

Parts Manual

HQ680

Tough Cut Mower
Serial Number HQ680-AD1902 --



Revised 10/06/22
09.20030 Rev. 03



500 Venture Drive
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www.ventrac.com

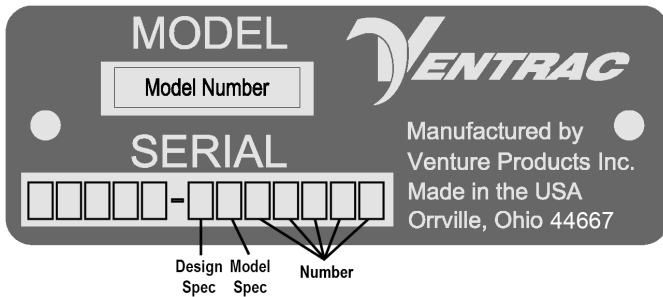
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Serial Number Description



Notes

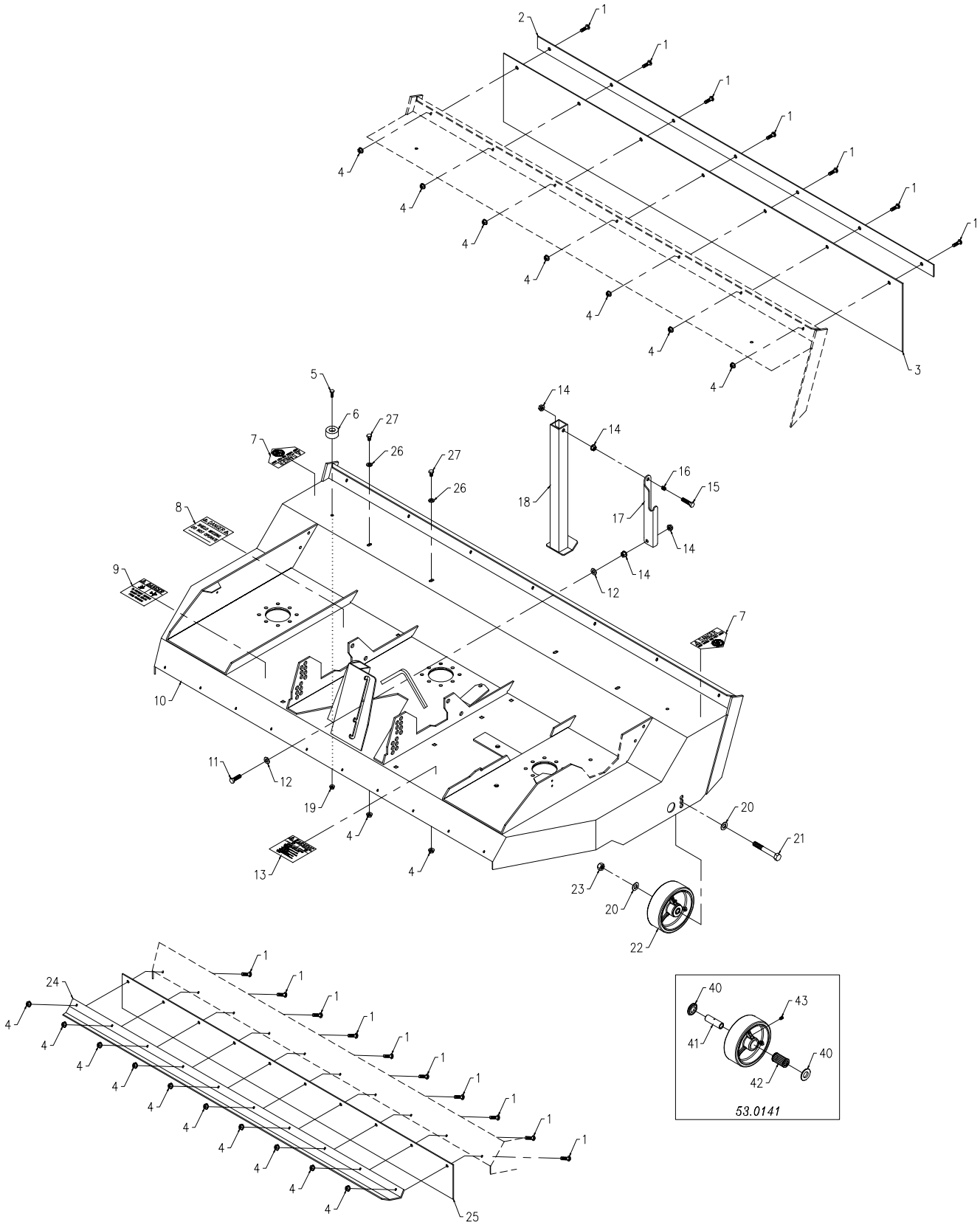
- If any component requires replacement, use only original Ventrac replacement parts.
- When ordering new components, be sure to order all required safety decals. All current safety decals must be affixed to the replacement components prior to installation of the component.

