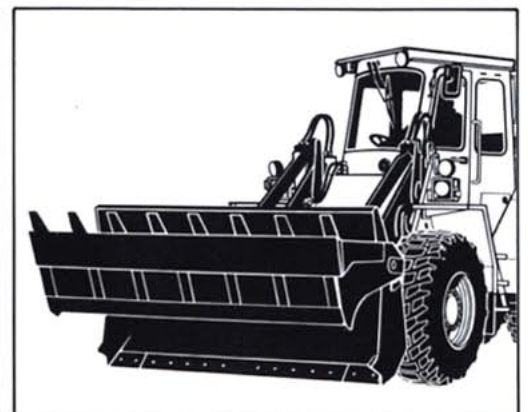
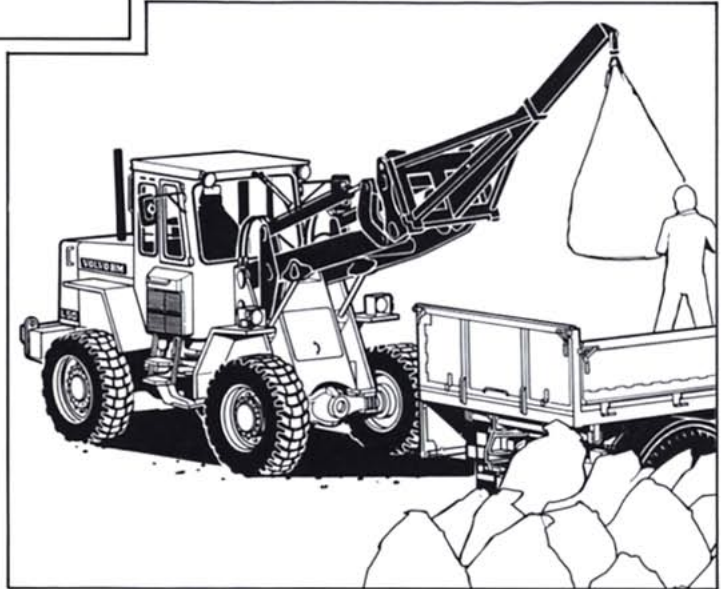
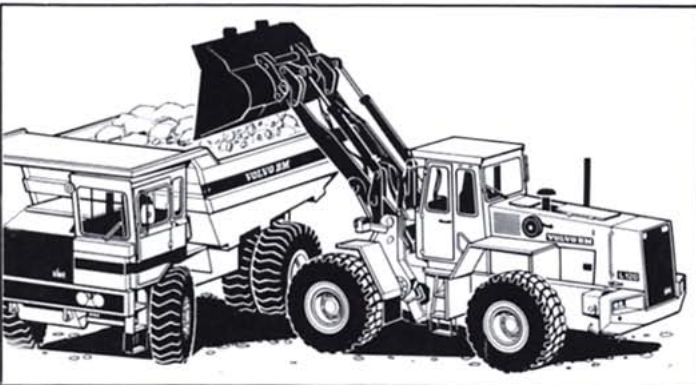
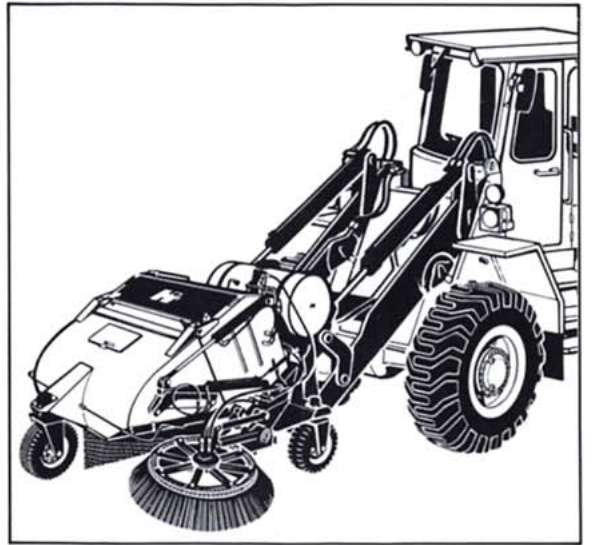
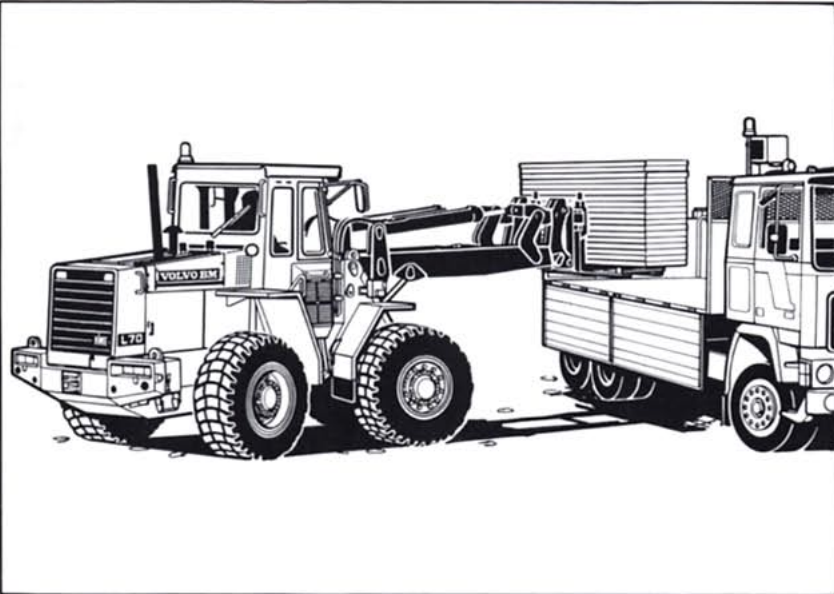


VOLVO BM

ATTACHMENTS

FOR WHEEL LOADERS L50, L70, L90, L120, L160




GENUINE ATTACHMENTS FOR BEST OVERALL ECONOMY

As a loader manufacturer, Volvo BM realized at an early stage the importance of flexibility and quick adaptation to different jobs. In all situations the machine and its attachment must function as an integral unit giving maximum capacity and thereby optimum economy.

In addition to bucket loading, a loader must be capable of handling many other working operations, such as handling of timber, sawn wood and palletized goods, as well as snow clearance, construction work etc.

Volvo BM is the only loader manufacturer who both designs and manufactures a full range of attachments. This means that the design of each attachment is perfectly adapted to the loader's liftarm system and performance. Technical modifications to the machines are coupled with continuous modification of the attachments in order to ensure maximum possible capacity. In other words, the ultimate goal is to provide a well functioning unit able to exploit the loader's performance capacity in the best possible way.

VOLVO BM	
VOLVO BM COMPANY ESKILSTUNA SWEDEN 	
A SUBSIDIARY OF VME GROUP NV	
SKOPA / BUCKET MODEL	NO <input type="text"/>
TILLV. / SERIAL	NO <input type="text"/>
VOLYM / RATED CAPACITY SAE	m ³ <input type="text"/>
LAST / RATED LOAD	ton <input type="text"/>
MAX TRYCK / PRESSURE	MPa <input type="text"/>
VIKT / WEIGHT	kg <input type="text"/>
SKOPBREDD / BUCKET WIDTH	mm <input type="text"/>
SKÅR / EDGE	PART NO <input type="text"/>
SPARSKÅR / EDGE SAVER	PART NO <input type="text"/>
TAND / TOOTH	PART NO <input type="text"/>
HÅLLARE / ADAPTER	PART NO <input type="text"/>

VOLVO BM 4787 004

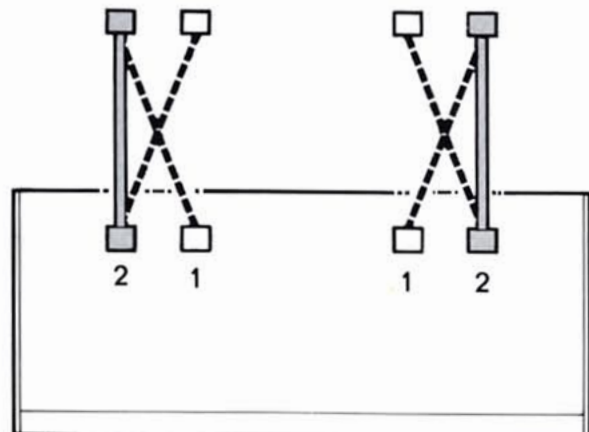
The product data plate affixed to all genuine attachments is the buyer's guarantee that the attachment has been tested and approved by Volvo BM with respect to quality and function. Reassuring to know. The data plate not only marks the attachment as a genuine Volvo BM product, but also serves as a certificate of identification.

MACHINE AND ATTACHMENT WORKING TOGETHER

Volvo BM's lift-arm system gives good breakout forces throughout the entire lift-arm movement, together with good bucket angles. This is the result of the ingenious design of the linkage arms, which ensures that the lever that carries out the tilting movement is always long.

- The loader unit developed with the aid of up to date computer technology has been designed especially for Volvo BM attachments ensuring correct bucket angles and breakout force. If the geometry is altered by using non Volvo BM bucket, the capacity of the machine can be considerably reduced.
- High lift-arm attachment and long reach give a high working level. This makes it possible to reach in and across truck platforms and railway from one side without bumping the underside of the arms - a common problem on many other machines.
- Maximum visibility together with good function and high strength have been achieved by arranging the loader unit in such a way that the cylinders lift arms and linkages are correctly aligned.
- Loading forces act symmetrically on the lift-arm system and its bearings, thereby eliminating bending stresses and unnecessary wear.
- Attachments must not be heavier than necessary, as this reduces overall working capacity. Volvo BM attachments feature high material quality and are ideally matched to the power resources of the machine.

All of these factors must act in harmony with each other. Only then can the best possible capacity and economy be achieved.

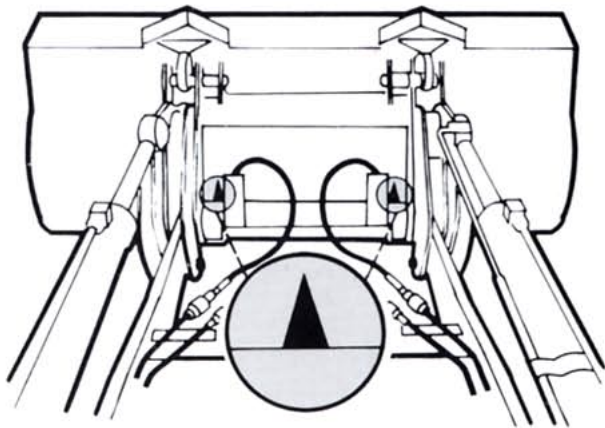
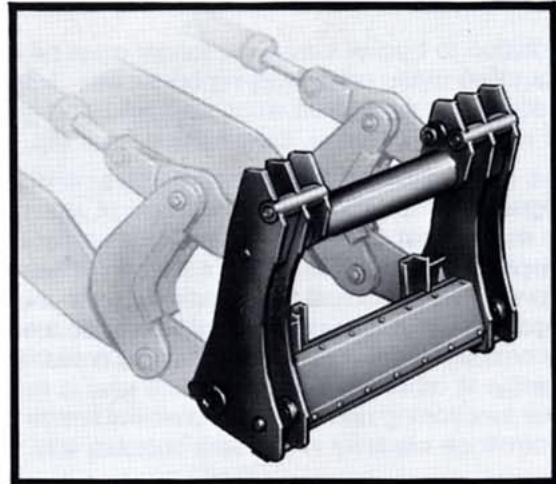


- 1 Non-parallel points of attachment result in off-center forces and thereby a greater risk of rapid wear.
- 2 This is the best and least stressful means of attachment, and it is the one Volvo BM has chosen for its range of loaders.

