARE OF YOUR SURROUNDINGS AS DEBRIS CAN BE THROWN FAR. ALWAYS WORK AWAY FROM PERSONS OR DAMAGEABLE PROPERTY.
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

**Modifications to Equipment**
Any modifications made to this equipment may void any warranty and relieve the manufacturer of liability of any resulting injury or damage.

**About the Brush Cutter Attachment**
The Brush Cutter attachment is intended for use as a brush cutting and clearing tool. The primary use of the Brush Cutter attachment includes land clearing, and grounds maintenance. Use of this equipment in any other manner is considered to be contrary to the intended use of the attachment.

**Extreme Duty Brush Cutter (open front high flow)**
This aggressive cutter will allow a faster travel speed with increased cutting capabilities. The Extreme Brush Cutter features four swing-away blades and ultra-rugged construction. Cuts up to 5" trees and discharges very well for heavy grass cutting. The four-blade system, ultra-heavy construction and direct drive, combined with a protected reversible motor, allow you to cut the thickest brush with confidence. The larger capacity means less time in the field and cost savings in both time and energy.

The Brush Cutter attachment is vital in the land clearing, and grounds maintenance industries.

*Figure 1 – Extreme Duty Brush Cutter (open front)*
Attaching the Brush Cutter to the Prime Mover

**NOTE:** Before attempting to attach the Brush Cutter to the prime mover, verify that all hydraulic couplings are compatible.

**WARNING:** Improper attachment to the prime mover may cause personal injury.

**CAUTION:** All hydraulic connections must be clean and free of debris before making any connection.

1. Place the Brush Cutter attachment on a level surface.
2. Position and align the prime mover to the rear of the attachment, within proximity of the front of prime mover.
3. Insert and connect the prime mover into the attachment.
4. Connect the hydraulic lines from the attachment to the prime mover.
5. Close latches (or other locking mechanism) to secure the attachment to the prime mover.
6. Using the prime mover, raise the attachment and move the attachment to ensure hydraulic lines are clear of air and operate properly.

**CAUTION:** Hydraulics should operate in an even and smooth manner. Hydraulic movement that is not even and smooth may indicate that air is in the hydraulic lines.

7. Lower the attachment to ground level.
8. Inspect that the attachment is mounted properly and securely. If the attachment does not meet this requirement, follow the instructions to remove the Brush Cutter and re-attach using the instructions above.

Removing the Brush Cutter from the Prime Mover

**WARNING:** Improper disconnection may result personal injury or damage to the attachment and prime mover.

**CAUTION:** All hydraulic connections must be clean and free of debris before disconnection.

1. Using the prime mover, lower the attachment to the ground.
2. To prevent contamination, remove any dirt and debris from the couplings. Disconnect the hydraulic connection between the attachment and the prime mover.

**NOTE:** Hydraulic connections must be disconnected before disengaging latches to prevent damage to the prime mover or the attachment.

3. Disengage the prime mover latches (or other locking mechanism) from the attachment.
4. Move the prime mover from the attachment.
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

Brush Cutter Operation

- Operate this attachment with a prime mover with an enclosed cab with safety glass in front door.
- Wear proper safety equipment as required by working conditions and local, state, and Federal laws.
- Never operate the Brush Cutter within 300 feet of people, animals, or damageable property. Clear the area of objects that could become projectiles, such as rocks, bottles, and construction debris.
- Be sure you are operating within the hydraulic flow rating of this attachment. Contact your dealer or Blue Diamond Attachments if you are uncertain. The High flow Model has a max flow of 40 GPMs. Operation over this can cause serious injury and damage to the Attachment.
- Never operate the Brush Cutter with the back more than 12” off the ground or where your view is obstructed.
- Never operate the Brush Cutter with any guards removed, including the motor cover.
- Never operate the Brush Cutter without the safety chain securely fastened to your machine.
- Disengage the Brush Cutter and shut off the engine before leaving the cab of your machine.
- Do not place hands or feet near the Brush Cutter while the machine is running.