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PARTS

ILLUSTRATED DRAWING Main Deck



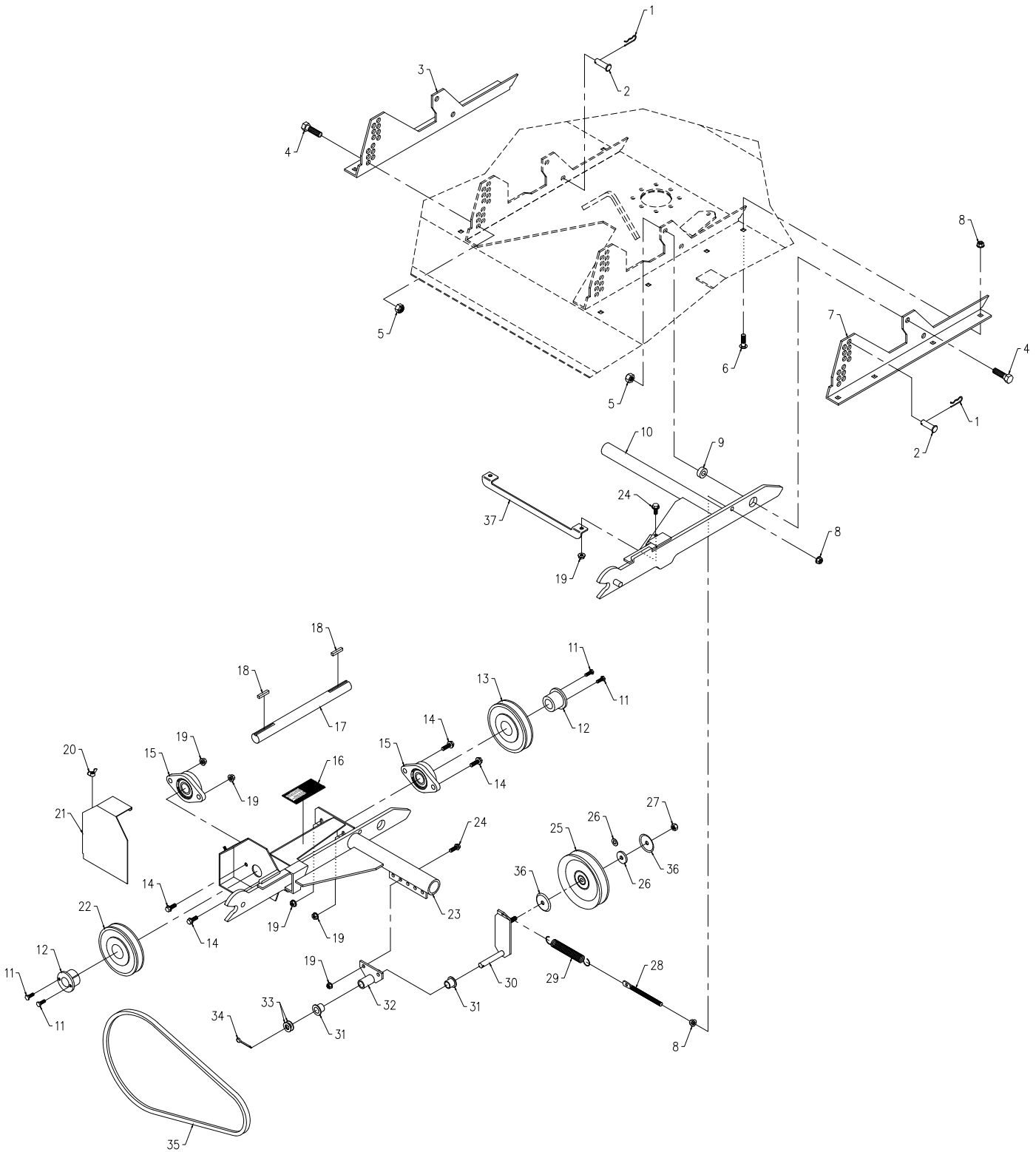
PARTS

Main Deck

REF.	PART NO.	DESCRIPTION	QTY.
1	97.0506	.BOLT, CARRIAGE 5/16 X 3/4	17
2	60.0793	.CLAMP, FRONT BELTING	1
3	44.0191	.BELTING, 1/8 X 10 X 67-1/2L	1
4	99.SF05	.NUT, SRF 5/16-18 USS	21
5	90.0406	.BOLT, 1/4-20 USS X 3/4	2
6	05.0095	.BUMPER, RUBBER CYLINDRICAL	2
7	00.0123	.DECAL, KEEP HANDS & FEET CLEAR (Serial # 1902-8321)	2
7	00.0628	.DECAL, CUTTING HAZARD - MOWER BLADE (Serial # 8322-)	2
8	00.0062	.DECAL, DANGER SHIELD MISSING (Serial # 1902-8321)	1
8	00.0625	.DECAL, SHIELD MISSING (Serial # 8322-)	1
9	00.0102	.DECAL, DANGER-PINCHING HAZARD (Serial # 1902-8321)	1
9	00.0620	.DECAL, PINCHING OR CRUSHING HAZARD (Serial # 8322-)	1
10	62.0897	.FRAME, MAIN DECK (Serial # 1902-7712)	1
10	62.1508	.FRAME, MAIN DECK (Serial # 7713-)	1
11	90.0610	.BOLT, 3/8-16 USS X 1 1/4	1
12	95.06	.WASHER, FLAT 3/8 SAE	2
13	00.0101	.DECAL, HAZARD-MOVING PART (Serial # 1902-8321)	1
13	00.0626	.DECAL, ENTANGLEMENT HAZARD (Serial # 8322-)	1
14	99.SF06	.NUT, SRF 3/8-16 USS	4
15	90.0612	.BOLT, 3/8-16 USS X 1 1/2	1
16	41.0039	.SPRING, COMP. 9/16 OD X 5/8	1
17	64.1114	.LATCH, JACK STAND HQ	1
18	62.1011	.STAND, JACK	1
19	99.SF04	.NUT, SRF 1/4-20 USS	2
20	95.08	.WASHER, FLAT 1/2 SAE	4
21	90.0828	.BOLT, 1/2-13 USS X 3 1/2	2
22	53.0141	.WHEEL, CASTER 6 X 2	2
23	99.A08	.LOCKNUT, STOVER 1/2-13 USS	2
24	60.0882	.CLAMP, BELT REAR HQ	1
25	44.0209	.BELTING, 1/8 X 5 X 56L	1
26	94.05	.WASHER, FLAT 5/16 USS (Serial # 3122-)	4
27	90.0504	.BOLT, 5/16-18 USS X 1/2 (Serial # 3122-)	4
40	55.0074	.BEARING, RETAINER 3/4"	2
41	85.B0089	.BUSHING, 1/2ID X 3/4OD X 2.406	1
42	55.0073	.BEARING, ROLLER 1-13/16" LONG	1
43	29.GF0001	.GREASE FTG, 1/4 SAE ST	1