ATTACHMENT BRACKETS

Different materials require different handling methods - but not necessarily different machines. Volvo BM loaders are continuously being developed to provide higher capacity within different fields of operation. Snap-on coupling of attachments permits effective utilization of the machine where previously only special-purpose machines, such as fork-lift trucks and mobile cranes, could be used.

The idea of interchangeable attachments is a unique solution that made Volvo BM a market leader long ago. The attachment bracket with snap-on coupling is easy to operate and withstands hard use. Precision fits and quality engineering with large, rounded hooks make it easy to guide the attachment onto the bracket. The difference in operating load between direct-mounted (pin-on) and bracket-mounted (hook-on) attachments is not great. Bushes, plates etc for attachment to the lift-arms are located either on the bracket or on the attachment. The difference in weight is insignificant. As designers of both the machine and the attachment, we have taken the unique opportunity to build an integral unit.



Attachment bracket with hydraulic lock

The attachment is locked from the cab via the control lever for the 3rd/4th hydraulic control. The operator can tell when the attachment is fully engaged and locked by observing two indicator arrows on the attachment bracket.

Please note that the attachment bracket requires a third hydraulic control.

		L50	L70	L90	L120	L160
Order No			90271	90423	90423	99032
Weight	kg		145	200	200	305
A	mm		1150	1150	1150	1300
B	mm		800	800	800	1010

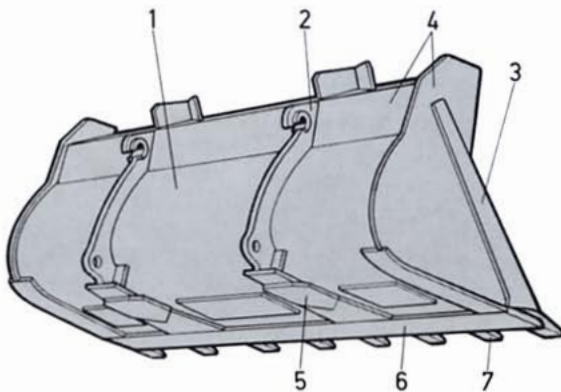
QUALITY

High material quality in each attachment is essential if it's to stand up to the rigorous treatment to which it will be constantly subjected. That's why Volvo BM uses the very best materials in each and every part - materials that make for lightweight attachments and thereby high operating loads.

But the concept of quality includes more than just quality of materials; quality of workmanship is just as important. Our attachments are manufactured in well-equipped workshops. Correct tolerances are essential for the best possible fits. The high quality liftarm system need top quality attachments. This is achieved by manufacture in advanced jigs and fixtures, frequent dimensional inspection, advanced welding methods and precision machining, including boring of bearing seats and bucket mountings. By boring the attachment mountings, a fully centered hole pattern is obtained, thereby avoiding inherent stresses which could result in rapid wear.

Each Volvo BM loader has a fully modern and functional range of attachments at its disposal. This enables the best attachment to be chosen for the task at hand. This in turn means that the machine's features can be utilized to the full, giving high capacity and thereby good economic returns.

The hard and abrasive materials that constitute normal working conditions in Scandinavia have forced us to use high-quality grade steels. Since conditions are not only severe but also varying, mere strength is not enough - flexibility is also important. Through extensive testing, we have developed a large number of buckets for materials of different density for optimum utilization of the tipping load.



- 1 *Hardened-and-tempered special steel in the shell (on smaller machines only in the bottom).*
- 2 *Solid plate prevents stresses being built in from the start and distributes them better during the work. This leads to longer service life.*
- 3 *The side cutter has extra wear plates (edge and corner bits) of hardened-and-tempered special steel.*
- 4 *Grain-refined structural steel.*
- 5 *Easily replaceable wear plates of hardened-and-tempered abrasion-resistant steel.*
- 6 *Bucket lip of hardened-and-tempered abrasion-resistant steel.*
- 7 *Teeth of the best quality.*

EDGE SAVERS

In order to reduce the maintenance of buckets, some can be fitted with edge savers. These protect the bottom of the bucket and prolong the life of the wear plates. An additional advantage is that they help to prevent spillage. The edge savers are mounted in sections and are interchangeable, permitting optimum economy. They are fastened with three bolts in each section.

To obtain the best results edge savers should be fitted to the bucket from new.

All straight-lip buckets without teeth have been equipped with pre-drilled cutting edges to prepare them for easy edge saver mounting. High-dump buckets and some non-hydraulic-dump wood chip buckets are equipped as standard with edge savers. The data plate on each bucket specifies the appropriate edge savers.

SPILL GUARD

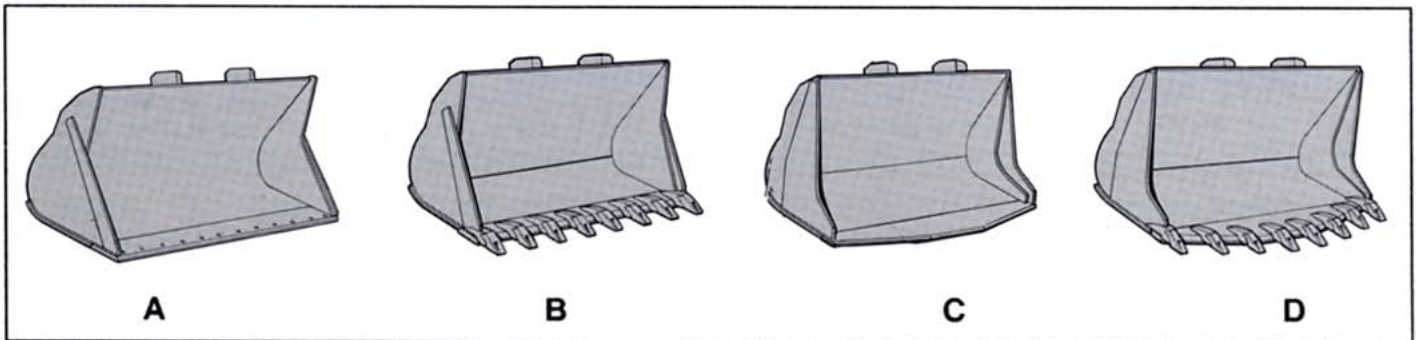
These prevent materials from spilling over the rear edge of the bucket during rollback. They can be mounted on a bucket equipped with a tilt cylinder guard. Spill guards complete with fasteners are supplied only for retrofitting.

		L50	L70	L90	L120	L160
Order No			99173	99174	99174	99175
Width	mm		1650	1700	1700	1850
Height	mm		185	285	245	305
Weight	kg		26	44	44	69

SELECTING A BUCKET

Bucket volume alone is not an adequate measure of the capacity of the loader. The crucial factor is the ability of the machine to fill the bucket every time. A large bucket can mean lower capacity because it is more difficult to fill, while a small bucket that is easier to fill can increase capacity. A number of factors have to be taken into account, such as the nature of the

material being handled, the condition of the machine, the operator's skill and the transport distance. If the transport distance is long, this may mean spillage. Since all of these factors vary, a wide selection of buckets is required in order to achieve maximum capacity. The Volvo BM range offers such a wide selection.

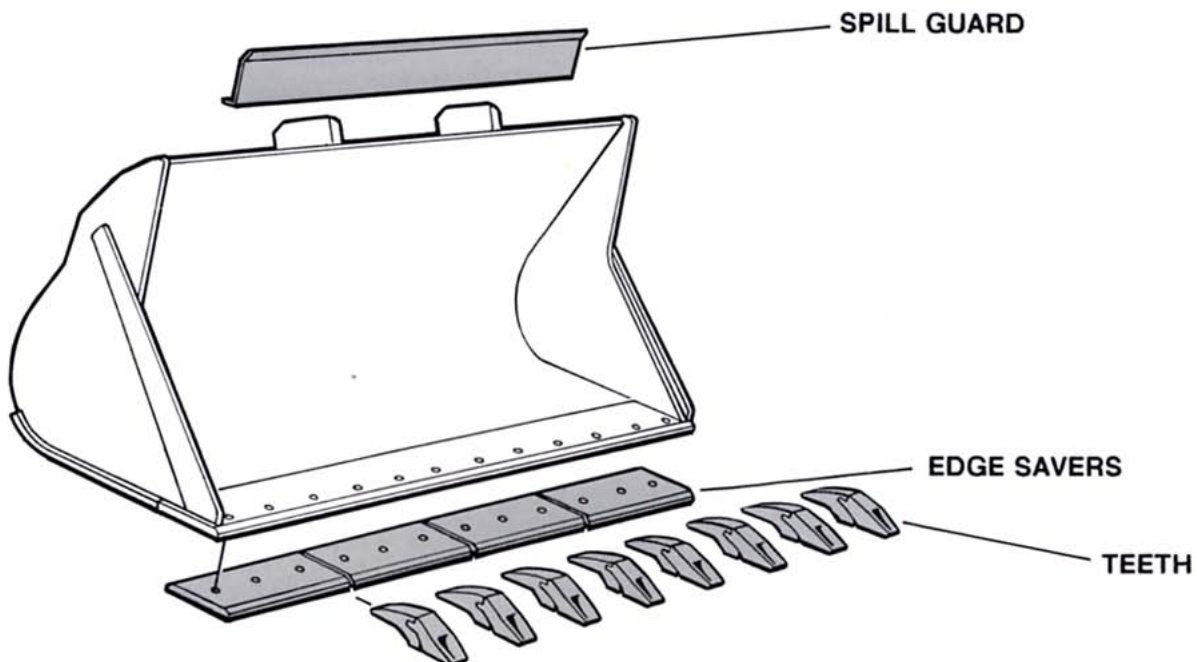


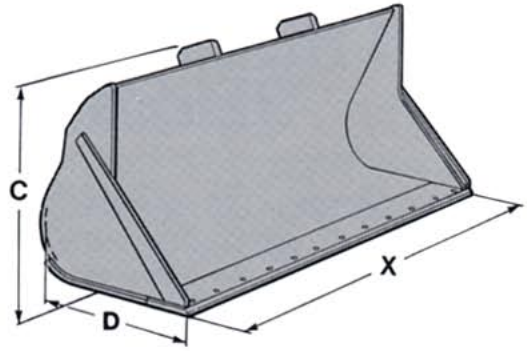
A
Straight-lip bucket without teeth. The best choice for loosened material or for loading easily broken material from banks. Can be fitted with an edge saver.

B
Straight-lip bucket with teeth. Designed for materials that require good penetration and breakout forces, e.g. gravel, clay and for excavation work.

C
Spade nose bucket without teeth. The bucket is used for materials that require high penetration and breakout forces. Suitable for gravel, finely blasted rubble and ore.

D
Spade nose bucket with teeth. Used for breaking out hard and stony material and rubble.





STRAIGHT-LIP BUCKET WITHOUT TEETH
(sand, gravel, soil, clay)

The bucket is designed for stockpiling and for loading material that is relatively easy to break out from the bank.

Available with edge savers.