**DANGER:** Keep all body parts away from the Brush Cutter when in use.

<table>
<thead>
<tr>
<th>Eye and Ear Protection:</th>
<th>To help ensure your safety as a designated operator wear eye and ear protection.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety Helmet:</td>
<td>To help ensure your safety as a designated operator wear a safety helmet.</td>
</tr>
</tbody>
</table>
Equipment Inspection Schedule

We recommend that you inspect the equipment for damage and wear before use. Use the following list as a guideline during equipment inspection.

**WARNING:** Do not use hands to check for hydraulic leaks. Keep body parts away from leaking hydraulic lines and couplings that are under pressure.

**NOTE:** Shut off the prime mover and disengage the Brush Cutter before performing any maintenance.

Daily Inspection

Inspect the Brush Cutter by performing a walk around daily before and after use. Use the following inspection checklist as a guideline.

- After the Brush Cutter has been attached, check that all latches or locks are closed.
- Check that all hydraulic fittings are tight and free of leaks.
- Check that all hydraulic lines are free of leaks, holes, or cracks. Replace as required.
- Check all hardware connections to the prime mover for damage or fatigue such as cracks or other structural flaws.
- Inspect the safety chain for damage.
- Inspect blades and bolts for wear, damage, and loosening.
- Check for wire or debris under the deck, remove any present.
- Check that all guards and safety equipment are in good condition.

Weekly Inspection (40 hours of use)

- Check blade bolts for correct torque (1,440 foot/pounds)
- Check all bolts for tightness. 3/8” bolts 50 foot/pounds and ½” bolts 100 foot/pounds
- 5/8” bolts to
- Inspect the deck for cracks, bends, or damage.
- Inspect discharge chains and replace any missing or broken chains.

Monthly Inspection

- Inspect the blades for cracks, bends, or excessive wear.
- Check skid plates for wear.
- Check that all bolts are tight.

250 Hour Maintenance

- Remove motor hood and grease drive unit using Shell Gadus red lithium S5 V100 2 grease ... or equivalent. 5 to 10 pumps.
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

Inspection Checklist

☐ Are all safety notices and warning stickers in proper locations and visible?
☐ Are all safety guards properly installed and in good condition?
☐ Are there any visible hydraulic leaks?
☐ Is there any wire or vines wound under the deck?
☐ Are any cracks visible in Brush Cutter structure?
☐ Are the blades worn, bent, or broken?
☐ Has all debris been removed from the deck and motor area?
☐ Has the prime mover been properly inspected for hydraulic leaks and proper tire inflation?
☐ Has the prime mover been properly maintained?
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

Detailed Parts List

Figure 2 – Extreme Duty Brush Cutter Exploded View
# Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