PARTS

ILLUSTRATED DRAWING Hitch Arms & Drive Shaft



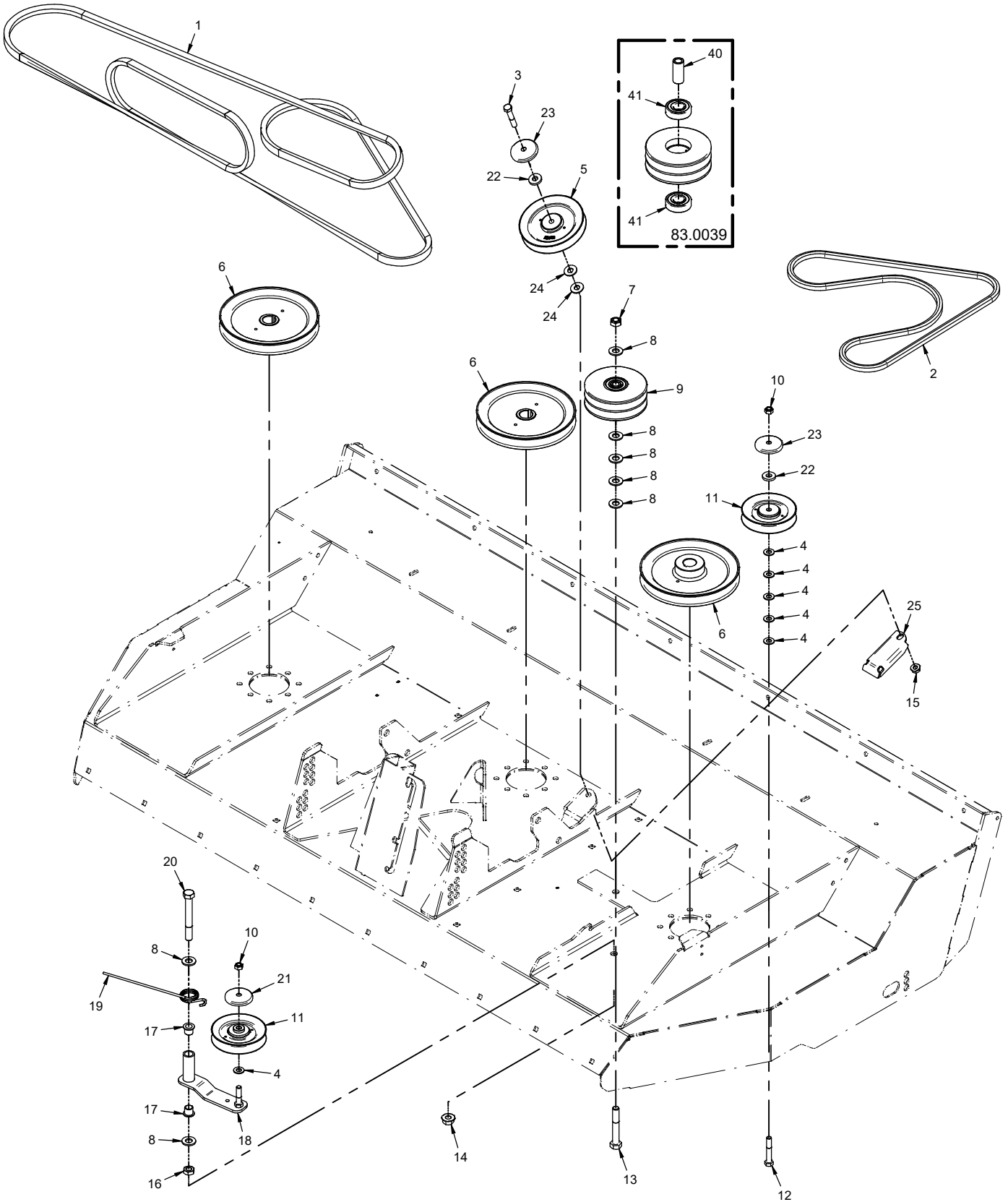
PARTS

Hitch Arms & Drive Shaft

REF.	PART NO.	DESCRIPTION	QTY.
1	02.HP0416	.HAIRPIN, 1/8 X 2	4
2	03.0810	.CLEVIS PIN, 1/2 X 1 1/4	4
3	60.0792	.PLATE, HITCH ARM MOUNT LEFT	1
4	90.0812	.BOLT, 1/2-13 USS X 1 1/2	4
5	99.A08	.LOCKNUT, STOVER 1/2-13 USS	4
6	97.0606	.BOLT, CARRIAGE 3/8 X 3/4	8
7	60.0791	.PLATE, HITCH ARM MOUNT RIGHT	1
8	99.SF06	.NUT, SRF 3/8-16 USS	10
9	85.SC08	.SET COLLAR, 1/2" (Serial # 1902-3281)	2
9	64.1901	.BUSHING, 1/2 X 1 X 1/2 (Serial # 3282-)	2
10	62.0898	.ARM, RIGHT HITCH	1
11	90.0406	.BOLT, 1/4-20 USS X 3/4	4
12	83.H16S-2	.BUSHING, 1" SPLIT 3/16&1/4 KEY	2
13	83.BK50H	.PULLEY, 5" H-BUSH	1
14	99.SF0508	.BOLT, SRF 5/16-18 USS X 1	4
15	55.FB16016-1	.BEARING, FLANGE BLOCK 1"	2
16	00.0217	.DECAL, WARNING READ OWNERS MAN (Serial # 1902-8321)	1
16	00.0619	.DECAL, READ OPERATOR'S MANUAL (Serial # 8322-)	1
17	80.0312	.SHAFT, TGP 1 X 15-3/8L JACK	1
18	85.K0410	.KEY, 1/4 X 1 1/4	2
19	99.SF05	.NUT, SRF 5/16-18 USS	8
20	99.E0004	.NUT, WING 1/4-20 USS	1
21	60.0665	.SHIELD, DRIVE PULLEY	1
22	83.BK55H	.PULLEY, 5.5" H-BUSHING	1
23	62.0899	.ARM, LEFT HITCH	1
24	99.SF0506	.BOLT, SRF 5/16-18 USS X 3/4	4
25	83.0031	.PULLEY, V-IDLER 5 1/16 X 3/8ID	1
26	95.06	.WASHER, FLAT 3/8 SAE (Serial # 1902-2121)	1
26	99.G0014	.WASHER, 3/8 USS FW .165 THK (Serial # 2122-3781)	1
27	99.A06	.LOCKNUT, STOVER 3/8-16 USS	1
28	99.K0094	.BOLT, HANGER 3/8-16 X 4	1
29	41.0048	.SPRING, EXT. 1 OD X 6	1
30	40.0293	.ARM, MAIN IDLER	1
31	85.B0027	.BUSHING, 1/2 ID X 5/8 OD X 5/8	2
32	40.0291	.BRACKET, MAIN IDLER MOUNT	1
33	95.08	.WASHER, FLAT 1/2 SAE	2
34	02.CP0406	.COTTER PIN, 1/8 X 3/4	1
35	81.B045	.BELT, B45	1
36	60.1056	.COVER, PULLEY (Serial # 2122-)	2
37	42.0578	.LINK, SPACING - LIFT ARM (Serial # 3162-)	1