1,8 t/m ³ (3000 lb/yd ³)		L50		L70		L90		L120		L160	
Type of mounting		R	D	R	D	R	D	R	D	R	D
Order No		90039	PF	90041	PF	90442	90446	90450	90453	98933	99026
Volume Heaped	m ³	1,15	1,15	1,5	1,5	2,1	2,1	2,8	2,8	3,8	3,8
	yd ³	1,5	1,5	2,0	2,0	2,7	2,7	3,66	3,66	5,0	5,0
Weight	kg	450	470	630	625	930	1030	1145	1245	1800	1830
X Cutting edge	mm	2300	2300	2430	2430	2500	2500	2750	2750	3200	3200
C	mm	1100	1100	1200	1200	1370	1370	1475	1475	1630	1630
D	mm	810	810	970	910	1054	1054	1190	1190	1310	1310

1,6 t/m ³ (2700 lb/yd ³)		L50		L70		L90		L120		L160	
Type of mounting		R*	D	R*	D	R*	D*	R*	D*		D*
Order No		99776	PF	99784	PF	90229	90447	90226	90454		99203
Volume Heaped	m ³	1,25	1,25	1,65	1,65	2,3	2,3	3,1	3,1		4,2
	yd ³	1,64	1,64	2,17	2,17	3,0	3,0	4,05	4,05		5,5
Weight	kg	470	490	650	645	960	1060	1160	1260		1910
X Cutting edge	mm	2300	2300	2430	2430	2500	2500	2750	2750		3200
C	mm	1200	1200	1295	1295	1450	1450	1550	1550		1700
D	mm	810	810	970	910	1054	1054	1190	1190		1310

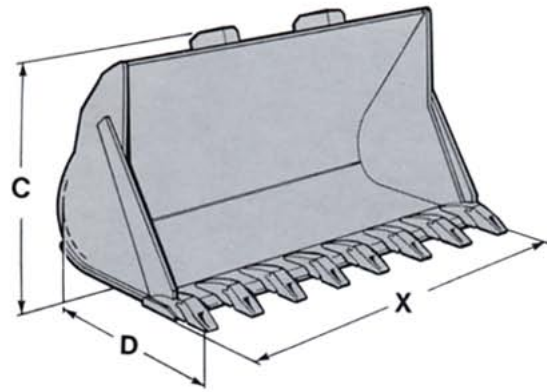
1,5 t/m ³ (2500 lb/yd ³)		L50		L70		L90		L120		L160	
Type of mounting		R		R	D	R	D	R	D	R	D
Order No		99778		99786	PF	90443	90448	90451	90455	99028	99027
Volume Heaped	m ³	1,4		1,8	1,8	2,5	2,5	3,3	3,3	4,5	4,5
	yd ³	1,1,8		2,4	2,4	3,26	3,26	4,3	4,3	6,0	6,0
Weight	kg	4540		690	670	1025	1125	1275	1375	1900	1930
X Cutting edge	mm	2300		2430	2430	2500	2500	2750	2750	3200	3200
C	mm	1180		1280	1295	1480	1480	1610	1610	1740	1750
D	mm	910		1015	1015	1170	1170	1315	1315	1445	1445

- R = Bracket-mounted (hook-on)
- D = Direct-mounted (pin-on)
- PF = On request
- * = Spill guard cannot be fitted

STRAIGHT-LIP BUCKET WITH TEETH
(sand, gravel, soil, clay)

The bucket is designed for loading materials that require high penetration and breakout forces.

All dimensions are inclusive of teeth.



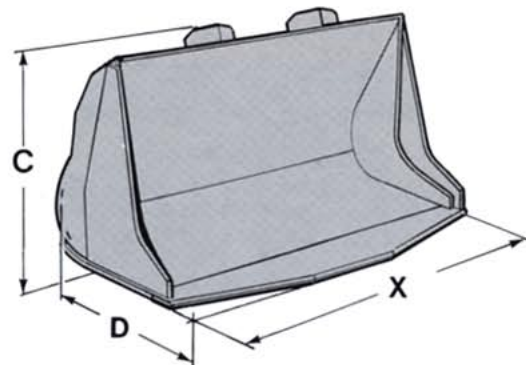
1,8 t/m ³ (3000 lb/yd ³)	L50		L70		L90		L120		L160	
Type of mounting	R	D	R	D	R	D	R	D	R	D
Order No	90040	90252	90042	90043	90444	90227	90225	90228	98936	98932
Volume Heaped	m ³	1,15	1,15	1,5	1,5	2,1	2,1	2,8	2,8	3,8
	yd ³	1,5	1,5	2,0	2,0	2,7	2,7	3,66	3,66	5,0
Weight	kg	500	520	705	695	1020	1060	1270	1350	2050
Number of teeth		8	8	8	8	8	8	9	9	9
X Cutting edge	mm	2300	2300	2430	2430	2500	2500	2750	2750	3200
C	mm	1100	1100	1210	1200	1370	1370	1500	1500	1630
D	mm	960	960	1065	1065	1280	1280	1410	1410	1510

1,6 t/m ³ (2700 lb/yd ³)	L50		L70		L90		L120		L160	
Type of mounting	R*	D	R*	D*	R*	D*	R	D*		D*
Order No	99777	90250	99785	99781	90445	90449	PF	90456		99202
Volume Heaped	m ³	1,25	1,25	1,65	1,65	2,3	2,3	3,1	3,1	4,2
	yd ³	1,64	1,64	2,17	2,17	3,0	3,0	4,05	4,05	5,5
Weight	kg	520	540	725	715	1030	1055	1305	1355	2170
Number of teeth		8	8	8	8	8	8	9	9	9
X Cutting edge	mm	2300	2300	2430	2430	2500	2500	2750	2750	3200
C	mm	1205	1200	1280	1300	1440	1440	1560	1560	1690
D	mm	960	960	1065	1065	1280	1280	1385	1410	1510

SPADE NOSE BUCKET WITHOUT TEETH
(gravel, finely-blasted rubble)

The bucket is designed for loading materials that require very high penetration and breakout forces.

Spade nose buckets for L50 and L70.



1,8 t/m ³ (3000 lb/yd ³)	L50		L70		L90		L120		L160	
Type of mounting	R		R	D	R	D	R	D	R	D
Order No	99838		99841	PF	90487	90485	90483	90480	PF	99023
Volume Heaped	m ³	1,15	1,5	1,5	2,1	2,1	2,8	2,8	3,8	3,8
	yd ³	1,5	2,0	2,0	2,7	2,7	3,66	3,66	5,0	5,0
Weight	kg	470	705	700	965	1065	1260	1360	2290	2340
X Cutting edge	mm	2300	2430	2430	2500	2500	2750	2750	3200	3200
C	mm	1100	1290	1290	1340	1340	1530	1530	1630	1630
D	mm	1010	1155	1155	1205	1205	1315	1315	1508	1510

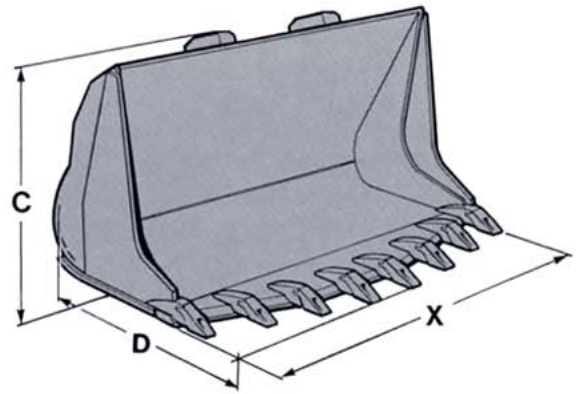
R = Bracket-mounted (hook-on)
D = Direct-mounted (pin-on)

PF = On request
* = Spill guard cannot be fitted

**SPADE NOSE BUCKET WITH TEETH
(hard gravel, blasted rock)**

The bucket is designed for loading materials that require very high penetration and breakout forces. The bucket has low-cut sides to facilitate penetration into the material.

All dimensions are inclusive of teeth.



1,8 t/m ³ (3000 lb/yd ³)		L70		L90		L120		L160	
Type of mounting		R	D	R	D	R	D	R	D
Order No		99839	PF	90486	90484	PF	90479	PF	98934
Volume Heaped	m ³	1,5	1,5	2,1	2,1	2,8	2,8	3,8	3,8
	yd ³	2,0	2,0	2,7	2,7	3,66	3,66	5,0	5,0
Weight	kg	750	710	1075	1140	1370	1450	2430	2415
Number of teeth		8	8	8	8	9	9	9	9
X Cutting edge	mm	2430	2430	2500	2500	2750	2750	3200	3200
C	mm	1200	1200	1340	1340	1520	1520	1570	1570
D	mm	1145	1145	1430	1430	1515	1540	1708	1575

**SPADE NOSE BUCKET WITH TEETH
(Heavy duty rock bucket)**

The bucket is designed for handling materials in stone and rock quarries etc. where extra-high penetration forces are required.

All dimensions are inclusive of teeth.

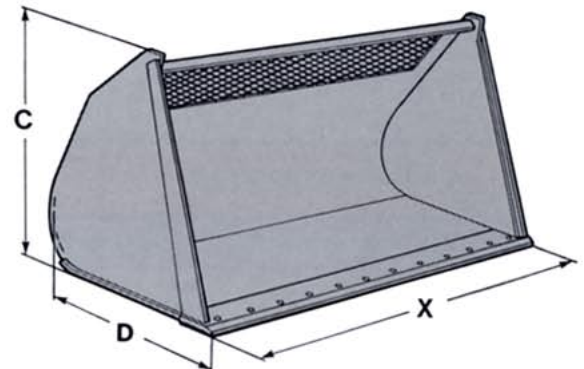
		L120	L160
Type of mounting		D	D
Order No		91075	91076
Volume Heaped	m ³	2,4	3,4
	yd ³	3,14	4,5
Weight	kg	1295	2165
Number of teeth		9	9
X Cutting edge	mm	2750	3200
C	mm	1425	1570
D	mm	1460	1665

0,8-1,0 t/m ³ (1350-1700 lb/yd ³)		L50	L70	L90	L120	L160
Type of mounting		R	R	R	R	R
Order No		98611	90928	90926	90927	99172
Volume Heaped	m ³	2,1	3,0	4,0	5,4	7,0
	yd ³	2,75	3,9	5,2	7,1	9,16
Weight	kg	540	830	1215	1510	2170
X Cutting edge	mm	2380	2500	2750	2950	3200
C	mm	1200	1365	1510	1675	1925
D	mm	1220	1415	1520	1720	1835

**LIGHT MATERIALS BUCKET
(wood chips, coal, coke, snow etc)**

The bucket is designed for handling materials of low density. Available with edge savers.

	0,7 t/m ³ (1250 lb/yd ³)		0,5 t/m ³ (850 lb/yd ³)	
	L50	L70	L120	L160
Type of mounting	R	R	R*	R*
Order No	98018	98432	90505	99358
Volume Heaped	m ³	2,5	3,6	10,0
	yd ³	3,3	4,7	13,0
Weight	kg	735	1080	1710
X Cutting edge	mm	2430	2500	3500
C	mm	1280	1475	2150
D	mm	1235	1440	1915

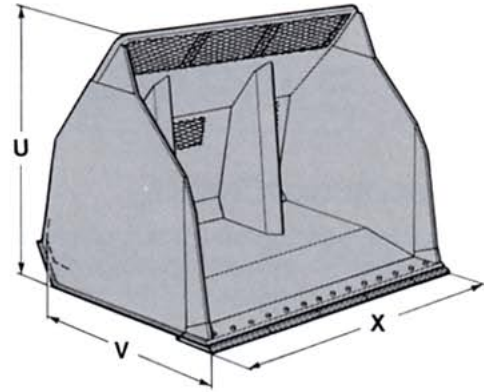


R = Bracket-mounted (hook-on) PF = On request
D = Direct-mounted (pin-on) * = Spill guard cannot be fitted

HIGH-DUMP LIGHT MATERIALS BUCKET (wood chips, coal, coke, etc)

The bucket is designed for handling materials of low density. Since it can be dumped over a special frame, its unloading height can be considerably increased. Buckets for loaders up to and including the L70 have one tipping cylinder, the others have two.

The attachment requires a 3rd hydraulic control.
The bucket is equipped with edge savers.