## Table 1 - Parts List – Extreme Duty Brush Cutter

<table>
<thead>
<tr>
<th>Item Number</th>
<th>Description</th>
<th>Part No.</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Deck weldment 60”</td>
<td>203500</td>
<td>1</td>
</tr>
<tr>
<td>1</td>
<td>Deck weldment 72”</td>
<td>203505</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>Discharge chain (4 link)</td>
<td>203045</td>
<td>42</td>
</tr>
<tr>
<td>3</td>
<td>Hydraulic motor 11.2 cubic in. for 72”</td>
<td>203703</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>Hydraulic motor 6.0 cubic in. for 60”</td>
<td>203763</td>
<td>1</td>
</tr>
<tr>
<td>Not shown</td>
<td>Inspection cover</td>
<td>203008</td>
<td>1</td>
</tr>
<tr>
<td>Not shown</td>
<td>Inspection cover bolts</td>
<td>203009</td>
<td>2</td>
</tr>
<tr>
<td>Not shown</td>
<td>Motor cover</td>
<td>203007</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>Pivot bolt</td>
<td>203035</td>
<td>3 or 4</td>
</tr>
<tr>
<td>8</td>
<td>Housing nuts</td>
<td>*</td>
<td>6</td>
</tr>
<tr>
<td>17</td>
<td>Blade double edged stamped 4”</td>
<td>203027</td>
<td>3 or 4</td>
</tr>
<tr>
<td>19</td>
<td>Motor cover bolts</td>
<td>203006</td>
<td>6</td>
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<tr>
<td>20</td>
<td>Safety chain and clevis</td>
<td>203048</td>
<td>1</td>
</tr>
<tr>
<td>22</td>
<td>Motor to hose fitting</td>
<td></td>
<td>1</td>
</tr>
<tr>
<td>23</td>
<td>Hydraulic hose kit</td>
<td>203037</td>
<td>2</td>
</tr>
<tr>
<td>24</td>
<td>Hydraulic coupler male</td>
<td>224012</td>
<td>1</td>
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<tr>
<td></td>
<td>Note: these may be changed to fit machine specific coupler</td>
<td></td>
<td></td>
</tr>
<tr>
<td>25</td>
<td>Hydraulic coupler female</td>
<td>224011</td>
<td>1</td>
</tr>
<tr>
<td></td>
<td>Note: these may be changed to fit machine specific coupler</td>
<td></td>
<td></td>
</tr>
<tr>
<td>30</td>
<td>Direct drive housing</td>
<td>*</td>
<td>1</td>
</tr>
<tr>
<td>31</td>
<td>Direct drive shaft (spindle)</td>
<td>*</td>
<td>1</td>
</tr>
<tr>
<td>32</td>
<td>Bearing upper</td>
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<tr>
<td>34</td>
<td>Drive bearing</td>
<td>*</td>
<td>1</td>
</tr>
<tr>
<td>36</td>
<td>Lower bearing seal</td>
<td>*</td>
<td>1</td>
</tr>
<tr>
<td>37</td>
<td>Motor flange</td>
<td>*</td>
<td>1</td>
</tr>
<tr>
<td>38</td>
<td>Blade carrier 60”</td>
<td>203043</td>
<td>1</td>
</tr>
<tr>
<td>38</td>
<td>Blade carrier 72”</td>
<td>203040</td>
<td>1</td>
</tr>
<tr>
<td>39</td>
<td>Chain retainer bar 60”</td>
<td>203050</td>
<td>1</td>
</tr>
<tr>
<td>39</td>
<td>Chain retainer bar 72”</td>
<td>203055</td>
<td>1</td>
</tr>
<tr>
<td>40</td>
<td>Flange bolt (star head)</td>
<td>203167*</td>
<td>6</td>
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<tr>
<td>41</td>
<td>Housing bolts</td>
<td>*</td>
<td>6</td>
</tr>
<tr>
<td>42</td>
<td>Blade carrier bolts</td>
<td>299454*</td>
<td>10</td>
</tr>
<tr>
<td>43</td>
<td>Direct drive assembly</td>
<td>*</td>
<td>1</td>
</tr>
</tbody>
</table>

*see page 12 for drive parts

* After 2/2017 mount changed. Newer models use 4ea 203169
### Figure 3 – Extreme Direct Drive Exploded View