PARTS

ILLUSTRATED DRAWING Deck Belts & Pulleys



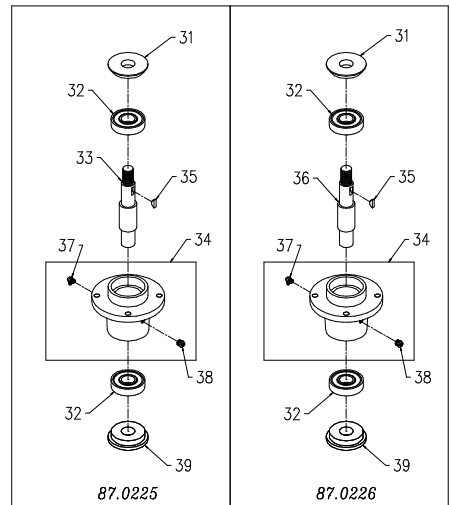
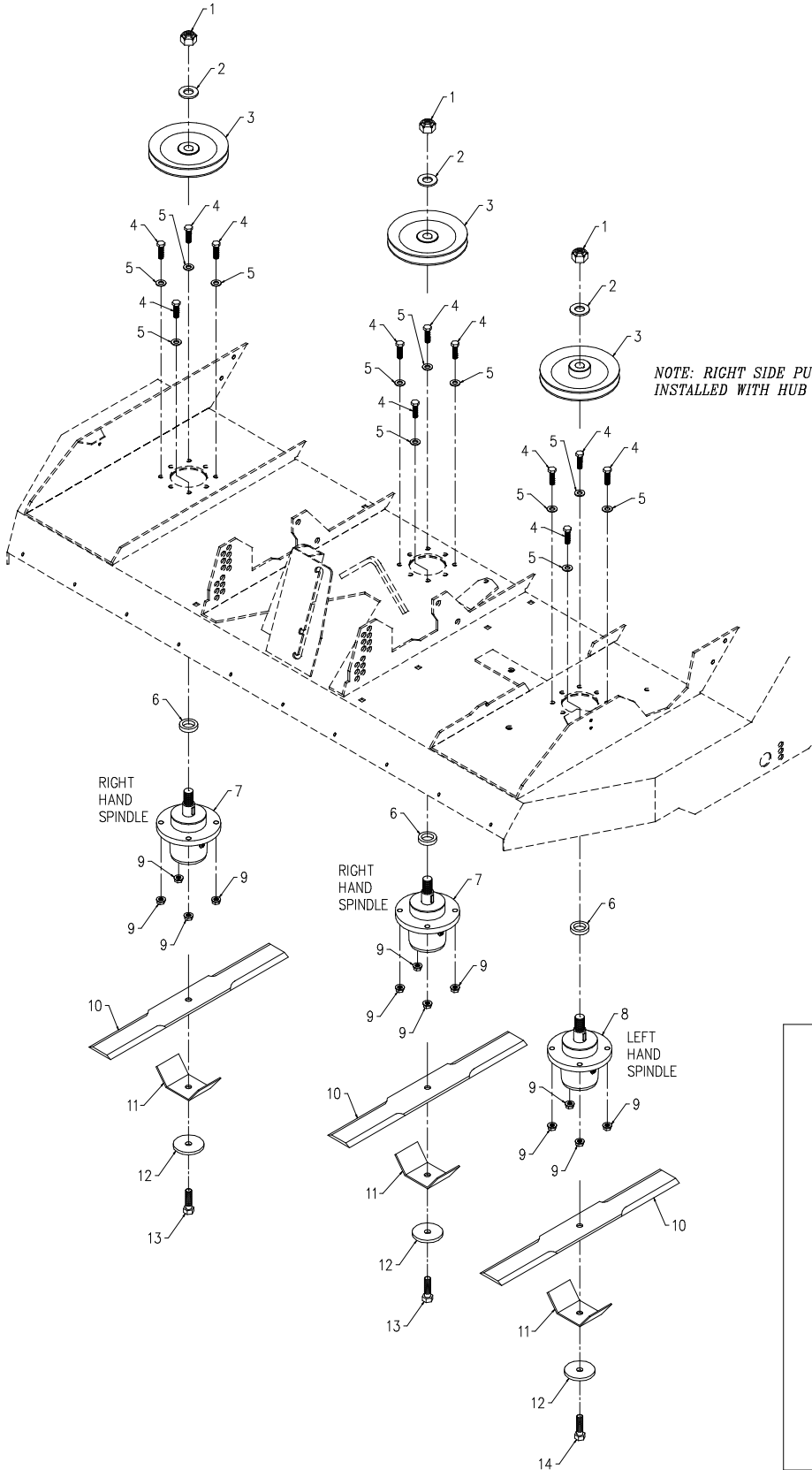
PARTS