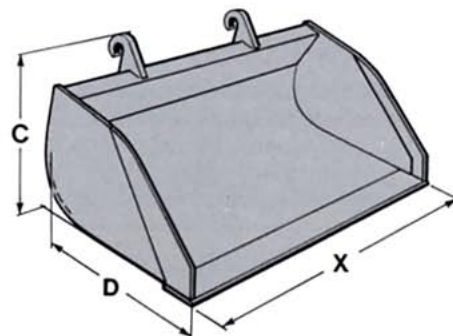
0,8-1,0 t/m ³ (1350-1700 lb/yd ³)		L50	L70	L90	L120	L160
Type of mounting		R	R	R	R	R
Order No		98612	99788	90501	90503	90900
Volume						
Heaped	m ³	1,6	2,2	3,4	4,8	6,5
	yd ³	2,1	2,9	4,5	6,3	8,5
Weight	kg	760	1115	1480	1960	2650
X Cutting edge	mm	2430	2500	2750	2830	3500
U	mm	1100	1280	1920	1875	1950
V	mm	1090	1200	1535	1675	1910

0,5 t/m ³ (850 lb/yd ³)		L50	L70	L90	L120	L160
Type of mounting		R	R	R	R	R
Order No		98605	99795	98643	90504	90110
Volume						
Heaped	m ³	3,0	4,3	6,5	8,8	12,0
	yd ³	3,9	5,6	8,5	11,5	15,7
Weight	kg	990	1120	1810	2130	2950
X Cutting edge	mm	2430	2430	2500	2830	4000
U	mm	1500	1650	2250	2380	2620
V	mm	1295	1627	1875	2115	2330

GRADING BUCKET

This bucket is intended for earthmoving work such as topsoil stripping, small-scale dozing, landscaping and leveling of infill.

The bucket is provided with an edge at the rear that can be used for grading when the machine is reversed.



1,3-1,5 t/m ³ (2200-2500 lb/yd ³)		L50	L70
Type of mounting		R	R
Order No		91180	91180
Volume			
Heaped	m ³	1,6	1,6
	yd ³	2,1	2,1
Weight	kg	593	593
X Cutting edge	mm	2500	2500
C	mm	890	890
D	mm	1205	1205

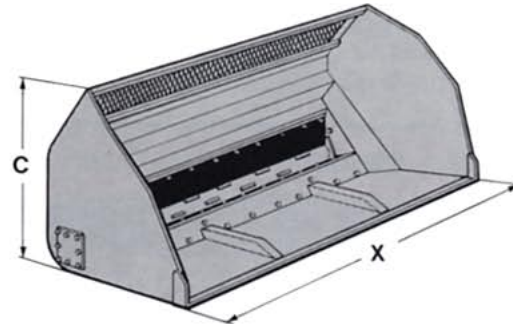
R = Bracket-mounted (hook-on)
D = Direct-mounted (pin-on)

PF = On request
* = Spill guard cannot be fitted

SAND SPREADING BUCKET, EPOKE

Intended for spreading sand, gravel, wood chips, salt, urea etc. Adjustment of the spreading rate is effected by means of a hydraulic control valve. The bucket can also be used for snow loading.

The attachment is hydraulically powered and *requires a 3rd hydraulic control.*



		L50	L70
Type of mounting		R	R
EPOKE Order No		3401-4	3401-4
Volume			
Heaped	m ³	2,0	2,0
	yd ³	2,6	2,6
Weight	kg	680	680
Spreading width min.	mm	1900	1900
X Cutting edge	mm	2445	2445
C	mm	1215	1215

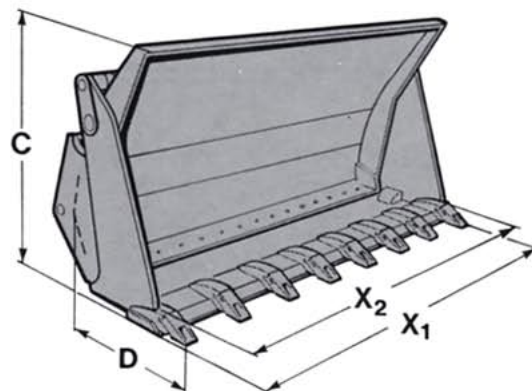
MULTIPURPOSE BUCKET WITH TEETH

ULRICH "SIMPLEX" from REYNOLDS BOUGHTON Ltd.

This bucket is intended for different types of earthmoving work and can be used as an ordinary bucket, a grader blade, a dozer blade, a grab bucket etc.

The attachment requires a 3rd hydraulic control.

All dimensions are inclusive of teeth.



Multipurpose buckets for L120 and L160 on request.

Direct-mounted (pin-on) versions of the buckets and buckets without teeth are available on request.

Also available for L90 and L160 in compactor version. Then fitted with a HIGH MESH REFUSE SPILLGUARD.

On-request versions delivery time 4-6 weeks.

1,8 t/m ³ (3000 lb/yd ³)	L50	L70	L90	L120	L160	
Type of mounting	R	R	R	R	R	
Boughton order no.	SP3-20 MK4 HB	SP2-17 MK5 MHB	SP2-32 MK5 MHB	SP1-22 MK3 HB	SP44-13 MK2 HB	
Volume						
m ³	1,0	1,3	1,9	2,5	3,4	
yd ³	1,25	1,75	2,5	3,25	4,5	
Weight						
kg	780	1210	1520	1645	2150	
No of teeth	8	8	8	9	9	
X ₁ Cutting edge, clam	mm	2341	2484	2688	2845	3197
X ₂ Cutting edge, blade	mm	2219	2353	2547	2727	3050
C	mm	945	1140	1278	1278	1506
D	mm	875	858	1054	1258	1349

R = Bracket-mounted (hook-on)
D = Direct-mounted (pin-on)

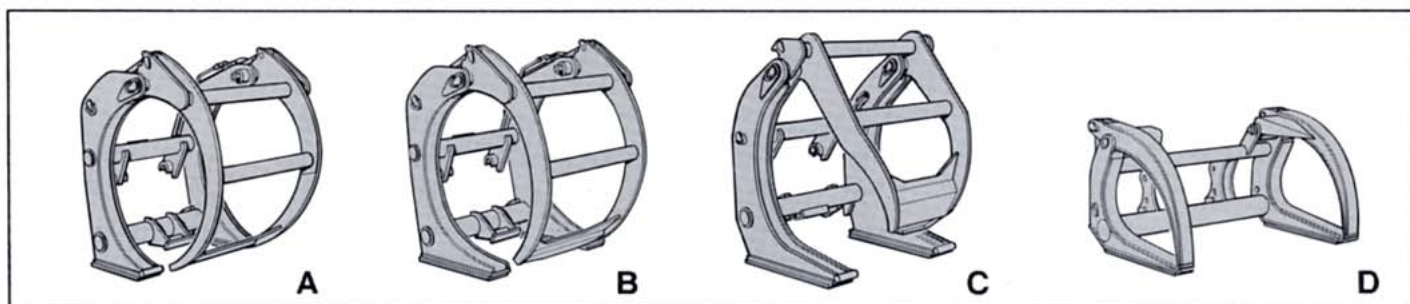
PF = On request
* = Spill guard cannot be fitted

SELECTING A LOG GRAPPLE

One of the fundamental principles in choosing a log grapple for handling round timber is that the longer the timber is, the smaller the grip area and the wider the grapple must be. The log grapples are designed differently depending on how the machine is to work. Size is normally expressed in m². The length of the timber then decides how much can be carried measured in m³.

Log grapples always require a 3rd hydraulic control.

The 3rd valve, and sometimes the complete piping assembly, is standard equipment on Volvo BM loaders, which means that they are "prepared for work with log grapples".



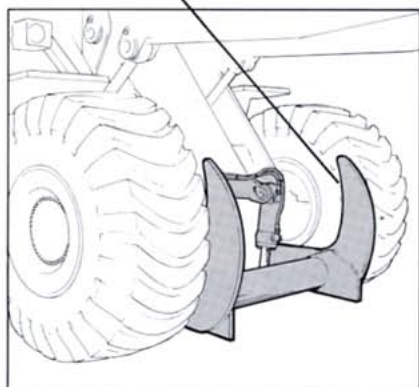
A
The unloading grapple has short, rounded tines, making it easier to fill the grapple when unloading a vehicle. Long, straight tines could damage both the timber and the vehicle if used for this purpose.

B
The sorting grapple has relatively long and straight bottom tines that can slide along the ground so that the grapple can be well filled when loading from stacks and sorting bunkers.

C
The tree-length grapple is a wide grapple that is capable of gripping single stems as well. It is slightly longer than the sorting grapple.

D
The tropical timber grapple is very wide with two separate clamping arms to hold large, heavy stems securely. Principally intended for handling large-diameter and high-density timber of the tropical type.

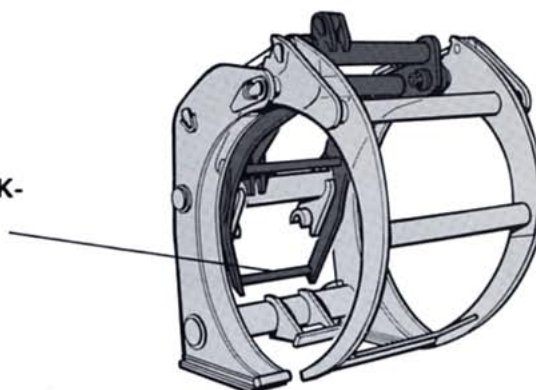
LOG PUSHER



Recommended for all handling of roundwood. Permits timber to be stacked higher and clears a path in front of the loader wheels.

Hydraulic heel/kick-out is available for most grapples. The heel is used, for example, for holding a single log in a large grapple. The kick-out is used to make higher stacks, since the grapple does not have to be tilted to empty; instead, the log is pushed out, making it possible to reach about half a meter higher.

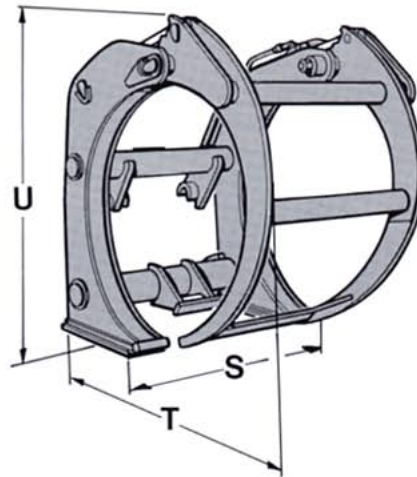
HEEL/KICK-OUT



UNLOADING GRAPPLE

For unloading timber from e.g. vehicles and placing it in stacks. The grapple has short tines and a clamping arm that gives the grapple a large grip opening. The short tines permit effective and gentle unloading. The attachment requires a 3rd hydraulic control.

Only stocked for mounting in attachment bracket.
Can be equipped with hydraulic heel/kick-out.