<table>
<thead>
<tr>
<th>Item Number</th>
<th>Description</th>
<th>Part No.</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>17</td>
<td>Hydraulic motor 11.2 cid for 72&quot;</td>
<td>203703</td>
<td>1</td>
</tr>
<tr>
<td>16</td>
<td>Motor to drive flange</td>
<td>203155</td>
<td>1</td>
</tr>
<tr>
<td>15</td>
<td>Direct drive spindle nut, upper</td>
<td>203090</td>
<td>1</td>
</tr>
<tr>
<td>14</td>
<td>Direct drive star lock washer</td>
<td>203100</td>
<td>1</td>
</tr>
<tr>
<td>13</td>
<td>Direct drive lock ring</td>
<td>203095</td>
<td>1</td>
</tr>
<tr>
<td>12</td>
<td>Direct drive spindle nut, lower</td>
<td>203105</td>
<td>1</td>
</tr>
<tr>
<td>11</td>
<td>Direct drive bearing and race (upper)</td>
<td>203075</td>
<td>1</td>
</tr>
<tr>
<td>10</td>
<td>Grease zerk</td>
<td></td>
<td>1</td>
</tr>
<tr>
<td>Not shown</td>
<td>Housing bolt ¾”</td>
<td>203056</td>
<td>6</td>
</tr>
<tr>
<td>Not shown</td>
<td>Housing nut ¾” (included with bolt)</td>
<td></td>
<td>6</td>
</tr>
<tr>
<td>7</td>
<td>Lower bearing seal</td>
<td>203086</td>
<td>1</td>
</tr>
<tr>
<td>8</td>
<td>Lower bearing and race</td>
<td>203074</td>
<td>1</td>
</tr>
<tr>
<td>9</td>
<td>Direct Drive housing</td>
<td></td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>Upper bearing seal protector</td>
<td>203134</td>
<td>1</td>
</tr>
<tr>
<td>2/3</td>
<td>Lower bearing seal protector (bushing and bolt)</td>
<td>203914</td>
<td>5</td>
</tr>
<tr>
<td>1</td>
<td>Direct drive spindle</td>
<td>203066</td>
<td>1</td>
</tr>
<tr>
<td>Not shown</td>
<td>Spindle seal retention ring</td>
<td>203087</td>
<td>1</td>
</tr>
</tbody>
</table>
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

Table 2 - Parts List – Extreme Direct Drive
*only used in early models

Warning Decal Placement

Table 3 - Parts List - Warning Decals

<table>
<thead>
<tr>
<th>#</th>
<th>Part Name</th>
<th>Description</th>
<th>Part No.</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Warning Decal</td>
<td>High Pressure Fluid Hazard</td>
<td>BD-01</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>Warning Decal</td>
<td>Read Owner’s Manual Before Operating</td>
<td>BD-02</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>Warning Decal</td>
<td>Do Not Operate Without Safety Chain In Place</td>
<td>BD-03</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>Warning Decal</td>
<td>Warning Keep Hands And Feet Away</td>
<td>BD-04</td>
<td>4</td>
</tr>
<tr>
<td>5</td>
<td>Warning Decal</td>
<td>DANGER Debris Discharge Area Stay Back 50 Feet</td>
<td>BD-05</td>
<td>1</td>
</tr>
</tbody>
</table>

Table 4 – Warning Stickers

<table>
<thead>
<tr>
<th>Warning Decal 1</th>
<th>Warning Decal 2</th>
<th>Warning Decal 3</th>
<th>Warning Decal 4</th>
<th>Warning Decal 5</th>
</tr>
</thead>
</table>
Manufacturer’s Limited Warranty

BLUE DIAMOND ATTACHMENTS, a manufacturer of quality attachments, warrants new BLUE DIAMOND ATTACHMENTS products and/or attachments at the time of delivery to the original purchaser, to be free from defects in material and workmanship when properly set up and operated in accordance with the recommendations set forth by BLUE DIAMOND ATTACHMENTS, LLC.

BLUE DIAMOND ATTACHMENTS liability for any defect with respect to accepted goods shall be limited to repairing the goods at a BLUE DIAMOND ATTACHMENTS designated location or at an authorized dealer location, or replacing them, as BLUE DIAMOND ATTACHMENTS shall elect. The above shall be in accordance with BLUE DIAMOND ATTACHMENTS warranty adjustment policies. BLUE DIAMOND ATTACHMENTS obligation shall terminate twelve (12) months after the delivery of the goods to original purchaser.