Deck Belts & Pulleys

REF.	PART NO.	DESCRIPTION	QTY.
1	81.5002	.BELT, B162 CUSTOM	1
2	81.0166	.BELT, AA60 CUSTOM	1
3	90.0614	.BOLT, 3/8-16 USS X 1 3/4 (Serial # 1902-2121)	1
3	90.0616	.BOLT, 3/8-16 USS X 2 (Serial # 2122-)	1
4	95.06	.WASHER, FLAT 3/8 SAE	6
5	83.0031	.PULLEY, V-IDLER 5 1/4 X 3/8 ID	1
6	83.0052	.PULLEY, 7-1/2 25 MM STR BORE (Serial # 1902-2521)	3
6	83.0065	.PULLEY, 7-1/2 25 MM STR BORE (Serial # 2522-)	3
7	99.A08	.LOCKNUT, STOVER 1/2-13 USS	1
8	95.08	.WASHER, FLAT 1/2 SAE	7
9	83.0039	.PULLEY, IDLER 2 GROOVE ASM	1
10	99.A06	.LOCKNUT, STOVER 3/8-16 USS	2
11	83.0038	.PULLEY, V-IDLER 4-1/4 X 3/8 ID	2
12	90.0616	.BOLT, 3/8-16 USS X 2 (Serial # 1902-2121)	1
12	90.0618	.BOLT, 3/8-16 USS X 2-1/4 (Serial # 2122-)	1
13	90.0826	.BOLT, 1/2-13 USS X 3 1/4	1
14	99.SF08	.NUT, SRF 1/2-13 USS	1
15	99.SF06	.NUT, SRF 3/8-16 USS	1
16	99.E0058	.NUT, JAM 1/2-13 USS	1
17	85.B0027	.BUSHING, 1/2 ID X 5/8 OD X 5/8	2
18	40.0292	.ARM, RIGHT SIDE IDLER	1
19	41.0066	.SPRING, SINGLE TORSION LH	1
20	90.0832	.BOLT, 1/2-13 USS X 4	1
21	95.06	.WASHER, FLAT 3/8 SAE (Serial # 1902-2121)	1
21	60.1056	.COVER, PULLEY (Serial # 2122-)	1
22	95.06	.WASHER, FLAT 3/8 SAE (Serial # 1902-2121)	2
22	99.G0014	.WASHER, 3/8 USS FW .165 THK (Serial # 2122-3781)	2
23	60.1056	.COVER, PULLEY (Serial # 2122-)	2
24	94.06	.WASHER, FLAT 3/8 USS (Serial # 1902-7712)	4
24	94.06	.WASHER, FLAT 3/8 USS (Serial # 7713-)	2
25	HQ-1001	.PLATE, IDLER MOUNT (Serial # 7022-7712)	1
40	85.B0074	.BUSHING, DRIVE PULLEY	1
41	55.0042	.BEARING, BALL 20 MM X 47 MM	2