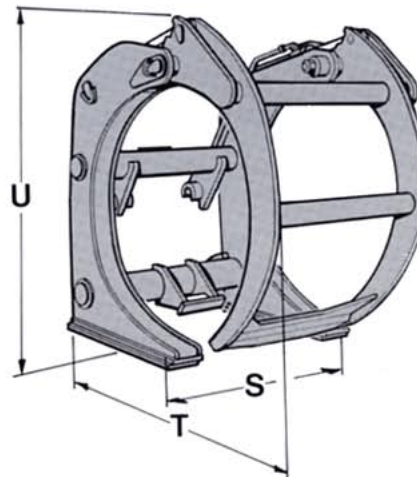


		L50	L70	L90	L120	L160
Order No				90353 90350	90353	PF 99745
Log length	m			3,0 4,5	4,5	3,0 4,5
Area	m ²			2,2 1,7	2,2	4,1 3,1
	ft ²			23,7 18,3	23,7	44,0 33,3
Recommended load	kg			3700 4300	5500	6890 7800
Weight	kg			1560 1420	1560	2050 2150
S	mm			1650 1650	1650	1780 1820
T	mm			2020 1800	2020	2750 2260
U	mm			2180 1920	2180	2900 2480

SORTING GRAPPLE

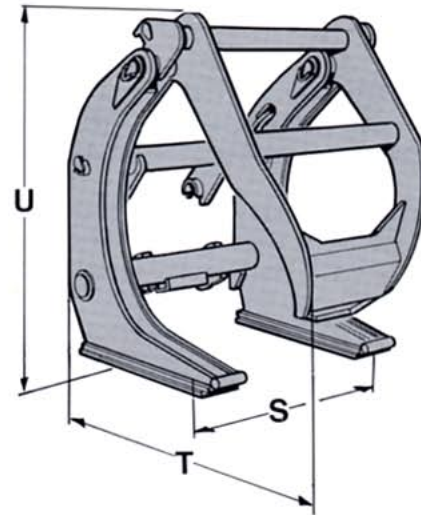
For feeding sorting plants from a stack. It has relatively long tines to reach into bunkers. The clamping arm is designed to provide a large grip opening.

The attachment requires a 3rd hydraulic control.
Only stocked for mounting in attachment bracket.
Can be equipped with hydraulic heel/kick-out.



		L50	L70	L90	L120	L160
Order No		90259	90257	90354 90351	90354	99999
Log length	m	4,5	4,5	3,0 4,5	4,5	4,5
Area	m ²	0,9	1,2	2,2 1,7	2,2	3,1
	ft ²	9,5	12,9	23,7 18,3	23,7	33,3
Recommended load	kg	2270	3000	3700 4300	5500	7800
Weight	kg	865	945	1650 1520	1650	2150
S	mm	1610	1610	1640 1640	1640	1790
T	mm	1400	1550	1830 1680	1830	2110
U	mm	1430	1620	2180 1920	2180	2480

PF = On request



TREE-LENGTH GRAPPLE

For handling tree-length stems. The grip area is adapted for handling single stems, i. e. a small minimum grip area can be obtained.

The attachment requires a 3rd hydraulic control.
Only stocked for attachment in attachment bracket.

		L50	L70	L90	L120	L160
Order No		90438	90438	90439	90439	90774
Area	m ²	0,7	0,7	1,3	1,3	1,8
	ft ²	7,5	7,5	13,9	13,9	19,3
Recommended load	kg	2270	3100	4450	5775	8200
Weight	kg	850	850	1375	1375	1750
S	mm	1610	1610	1640	1640	1790
T	mm	1230	1230	1620	1620	1900
U	mm	1500	1500	2020	2020	2370

HI-LIFT SWIVEL WOOD CLAMP

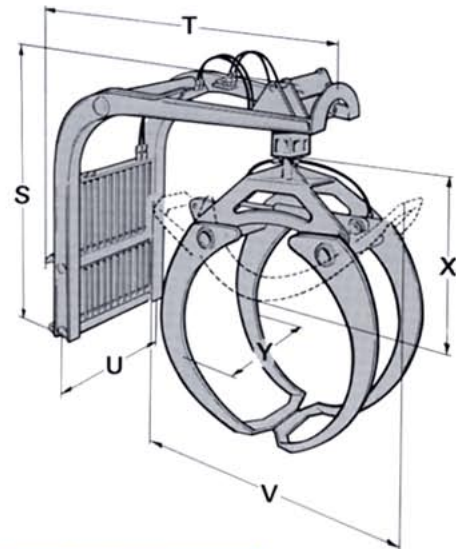
The hi-lift SWC handles pulpwood in 2-3 meter lengths and is mounted in the attachment bracket. It is designed for unloading vehicles to a stack or feeding table.

It is also suitable for transporting wood from a stack to a feeding table.

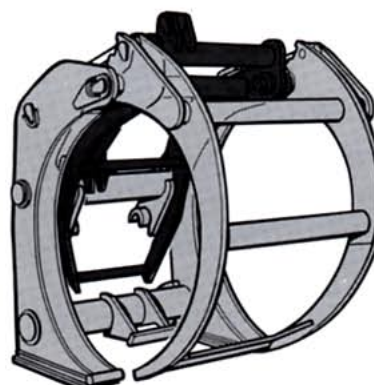
The grip can be positioned at either position "a" or position "b" depending on the size of the grip, density and length of timber. The specifications apply for a machine with 75% CaCl₂ in the rear tires.

Tipping load applies with horizontal arms and the frame in a vertical position.

3rd and 4th hydraulic controls are required.



		L90	L120
Grip Order No		90973	90975
Area	m ²	0,5-1,5	0,7-2,0
	ft ²	5,4-16,1	7,5-21,5
Weight	kg	880	930
Frame Order No		90897	90897
Weight	kg	1070	1070
Tipping load			
Position a	kg	3500	3500
Position b	kg	3900	3900
Working load			
Position a	kg	2100	2100
Position b	kg	2500	2500
S	mm	2588	2588
T	mm	2440	2440
U	mm	1317	1317
V	mm	1590	1770
X	mm	1380	1605
Y	mm	825	825

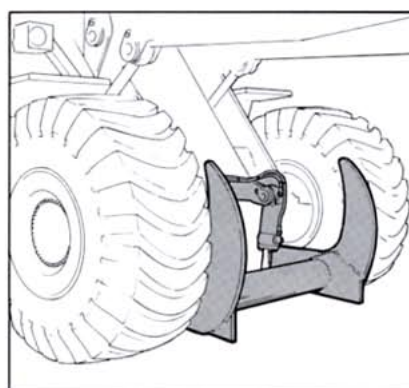


HEEL/KICK-OUT

Hydraulically operated. Supplied as assembly kit, assembly not included in price.

The equipment requires a 3rd hydraulic control.

		L50	L70	L90		L120		L160
For grapple		90259	90257	90350	90351	90353	90354	99745
Order No		90260	90258	90352	90352	90355	90355	90001
Weight	kg	200	210	300	300	330	330	410
M min. area	mm	85	200	170	170	220	220	240
For grapple			90259	90353	90354			99999
Order No			90260	90355	90355			90001
Weight	kg		200	330	330			410
M min. area	mm		85	220	220			240



LOG PUSHER

Recommended for all handling of roundwood. Permits timber to be stacked higher and clears a path in front of the loader wheels.

		L50	L70	L90	L120	L160
Order No			90665 ¹⁾	91238 ¹⁾	90664 ¹⁾	99292 ²⁾
Weight	kg		325	550	550	700
Width	mm		1310	1314	1314	1500
Depth	mm		1475	1710	1710	2060
Height	mm		610	810	810	1100

- 1) Operated with a 4th hydraulic control. If the log grapple has heel/kick-out, a 5th hydraulic control is required.
- 2) Necessary control equipment included.

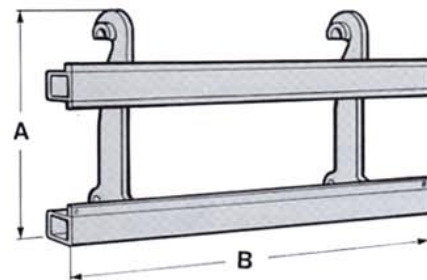
FORK ATTACHMENTS FOR VARYING NEEDS

On account of their special features, high performance, maneuverability and unique lift-arm system, Volvo BM loaders are used within many different fields of application today. The snap-on coupling permits the machine to be utilized effectively where previously only special-purpose machines such as fork-lift trucks and mobile cranes could be used. The stability of Volvo BM loaders and the reach and parallel lift-arm action of the loader unit make them particularly suitable for work with fork attachments.

On material yards, in warehouses and on docks, maximum use is made of the available space. It is here that Volvo BM's arm system and effective attachments

really prove their worth. Their high lifting height and long reach permit work with high stacks. They can also load wide vehicles from one side, permitting short work cycles.

For handling pallets of non-standard dimensions, we have a series of fork tines with lengths of 1050, 1225 and 1450 mm and fork frames with three different widths: 1200, 1500 and 2000 mm. Pallet forks and frames can be combined to form any desired unit. Our fork attachments meet the most diverse needs. From extra-heavy-duty breakout forks to forks with hydraulic positioning and combined hydraulic positioning and side shift.



FORK FRAME

For materials handling. Can be combined with different fork tines.

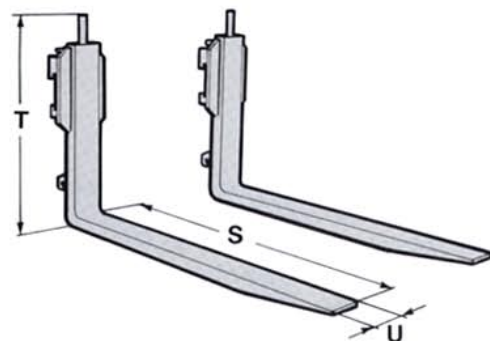
Available in three different widths.

		L50 L70			L90			L120			L160
Order no.		97791	97792	97793	90785	90786	90787	90785	90786	90787	99542
Weight	kg	130	145	180	195	225	310	195	225	310	400
A	mm	1200	1500	2000	1200	1500	2000	1200	1500	2000	2260
B	mm	815	815	815	825	825	825	825	825	825	1090

FORK TINES

Available in three different lengths. For use in combination with the above-mentioned fork frame. The fork tines are marked in accordance with existing Swedish and international standards. Specified maximum load applies at a load center distance of 600 mm

NOTE! The order number is for one fork tine only.

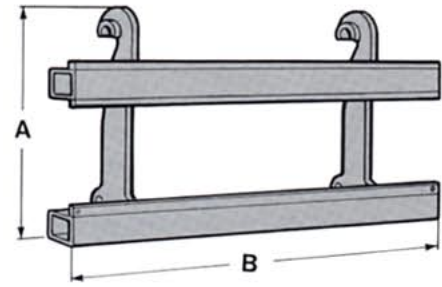


		L50		
Order No.		97788	97789	97790
Max. load per arm	kg	2000	2000	2000
Weight	kg	110	125	130
S	mm	1050	1225	1450
T	mm	920	920	920
U	mm	125	125	125

		L70			L90			L120			L160
Order No.		97788	97789	97790	90782	90783	90784	90782	90783	90784	99845
Max. load per arm	kg	2000	2000	2000	4000	4000	4000	4000	4000	4000	9000
Weight	kg	110	125	130	140	152	168	140	152	168	310
S	mm	1050	1225	1450	1050	1225	1450	1050	1225	1450	1500
T	mm	920	920	920	980	980	980	980	980	980	880
U	mm	125	125	125	150	150	150	150	150	150	200

BREAKOUT FORK FRAME

Extra heavy-duty. Intended for heavy jobs where a large breakout force is needed, e. g. stone quarrying.



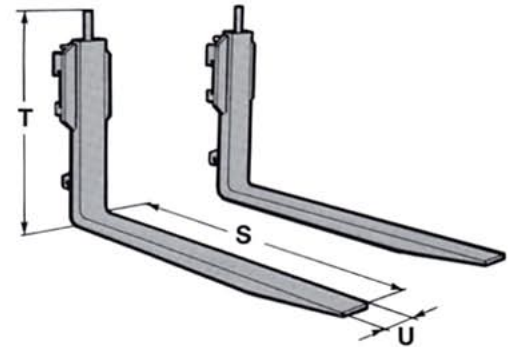
		L50 L70			L90	L120
Order no.		90785	90786	90787	90786	90786
Weight	kg	195	225	310	225	225
A	mm	1200	1500	2000	1500	1500
B	mm	825	825	825	825	825

BREAKOUT FORK TINES

Available in three different lengths. To be combined with the breakout fork frame. The fork tines are marked in accordance with existing Swedish and international standards.

