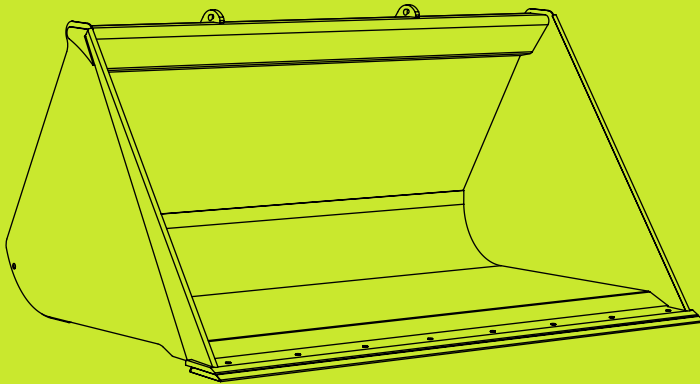


Bucket

Manual 2026



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Important Information

This manual details the relevant use, safety instructions, and maintenance procedures for Buckets. This document is not a training manual. Operators will need to be trained in the necessary skills to use the attachments before trying to work with it, or they risk being a danger to themselves and the people around them.

Important

Do not attempt to install, operate, or maintain any attachment until you have read and understood all the relevant operator documentation for both the attachment and the carrier machine. Pay strict attention to all relevant safety information. You must observe all relevant laws and regulations.

Intended Use

The BK, BKC light-medium duty range of Buckets are designed for handling loose agricultural materials such as grain and slurry. The HB medium duty range of Buckets are designed for bulk handling of low density materials such as woodchip or biomass. The PB medium-heavy duty range of Buckets are designed for handling the materials listed above, as well as uncompressed non-toxic industrial waste. These attachments must only be used for these purposes and under no circumstances should they be used as a lifting device, access platform, moving of palletised loads, moving logs or aggregates.

Carrier Machine Suitability

Always check the load capacity of the carrier machine is sufficient to use with the attachment. Make sure the carrier machine has the correct hitch pick-up / bracket type for the attachment.

Servicing

Only routine maintenance, as detailed in this manual, should be carried out by the user. It is recommended that major servicing be carried out by your respective dealer. When servicing, making adjustments, or cleaning, ensure that the appropriate personal protective equipment is worn. Always switch off the carrier machine and remove the key before servicing.

Product Identification

The Bucket has an identification plate located on the rear of the attachment. Use the 'Part Number' when identifying replacement parts.

		X-Form Engineering Griston IP25 6QA UK info@xformeng.com			
Part Number		Weight			
Model		Width			
Pick-up Type		Rated Capacity			
Serial Number		Year of Manufacture			

IMPORTANT Visit www.xformeng.com and read manual before use XF-IDBKv1

ID Plate Item	Description
Part Number	Attachment part number
Model	Attachment model
Pick-up Type	Pick-up/bracket hitch type
Serial Number	Unique serial number
Weight	Attachment weight, without tines, shown in kilograms
Width	Width of wear edge shown in millimeters
Rated Capacity	Rated capacity shown in cubic meters
Year of Manufacture	Year the attachment was manufactured

Safety Instructions



Warning

To operate the machine with the attachment safely, you must have the appropriate training and be authorised to use them. It is essential that operators observe all safety instructions as incorrect use can endanger life. You must abide by all relevant laws, including health and safety regulations that apply to the country you are operating in.

General Safety

In this manual, and on the attachment and machine, you will find warning messages. Read and understand them. They tell you of potential hazards and how to avoid them.

- Do not work with the attachment and machine until you are sure that you can control it and are sure that you and others around you will be safe.
- If you are unsure of anything about the attachments, machine, or the job, ask someone who knows. Do not assume anything.

Risk Assessment

- It is essential that a risk assessment of the work to be performed is completed and that the operator complies with all safety precautions that the assessment identifies. Do not put your life or others at risk.
- **DANGER!** It is the responsibility of the operator to assess factors affecting machine stability, including size and type load, angle of elevation, the distance the boom is extended, ground condition (remember that wet ground will not support the same loads as when dry), wind speed and direction before operating the machine.
- If you are unsure of the suitability of the attachment or machine for a specific task, contact your attachment / machine manufacturer or distributor, who will be able to advise you.

Installation & Removal



Warning

Keep other people clear of the area while you engage the attachment. If a second person is to be involved in this procedure, ensure that they keep clear of the machine and attachment until signalled by the operator to proceed.

Important

Before installation of the attachment, make sure it is within the carrier machines lifting capability (refer to carrier machine Operator Manual). The machine loading limits at different boom positions will be shown on the load charts located in the cab of the machine and/or in the carrier machine Operator Manual.