PARTS

ILLUSTRATED DRAWING Spindles & Blades



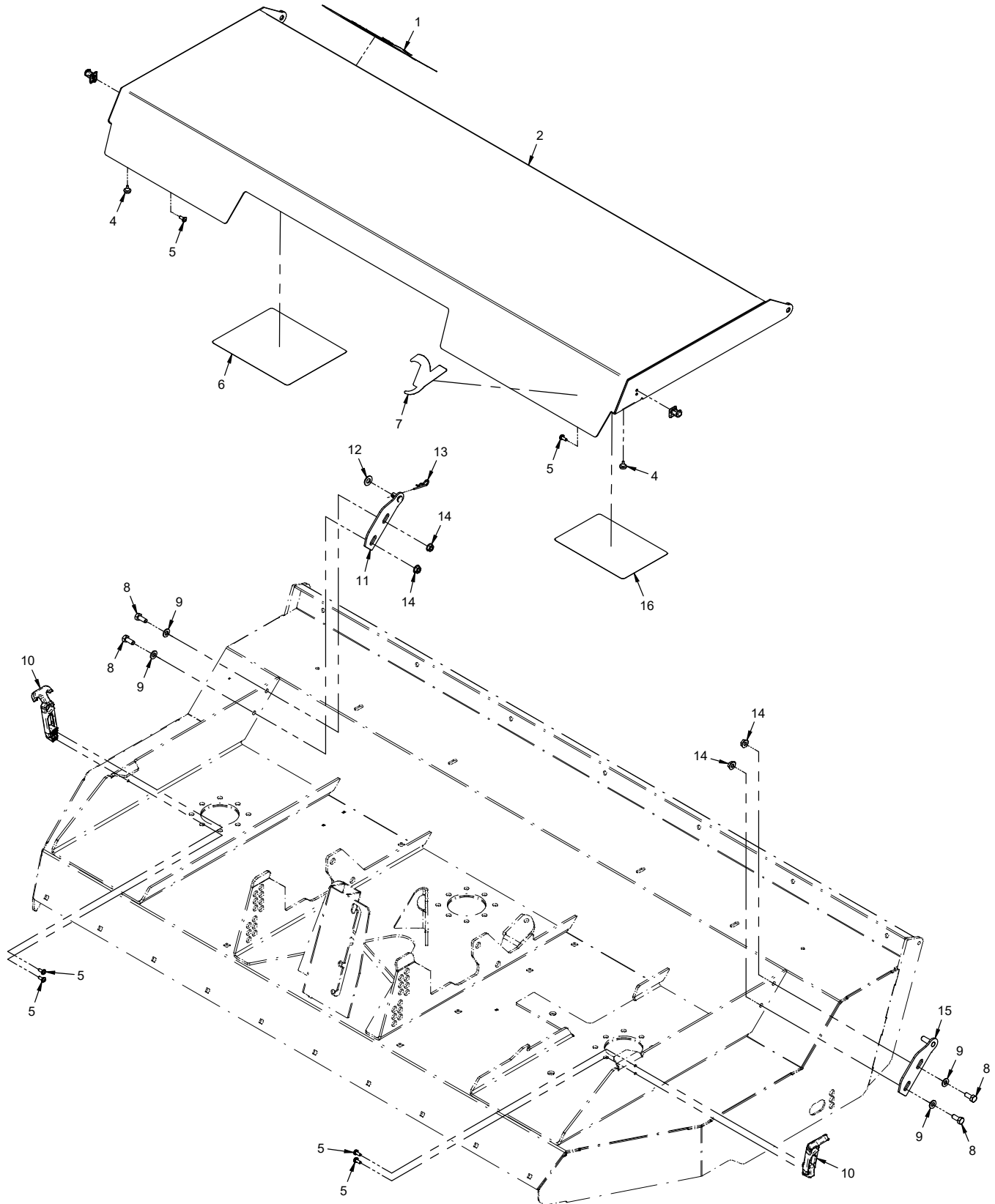
PARTS

Spindles & Blades

REF.	PART NO.	DESCRIPTION	QTY.
1	99.A12NF	.LOCKNUT, STOVER 3/4-16 SAE	3
2	99.B0057-2	.WASHER, MACH3/4 X1-1/4 10GA ZP	3
3	83.0052	.PULLEY, 7-13/16 25 MM STR BORE (Serial # 1902-2521)	3
3	83.0065	.PULLEY, 7-13/16 25 MM STR BORE (Serial # 2522-)	3
4	90.0612	.BOLT, 3/8-16 USS X 1 1/2	12
5	95.06	.WASHER, FLAT 3/8 SAE	12
6	85.B0080	.BUSHING, 1-1/2 OD, 1 ID	3
7	87.0225	.SPINDLE, ASM RH 25MM CI	2
8	87.0226	.SPINDLE, ASM LH 25MM CI	1
9	99.E0082	.NUT, LOCKING FLANGE 3/8-16	12
10	79.0048	.BLADE, 23.00X1/2 BD S FLAT	3
11	64.2002	.GUARD, SPINDLE/STRING WRAPPER	3