Specified max. load applies at a load center distance of 600 mm.

NOTE! The order number is for one fork tine only.

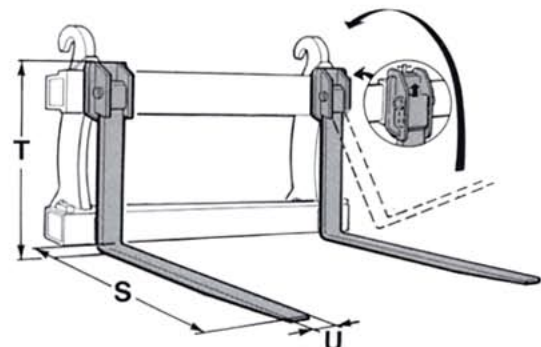


		L50			L70			L90		L120	
Order No.		90782	90783	90784	90782	90783	90784	90895	90896	90895	90896
Max. load per arm	kg	4000	4000	4000	4000	4000	4000	4700	4700	4700	4700
Weight	kg	140	152	168	140	152	168	160	194	160	194
S	mm	1050	1225	1450	1050	1225	1450	1050	1450	1050	1450
T	mm	980	980	980	980	980	980	990	990	990	990
U	mm	150	150	150	150	150	150	150	150	150	150

HINGED FORK TINES

Used where irregularities in the ground make the load difficult to pick up with conventional fork tines. The upward movement of the tines is 75 mm (3 in). The fork tines are marked in accordance with Swedish and international standards. Specified max. load applies at a load center distance of 600 mm.

NOTE! The order number is for one fork tine only.

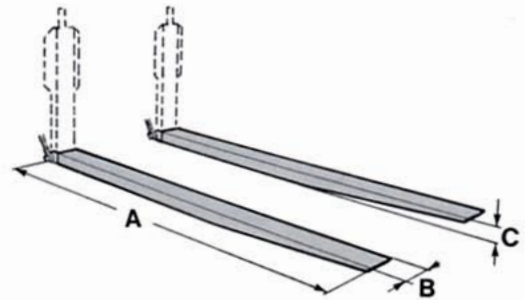


		L50 L70			L90	L120
Order No.		98098	98098	98098	98104	98104
Max. load per arm	kg	2000	2000	2000	3300	3300
Weight	kg	125	125	125	145	145
S	mm	1225	1225	1225	1225	1225
T	mm	810	810	810	830	830
U	mm	125	125	125	150	150

FORK TINE EXTENSION

Intended for handling of light materials.

NOTE! The order number is for one fork tine extension only.

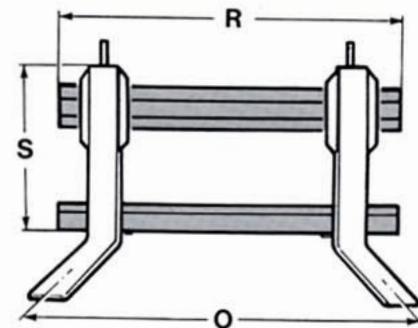


		L50 L70	L90 L120
Order No.		99107	99444
For fork size	mm	125x50	150x60
Permissible load per tine			
1250 mm (49,2 in) from frame	kg	1000	1750
Weight	kg	70	72
A	mm	2500	2500
B	mm	170	200
C	mm	70	86

PALLET FORK WITH FORK POSITIONER

This type of fork frame is ideal for cases where the width of the load varies. The fork tines can be hydraulically adjusted to the width of the load. Assembly components are included. *The attachment requires a 3rd hydraulic control.*

NOTE! Fork tines not included in order number.



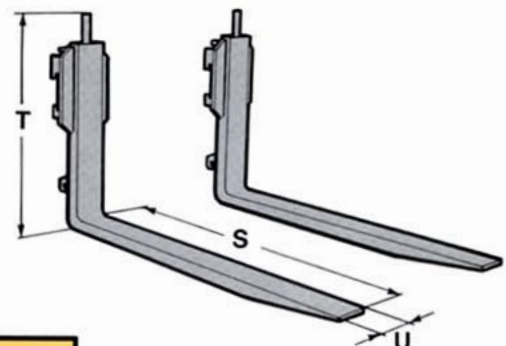
		L50		L70		L90		L120	
Order No.		90898	90899	90898	90899	90898	90899	90898	90899
O Range of movement	mm	300-1350	300-1750	300-1350	300-1750	300-1350	300-1750	300-1350	300-1750
Weight	kg	265	325	265	325	265	325	265	325
R	mm	1500	2000	1500	2000	1500	2000	1500	2000
S	mm	825	825	825	825	825	825	825	825



FORK TINES

There are three types of tines for use with the fork frame. Note that excessively long fork tines can damage goods located behind the load when picking up and setting down. The fork tines are marked in accordance with existing Swedish and international standards. Specified max. load applies at a load center distance of 600 mm.

NOTE! The order number is for one fork tine only.



		L50 L70			L90 L120		
Order No.		99228	99229	99230	90782	90783	90784
Max. load per arm	kg	2000	2000	2000	4000	4000	4000
Weight	kg	110	120	130	140	152	168
S	mm	1050	1225	1450	1050	1225	1450
T	mm	920	920	920	980	980	980
U	mm	125	125	125	150	150	150

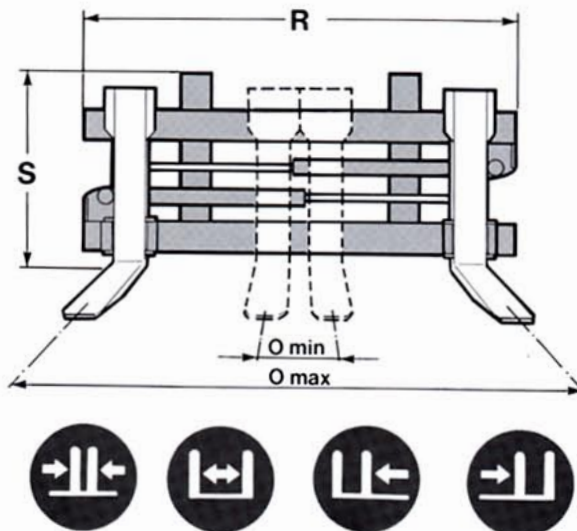
EML PALLET FORK WITH POSITIONER AND SIDE-SHIFT

This type of pallet fork is ideal for cases where the width of the load varies. The fork tines can be hydraulically adjusted to the width of the load. The side-shift function, which allows the load to be moved sideways, is invaluable for handling goods in cramped areas.

The attachment requires a 3rd and 4th hydraulic control.

The side-shifting movement is depending on the position of the fork tines. Maximum side-shift is obtained with the fork tines positioned at $O_{max}/2$.

When ordering, state the order No. for the pallet fork and the fork length.



		L50	L70	L90	L120
EML Order No		4000 F/SS/V	4000 F/SS/V	7000 F/SS/V	7000 F/SS/V
O Range of movement	mm	205-1295	205-1295	270-1930	270-1930
Weight	kg	290	290	680	680
R	mm	1500	1500	2100	2100
S	mm	735	735	910	910

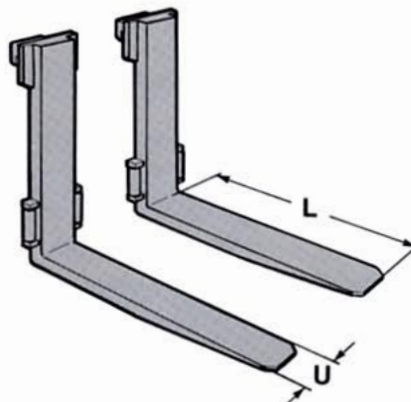
* Above ground level

FORK TINES

Available in different lengths for use in combination with the above mentioned fork frame.

Note that excessively long fork tines can damage goods located behind the load when picking up and setting down.

When ordering, state the order No. for the pallet fork and the fork length.



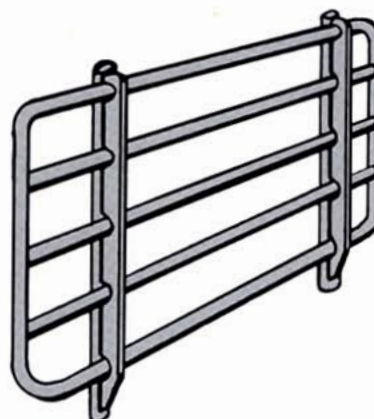
		L50 L70				L90 L120		
L	mm	1200	1400	1600	1800	1200	1600	1800
Weight	kg	181	203	426	671	310	356	385
U	mm	125	125	125	125	150	150	150

PROTECTION BARS

This type of attachment can be mounted on both old and new fork tines. It is used for handling goods that need support to keep them from falling backwards over the frame.

Fits all fork attachments up to and including the L120 loader.

(Sweden requires protection bars for certain material handling, according to ASS 94).

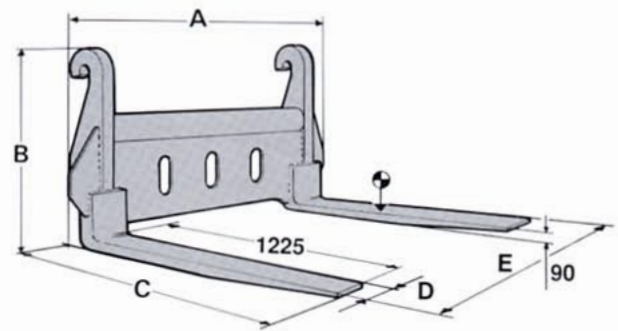


Order No.		98568
Width	mm	1200
Depth	mm	50
Height	mm	600
Weight	kg	25

FORK ATTACHMENTS WITH FIXED TINES

Fork attachments with heavy-duty tines.

		L120	L160
Attachment type		R	R
Order No.		PF	99995
Max load per arm	kg	7000	10000
Weight	kg	485	850
A	mm	1300	1500
B	mm	970	1215
C	mm	1435	1500
D	mm	160	230
E	mm	1160	1330



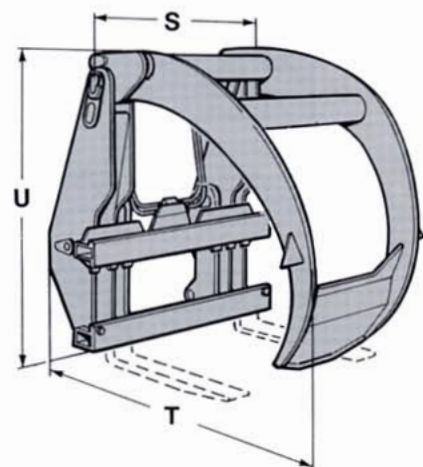
R = Bracket-mounted (Hook-on)
PF = On request

COMBI-FORK WITH ONE-PIECE CLAMP

A fork that is recommended for handling palletized goods and roundwood. The maximum height of palletized goods is 1200 mm (47 in). Hinged fork tines can be used to advantage for handling on uneven surfaces. Fork tines not included.

The attachment requires a 3rd hydraulic control.