This warranty shall not apply to any machine or attachment which shall have been repaired or altered outside the BLUE DIAMOND ATTACHMENTS factory or authorized BLUE DIAMOND ATTACHMENTS dealership or in any way so as in BLUE DIAMOND ATTACHMENTS judgment, to affect its stability or reliability, nor which has been subject to misuse, negligence or accident beyond the Company recommended machine rated capacity.

Warranty Claim

To submit a warranty claim, a return authorization from BLUE DIAMOND ATTACHMENTS must be obtained. The failed part may then be returned. Tampering with the failed part may void the warranty. This warranty does not include freight or delivery charges incurred when returning machinery for servicing. Dealer mileage, service calls, and pickup/delivery charges are the customers’ responsibility.

Exclusions of Warranty

Except as otherwise expressly stated herein, BLUE DIAMOND ATTACHMENTS makes no representation or warranty of any kind, expressed or implied, AND MAKES NO WARRANTY OF MERCHANTABILITY IN RESPECT TO ITS MACHINERY AND/OR ATTACHMENTS ARE FIT FOR ANY PARTICULAR PURPOSE. BLUE DIAMOND ATTACHMENTS shall not be liable for incidental or consequential damages for any breach or warranty, including but not limited to inconvenience, rental of replacement equipment, loss of profits or other commercial loss. Upon purchase, the buyer assumes all liability for all personal injury and property resulting from the handling, possession, or use of the goods by the buyer.

No agent, employee, or representative of BLUE DIAMOND ATTACHMENTS has any authority to bind BLUE DIAMOND ATTACHMENTS, LLC. to any affirmation, representation, or warranty concerning its machinery and/or attachments except as specifically set forth herein.

This warranty policy supersedes any previous documents.
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

Blue Diamond Attachments, a manufacturer of quality attachments, warrants new Blue Diamond Attachments products and/or attachments at the time of delivery to the original purchaser, to be free from defects in material and workmanship when properly set up and operated in accordance with the recommendations set forth by Blue Diamond Attachments, LLC. To file a warranty claim, please contact your nearest Blue Diamond Dealer or sales representative.

**Brush Cutters:**
The Blue Diamond Brush Cutters have a One(1) year parts and labor warranty policy. Dis-assembly of the cutter in any way, including the blade carrier, housing components, and/or motor, may void the warranty. Please contact Blue Diamond Attachments for instructions and authorization before taking apart to verify warranty.

**Augers:**
Warranty coverage on Blue Diamond Auger attachments is four(4) years on the Heavy Duty Series, and six(6) years on the Extreme Duty. Bent or Broken auger shafts are void from warranty. Coverage may be refused by Blue Diamond Attachments if the unit appears to have been abused or misused.

**Pallet Forks:**
Blue Diamond Pallet Forks have a one(1) year warranty. If the forks are put in an application where the weight that is lifted exceeds the fork rating, all warranty coverage will be voided.

**Grapples:**
All Grapples manufactured by Blue Diamond Attachments have a one(1) year warranty. Faulty cylinders are covered by warranty. Bent tines and/or bent hydraulic cylinders are not covered nor implied by warranty.

**Thumbs:**
Blue Diamond Thumbs have a one(1) year warranty on manufacturing defects, including weld cracks and leaking cylinders. Bent cylinders and/or bent tines/frame are not covered by warranty.

**Other Attachments:**
All other attachments that are not listed above, have a one(1) year warranty. This covers any manufacturing defect. Bent tines and/or bent cylinders are not covered. Any modification or alteration in any way may void the warranty on any piece. Blue Diamond Attachments, LLC reserves the right to decline any warranty claim at their digression.

**WARRANTY MAY BE VOIDED IF ATTACHMENT IS ALTERED IN ANY WAY**
(May weaken unit and cause damage)
Blue Diamond Extreme Duty Open Front Brush Cutter (High Flow)

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