12	99.B0091	.WASHER, .510 ID X 2-1/2 OD 1/4	3
13	91.0814-8	.BOLT, 1/2-20 X 1 3/4 GR8	2
14	91.0814-8L	.BOLT, 1/2-20 X 1 3/4 LH GR8	1
31	87.0225-3	.SHIELD, SPINDLE TOP	1
32	55.0070	.BEARING, 30MM X 62MM X 16MM	2
33	87.0225-2	.SHAFT, SPINDLE RH	1
34	87.0225-1	.HOUSING, SPINDLE CI	1
35	85.W0406	.KEY, WOODRUFF 1/4 X 3/4	1
36	87.0226-2	.SHAFT, SPINDLE	1
37	29.GF0005	.GREASE FTG, 1/8 NPT 90	1
38	29.GF0017	.FITTING, RELIEF	1
39	87.0224-3	.SHIELD, SPINDLE BOTTOM	1

PARTS

ILLUSTRATED DRAWING Deck Cover



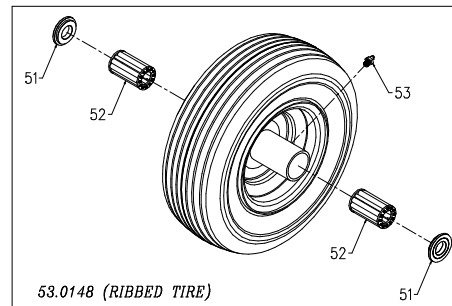
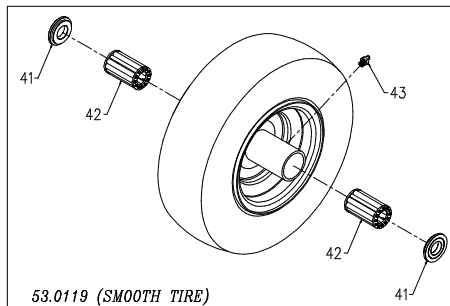
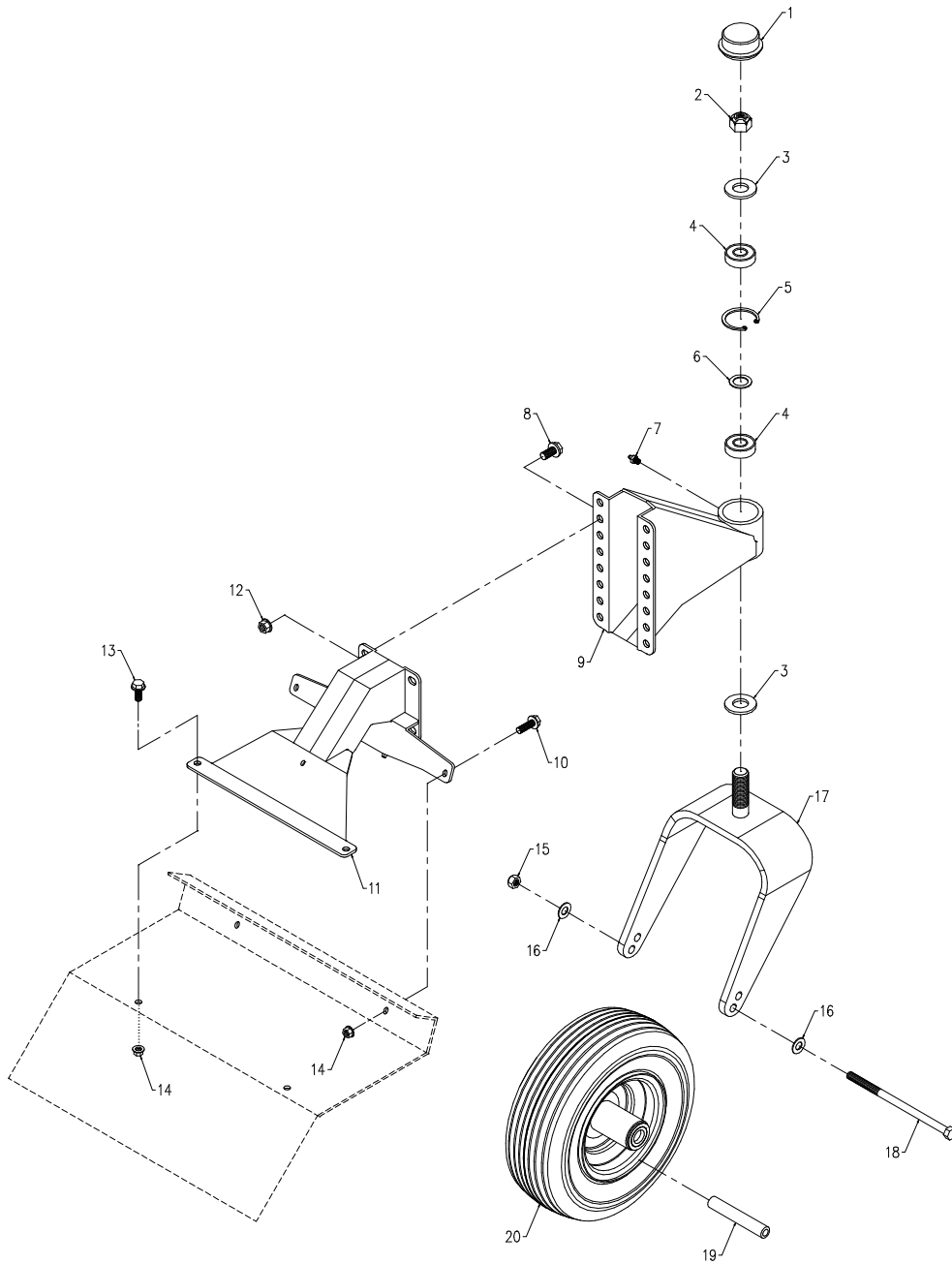
PARTS