		L50	L70	L90	L120
Order No.		97949	97949	90789	90789
A area	m ²	0,8-1,05	0,8-1,05	0,75-1,7	0,75-1,7
	ft ²	8,61-11,30	8,61-11,30	8,07-18,29	8,07-18,29
Recommended load	kg	2400 ¹⁾	3300 ¹⁾	4100 ²⁾	5600 ²⁾
Weight	kg	790	790	1150	1150
S	mm	1830	1830	1750	1750
T	mm	1330	1330	1400	1400
U	mm	1410	1410	2320	2320



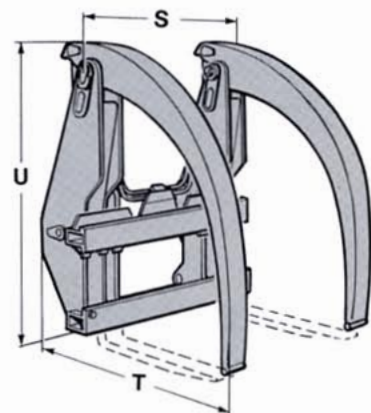
1) Load center distance 500 mm (19,7 in)
2) Load center distance 600 mm (23,6 in)

COMBI-FORK WITH TWIN-ARM CLAMP

This fork is suitable for materials handling at pulp mills, building sites etc. The clamping arms are automatically adjusted to provide a secure grip. Fork tines not included.

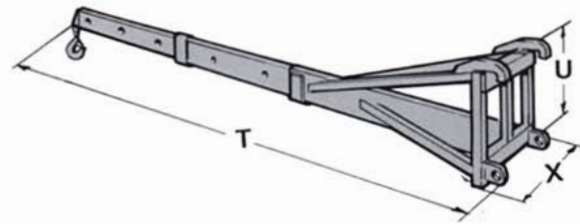
The attachment requires a 3rd hydraulic control.

		L50	L70	L90	L120
Order No.		97950	97950	90790	90790
A area	m ²	0,8-1,05	0,8-1,05	0,5-1,5	0,5-1,5
	ft ²	8,61-11,30	8,61-11,30	5,38-16,14	5,38-16,14
Recommended load	kg	2400 ¹⁾	3300 ¹⁾	4100 ²⁾	5600 ²⁾
Weight	kg	770	770	1025	1025
S	mm	1830	1830	1750	1750
T	mm	1450	1450	1120	1120
U	mm	1410	1410	2330	2330



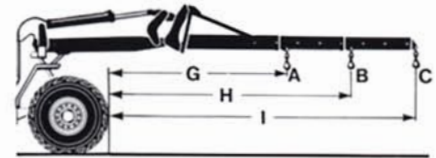
1) Load center distance 500 mm (19,7 in)
2) Load center distance 600 mm (23,6 in)

MATERIAL HANDLING ARMS

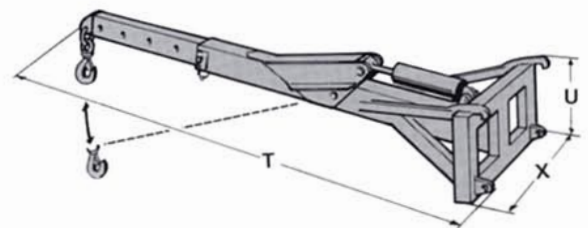


MATERIAL HANDLING ARM

The material handling arm is used on construction sites, for pipelaying etc. It has two telescopic sections with built-in mechanical stop to prevent overextension. Volvo BM furnishes type examination documents for Sweden.



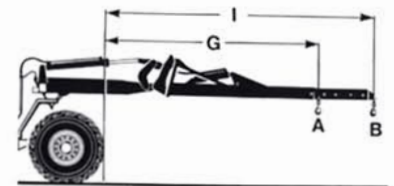
		L50	L70	L90	L120
Order No.		97824	97824	98761	98761
Weight	kg	360	360	455	455
Permissible load:	A	1120	1480	2200	3000
	B	940	1260	1750	2400
	C	750	1000	1450	2000
G	mm	3245	3270	3290	3245
H	mm	4310	4335	4325	4280
I	mm	5445	5465	5455	5410
T	mm	2030	2030	2050	2050
U	mm	840	840	840	840
X	mm	1180	1180	1180	1180



HYDRAULIC FOLDING MATERIAL HANDLING ARM

The material handling arm has a telescopic section and can be folded down hydraulically. It is used where loads have to be lowered below ground level or where obstacles have to be bypassed. The arm is equipped with a line rupture valve and the folding section can be lowered at a restricted rate.

Volvo BM furnishes type examination certificates for Sweden.



The attachment requires a 3rd hydraulic control.

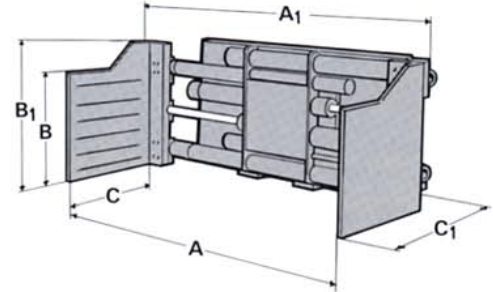
		L50	L70	L90	L120
Order No.		97819	97819	98762	98762
Weight	kg	410	410	560	560
Permissible load:	A	900	1150	1700	2300
	B	750	960	1400	1950
G	mm	4430	4455	4460	4415
I	mm	5425	5450	5460	5415
T	mm	3210	3210	3225	3225
U	mm	830	830	850	850
X	mm	1180	1180	1190	1190

OTHER ATTACHMENTS

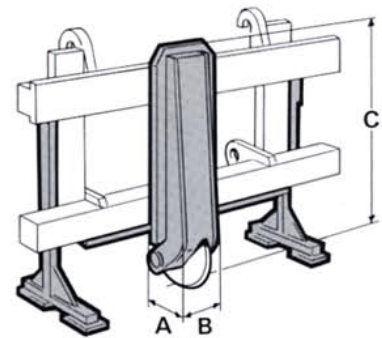
HYDRAULIC BALE CLAMP

The attachment is intended for handling baled material such as pulp bales, light scrap metal bundles etc.

The attachment requires a 3rd hydraulic control.



		L50	L70	L90	L120
Order No.		98067	98067	91105	91105
Clamping force	kg	4500	4500	9500	9500
Weight	kg	700	700	950	950
A min.	mm	850-	850-	900-	900-
A max.	mm	2400	2400	2700	2700
A ₁ min.	mm	1600-	1600-	1800-	1800-
A ₁ max.	mm	2560	2560	2900	2900
B	mm	370	370	500	500
B ₁	mm	850	850	980	980
C	mm	900	900	900	900
C ₁	mm	1250	1250	1250	1250



ASPHALT CUTTER

Facilitates removal of asphalt for repair work on road surfaces, pavements etc. The attachment makes one cut so that the asphalt edge is not damaged during the excavation work.

Mounted on fork frame.

Cutting depth 50-70 mm (3 in).

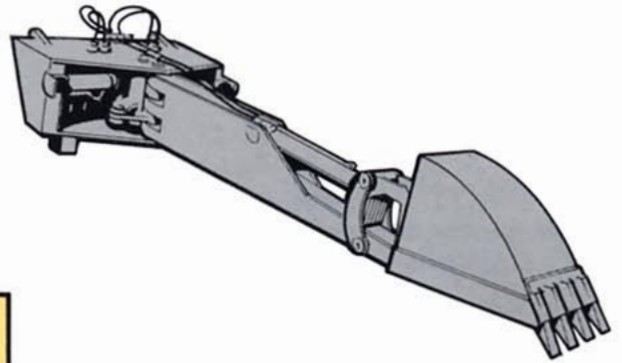
		L50	L70	L90	L120
Order No.		97815	97815	97815	97815
Weight	kg	96	96	96	96
A	mm	390	390	390	390
B	mm	280	280	280	280
C	mm	1050	1050	1050	1050

SERVICE DIGGER

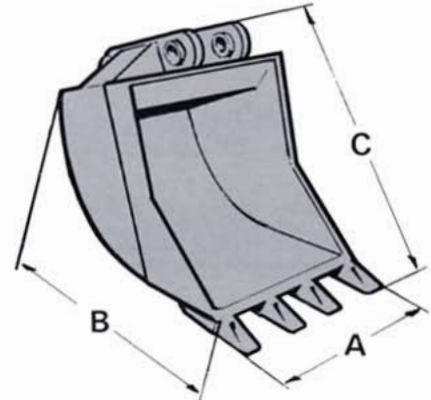
When coupled to the loader, the service digger comprises an agile and nimble unit, particularly suited for emergency service and repair jobs.

It is coupled to the loader's attachment bracket, and four hydraulic oil hoses are connected via quick-connect couplings. A lifting height of about 3 m and a side slew of 85° permit loading directly onto trucks with high sides. Raising and lowering of the bucket arm is effected by the loader's lifting and tilting cylinders. The digger unit's cylinders for bucket movement and side slew are double-acting.

3rd and 4th hydraulic controls as well as lever kit 90860 are required.



		L50	L70
Order No.		97977	
Weight	kg	850	
Max. digging depth	mm	3750	
Max. reach from center of drive wheel	mm	5355	
Unloading height	mm	3390	
Max. lateral deflection with tipped bucket	mm	3100	
Slewing angle	°	170	
Breakout force at bucket lip	kp	3100	



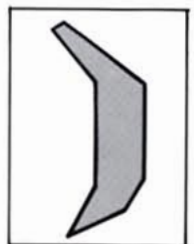
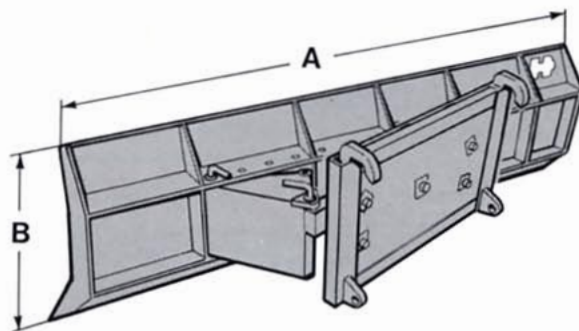
EXCAVATING BUCKETS

Three different buckets are available for the service digger. They can be changed easily.

		Excavating bucket	Post hole bucket	Cable bucket
Order No.		97821	97822	97823
Weight	kg	135	90	100
Volume	l	167	50	96
Number of teeth	st	4	4	4
A	mm	560	475	360
B	mm	1070	690	1070
C	mm	580	400	580

DOZER BLADE, HOLMS

The dozer blade is intended for dozing and leveling work and can be angled 20° to the right or left mechanically. The wear bar is reversible. Mounted in attachment bracket.

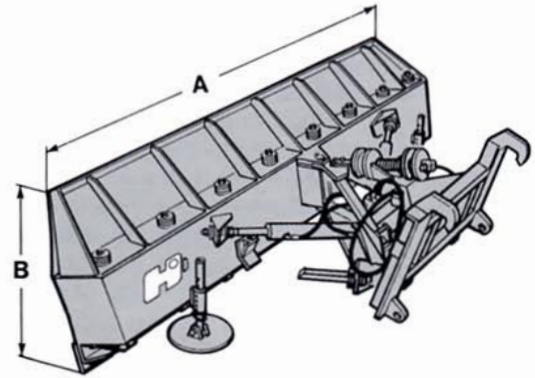


		L50	L70	L90	L120
Holms Order No.		F32550	F32550		
Weight	kg	480	480		
A	mm	2500	2500		
B	mm	800	800		

SNOW BLADE Type KHP, HOLMS
(municipal blade)

Recommended for snow clearance of roads etc. The blade has a reversible cutting edge divided into sections that fold back when they run into small obstacles such as manhole covers. Hydraulically adjustable 35° and equipped with horizontal oscillation with **variable ground pressure** for road-hugging performance. Can be equipped with rubber blades and snow screen.

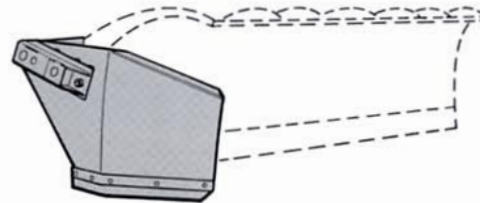
The attachment requires a 3rd hydraulic control.



		L50	L70	L90	L120
Holms Order No.		F31975	F31975		
Weight	kg	740	740		
A	mm	3200	3200		
B	mm	800	800		

SNOW WING, HOLMS

The snow wing prevents the creation of a ridge of snow when the plow passes driveways, intersections, pedestrian crossings etc. The snow wing is operated hydraulically and fits most Holms snow blades.

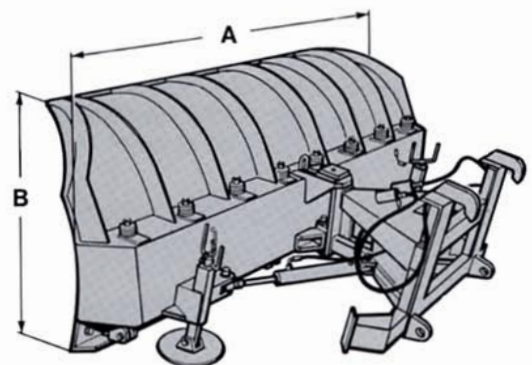


Holms Order No.		155079
Weight	kg	60

HEAVY-DUTY SNOW BLADE Type TKH, HOLMS
(municipal blade)

Recommended for snow clearance of roads etc. The blade has a reversible cutting edge divided into sections that fold back when they run into small obstacles such as manhole covers. Hydraulically adjustable 35° and equipped with horizontal oscillation. The blade can be fitted with rubber blades and snow screen.

The attachment requires a 3rd hydraulic control.



		L50	L70		L90		L120
Holms Order No.		F32125	F32125	F32225	F32125	F32225	F32225
Weight	kg	900	900	1100	900	1100	1100
A	mm	3200	3200	4000	3200	4000	4000
B	mm	1050	1050	1050	1050	1050	1050

SWEeper, HOLMS SBHL

For street cleaning where the sweepings do not have to be collected. Can be equipped with water tank and spray nozzle for laying the dust.

The sweeper is connected to the attachment bracket and the brush cylinder's two hydraulic motors are connected via quick-connect couplings to the 3rd hydraulic control. The brush pressure against the surface is regulated automatically. The brush cylinder has an easily replaceable brush made of polypropylene or rippled wire. The pivoting parking support provides stable parking of the sweeper.

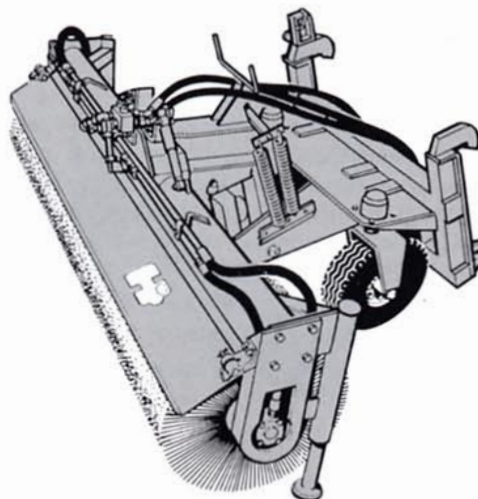
The attachment requires a 3rd hydraulic control.

The sweeper can be equipped with hydraulic pivoting 30° to the right/left, without disturbing the performance of the brush.

A 4th hydraulic control is required.

A hydraulic oil cooler and a single-acting lifting function are required.

A revolution counter is recommended.



		L50		L70		L90	
Holms Order No.		F22300	F22310*	F22375	F22310*	F22350	
Weight	kg	550	550	580	550	580	
Working width	mm	2500	2500	2500	2500	2500	
Brush cyl. diameter	mm	600	600	600	600	600	
Brush cyl. rot. speed	r/min	150	150	150	150	150	
Necessary hydr. pressure	kp/cm ²	75	75	75	75	75	
Necessary hydr. flow	l/min	100- 120	100- 120	100- 120	100- 120	100- 120	

* Dual-circuit hydraulics required.

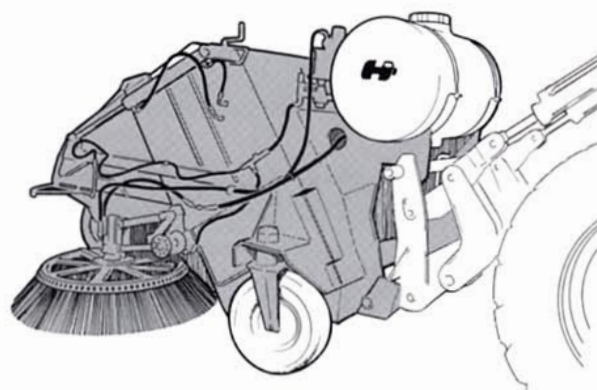
SWEeper, HOLMS 601

This fully hydraulic, self-collecting sweeper with high-pressure watering is particularly useful on park roads, pavements, industrial sites and in residential areas. The Holms 601 can be snapped on to the attachment bracket on a Volvo BM loader, providing an effective and economical system for public cleansing. The machine's 3rd hydraulic control powers the two bristle brushes, the sweepings elevator and the water pump for the spray nozzles. These nozzles create a dust-laying curtain around the brushes. A 3rd hydraulic control is required in order to empty the container.

The attachment requires a 3rd hydraulic control.

A hydraulic oil cooler and a single-acting lifting function are required.

A revolution counter is recommended.



		L50		L70		L90	
Holms Order No.		F20001	F20006*	F20002	F20006*	F20003	
Weight	kg	1160	1160	1200	1160	1200	
Working width	mm	2500	2500	2500	2500	2500	
Sweeping container volume	l	700	700	700	700	700	
Water tank volume	l	300	300	300	300	300	
Necessary hydr. flow	l/min	110	110	110	110	110	
Working pressure	kp/cm ²	90	90	90	90	90	
Water spray nozzles		16	16	16	16	16	
Carrying wheels		3	3	3	3	3	

* Dual-circuit hydraulics required.

SWEeper, HOLMS SBHL

For street cleaning where the sweepings do not have to be collected. Can be equipped with water tank and spray nozzle for laying the dust.

The sweeper is connected to the attachment bracket and the brush cylinder's two hydraulic motors are connected via quick-connect couplings to the 3rd hydraulic control. The brush pressure against the surface is regulated automatically. The brush cylinder has an easily replaceable brush made of polypropylene or rippled wire. The pivoting parking support provides stable parking of the sweeper.

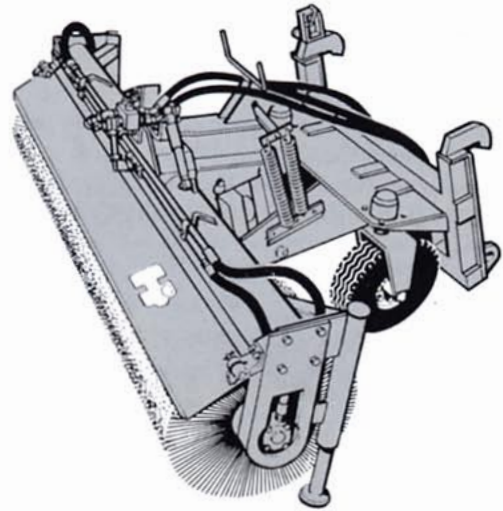
The attachment requires a 3rd hydraulic control.

The sweeper can be equipped with hydraulic pivoting 30° to the right/left, without disturbing the performance of the brush.

A 4th hydraulic control is required.

A hydraulic oil cooler and a single-acting lifting function are required.

A revolution counter is recommended.



		L50		L70		L90	
Holms Order No.		F22300	F22310*	F22375	F22310*	F22350	
Weight	kg	550	550	580	550	580	
Working width	mm	2500	2500	2500	2500	2500	
Brush cyl. diameter	mm	600	600	600	600	600	
Brush cyl. rot. speed	r/min	150	150	150	150	150	
Necessary hydr. pressure	kp/cm ²	75	75	75	75	75	
Necessary hydr. flow	l/min	100-120	100-120	100-120	100-120	100-120	

* Dual-circuit hydraulics required.

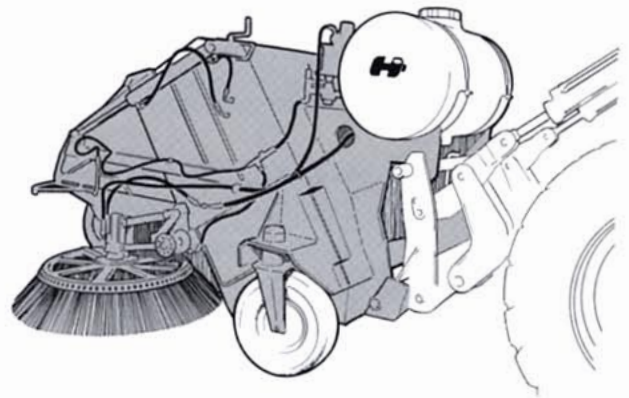
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The attachment requires a 3rd hydraulic control.

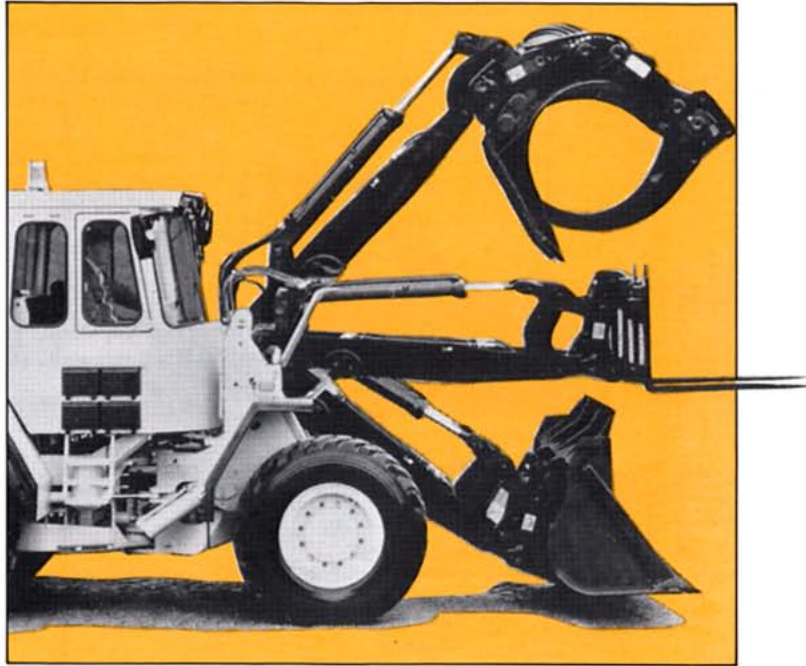
A hydraulic oil cooler and a single-acting lifting function are required.

A revolution counter is recommended.



		L50		L70		L90	
Holms Order No.		F20001	F20006*	F20002	F20006*	F20003	
Weight	kg	1160	1160	1200	1160	1200	
Working width	mm	2500	2500	2500	2500	2500	
Sweeping container volume	l	700	700	700	700	700	
Water tank volume	l	300	300	300	300	300	
Necessary hydr. flow	l/min	110	110	110	110	110	
Working pressure	kp/cm ²	90	90	90	90	90	
Water spray nozzles		16	16	16	16	16	
Carrying wheels		3	3	3	3	3	

* Dual-circuit hydraulics required.



"All over the world Volvo BM loaders have gained special status for their flexibility and reliability.

They can perform a wide range of tasks, no matter how tough, and they have extra capacity for coping with peak work times."

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