Deck Cover

REF.	PART NO.	DESCRIPTION	QTY.
1	00.0189	.DECAL, VENTRAC ORBITAL	1
2	60.0949	.COVER, TOP DECK	1
4	05.0062	.BUMPER, NEOPRENE 18-12 GA	2
5	99.K0072	.MACHINE SCREW, 10-24 X 1/2 ZP	6
6	00.0543	.DECAL, MAINTENANCE HQ680 (belt diagram)	1
7	00.0192	.DECAL, V-DECAL DIE CUT BLUE	1
8	90.0506	.BOLT, 5/16-18 USS X 3/4	4
9	95.05	.WASHER, FLAT 5/16 SAE	4
10	47.0127	.LATCH, RUBBER DRAW T-HANDLE	2
11	64.0910	.HINGE, COVER LEFT SIDE	1
12	95.06	.WASHER, FLAT 3/8 SAE	1
13	02.HP0313	.HAIRPIN, 3/32 X 1-5/8	1
14	99.SF05	.NUT, SRF 5/16-18 USS	4
15	64.0909	.HINGE, COVER RIGHT SIDE	1
16	00.0400	.DECAL, HEIGHT ADJUST HQ680	1

OPTIONS

ILLUSTRATED DRAWING 70.8054 Swivel Wheel Kit



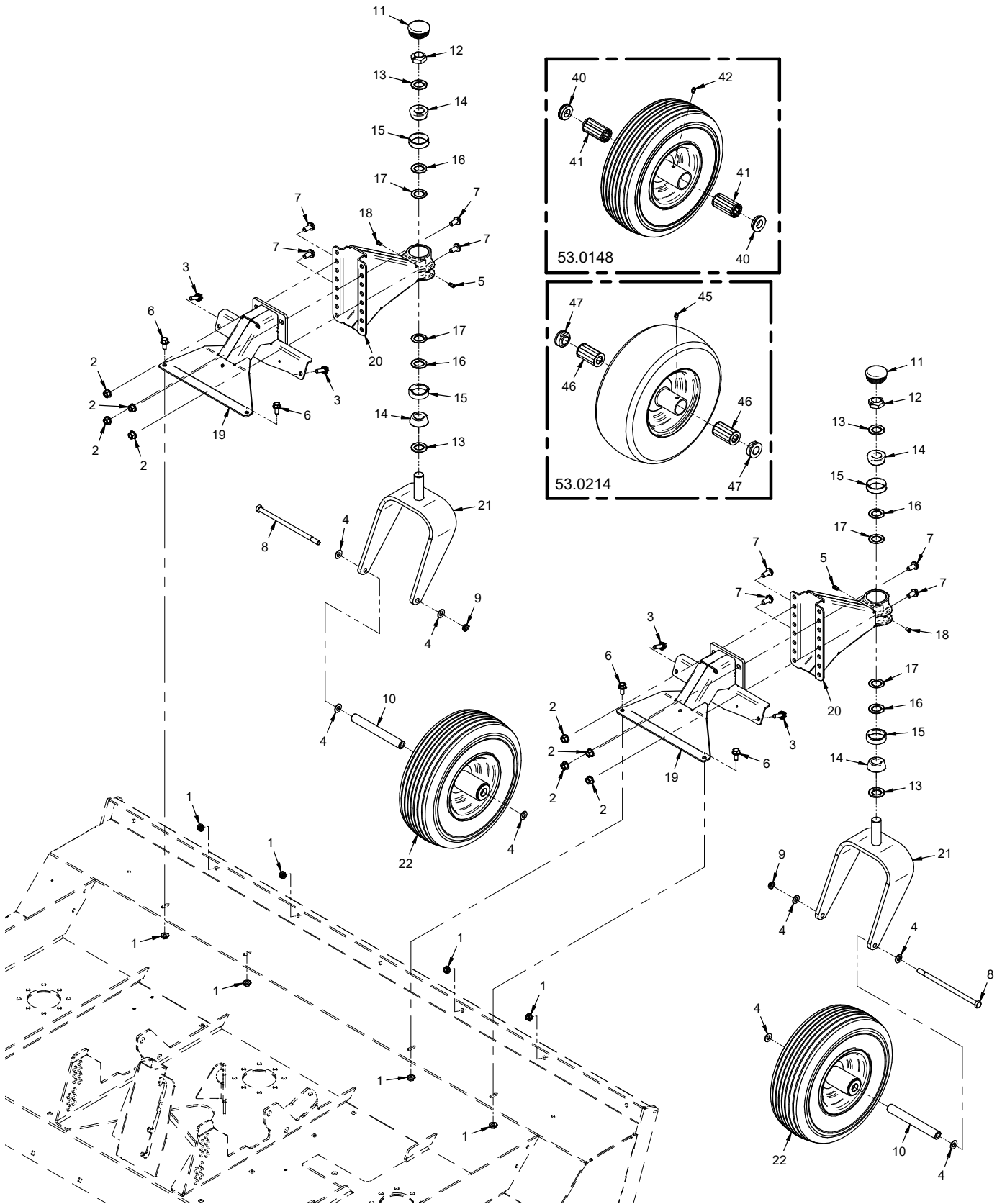
OPTIONS

70.8054 Swivel Wheel Kit

REF.	PART NO.	DESCRIPTION	QTY.
1	53.0080	.DUST CAP, BEARING MOWER CASTER	2
2	99.A12NF	.LOCKNUT, STOVER 3/4-16 SAE	2
3	99.B0057-2	.WASHER, MACH3/4 X1-1/4 10GA ZP	4
4	55.0023	.BEARING, BALL .75 ID X 1.78 OD	4
5	04.0013	.SNAP RING, INT .062 X 1.75	2
6	99.B0052	.SHIM, STEEL 3/4 X 1 X .062	2
7	29.GF0001	.GREASE FTG, 1/4 SAE ST	2
8	99.SF0606	.BOLT, SRF 3/8-16 USS X 3/4	8
9	64.1160	.FRAME, FRONT MOUNT	2
10	99.SF0508	.BOLT, SRF 5/16-18 USS X 1	4
11	64.1161	.FRAME, REAR MOUNT	2
12	99.SF06	.NUT, SRF 3/8-16 USS	8
13	99.SF0506	.BOLT, SRF 5/16-18 USS X 3/4	4
14	99.SF05	.NUT, SRF 5/16-18 USS	8
15	99.A06C	.LOCKNUT, CENTER 3/8-16	2
16	95.06	.WASHER, FLAT 3/8 SAE	4
17	50.0183	.YOKE, CASTER 13", HIGH/LOW	1
18	90.0660	.BOLT, 3/8-16 USS X 7-1/2	2
19	50.0050	.TUBE, SWIVEL AXLE	2
20	53.0119	.WHEEL, ASM 13 X 5 X 6 FLATFREE	2
20	53.0148	.WHEEL, ASM 13X5X6 RIB FLATFREE	2
41	55.0066	.BEARING, RETAINER 3/4"	2
42	55.0065	.BEARING, 3/4 ROLLER 2-1/4" LG	2
43	29.GF0001	.GREASE FTG, 1/4 SAE ST	1
51	55.0072	.BEARING, RETAINER 3/4"	2
52	55.0088	.BEARING, ROLLER REPLACEMENT	2
53	29.GF0001	.GREASE FTG, 1/4 SAE ST	1

OPTIONS

ILLUSTRATED DRAWING 70.8213 Swivel Wheel Kit



OPTIONS

70.8213 Swivel Wheel Kit

REF.	PART NO.	DESCRIPTION	QTY.
1	99.SF05	.Nut, SRF 5/16-18 USS	8
2	99.SF06	.Nut, SRF 3/8-16 USS	8
3	99.SF0508	.Bolt, SRF 5/16-18 USS X 1	4
4	95.06	.Washer, Flat 3/8 SAE	8
5	29.GF0001	.Grease Ftg, 1/4 SAE ST	2
6	99.SF0506	.Bolt, SRF 5/16-18 USS X 3/4	4
7	99.SF0606	.Bolt, SRF 3/8-16 USS x 3/4	8
8	90.0660	.Bolt, 3/8-16 USS x 7-1/2	2
9	99.A06C	.Locknut, Center 3/8-16	2
10	50.0050	.Tube, Swivel Axle	2
11	05.0172	.Plug, Ribbed Black LDPE	2
12	99.M0047	.Locknut, Stover M22 X 1.5 ZP	2
13	99.B0119	.Washer, Mach 7/8 x 1-3/8 x 10 GA	4
14	55.LM12749LA2	.Bearing, Taper Roller Cone	4
15	55.LM12710	.Bearing, Cup	4
16	85.B0099	.Bushing, .875ID x 1.375OD x .120T	4
17	85.B0101	.Bushing, .005 Spacer	4
18	29.GF0011	.Grease Ftg, Plug 1/4-28	2
19	64.1161	.Frame, Rear Mount	2
20	62.1507	.Frame, Front Mount	2
21	50.0195	.Yoke, Caster 13" Wheel	2
22	53.0148	.Wheel, Asm 13x5x6 Rib Flatfree (White Rim)	2
22	53.0214	.Wheel, Asm 13x5x6 Flatfree (Black Rim)	2
40	55.0072	.Bearing, Retainer 3/4"	2
41	55.0088	.Bearing, Roller Replacement	2
42	29.GF0001	.Grease Ftg, 1/4 SAE ST	1
45	29.GF0001	.Grease Ftg, 1/4 SAE ST	1
46	55.0116	.Bearing, Roller 2.25" Long	2
47	55.0114	.Retainer, Roller Bearing 3/4"	2