Installation of the Attachment

Never attempt to move the attachment manually. Pay particular attention to the safety notices and any specific notes about handling and installing (refer to carrier machines Operator Manual for hitching procedure). Remove any attachment from the pick-up/bracket hitch before proceeding.

- Make sure the attachment has the same pick-up/bracket hitch type as the carrier machine (the attachments pick-up type is shown on identification plate).
- Make sure the attachment is on firm, level ground and will not tip over.
- Fully engage the attachment with the carrier machines pick-up/bracket hitch.
- **IMPORTANT** Lock the attachment onto the carrier machine.

Removal of the Attachment

- Removal is the opposite to installation.

Operating Instructions



Warning

Make sure that you have had adequate training and that you are confident in your ability to operate the attachment safely before you operate it.

Important Safety Instructions

- Before using the attachment, ensure regular maintenance has been carried out and it is in good working order.
- Ensure the area is clear of personnel and other equipment before and during the operation of the attachment. If anyone enters the operating area, stop work and turn off the carrier machine.
- Ensure the attachment does not restrict forward vision or important sight-lines.
- Avoid electric power cables. You could be electrocuted or badly burned if you get the machine or its attachments too close to electrical power cables.
- When leaving the carrier machine, lower the attachment to the ground and turn off the engine.
- Make sure the proposed material to be moved does not exceed the combined weight of the attachment and the rated lifting capacity of the carrier machine.

Operation of the Attachment

CAUTION! This attachment can cause damage to the front tyres when the boom is lowered and the carriage is tilted forward. Exercise caution when lowering the boom with the carriage tilted forward when an attachment is fitted.

- Carefully drive into the pile and start rolling the bucket back while raising it at the same time. When loading from a pile of loose materials, start at the bottom and follow up the face. Approach the pile with the bucket level and skimming the ground. If the material is packed more tightly and stable, start at the top and work down. When removing material from a stockpile, start at a bucket's height from the base. Once the height of the stockpile has been reduced, begin loading from the base.
- If the load appears to be unstable, lower the load, and repeat the previous steps until the load is fully stable.
- To empty, raise the boom to the required position, dump the bucket forward and return to level position before lowering.
- Avoid wear edge scraping the ground with excessive force as this will increase wear.

Transporting Loads



Warning

The safe transit of the load is the responsibility of the machine operator and transport contractor. Any load that may move during transit must be adequately secured.

Transporting Loads with the Attachment

Before transporting loads with the attachment, make sure you obey the local rules and laws where the load will be carried through.

- Slowly raise the load to the minimum height required to safely cross the terrain, ensuring the load weight is within the capacity of the carrier machine.
- Operate the machine whilst ensuring the load always remain level.
- Accelerate, turn and brake gradually.
- Avoid any obstacles, bumps or holes on your intended path.
- Frequently check load to ensure the load has not become unstable.

Preparing the Attachment for Travel

It is your responsibility to comply with all the relevant local laws and regulations before taking the machine and attachment on the road or on site.

Maintenance

Daily Checks

- Check wear edges for excessive wear.
- Bolt on wear edge option. Check wear edge bolts for tightness.

Storage

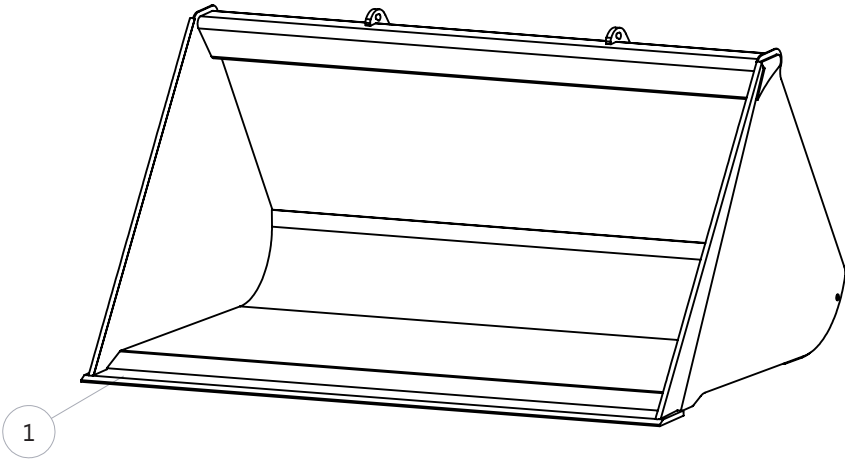
- Clean thoroughly, removing all mud and dirt.
- Inspect for visible signs of wear, breakage, or damage.
- Order any parts required and make the necessary repairs to avoid further wear or damage.
- Check wear edges for excessive wear.
- Bolt on wear edge option. Check wear edge bolts for tightness.
- Store in a dry and protected place.

Welding Wear Edges

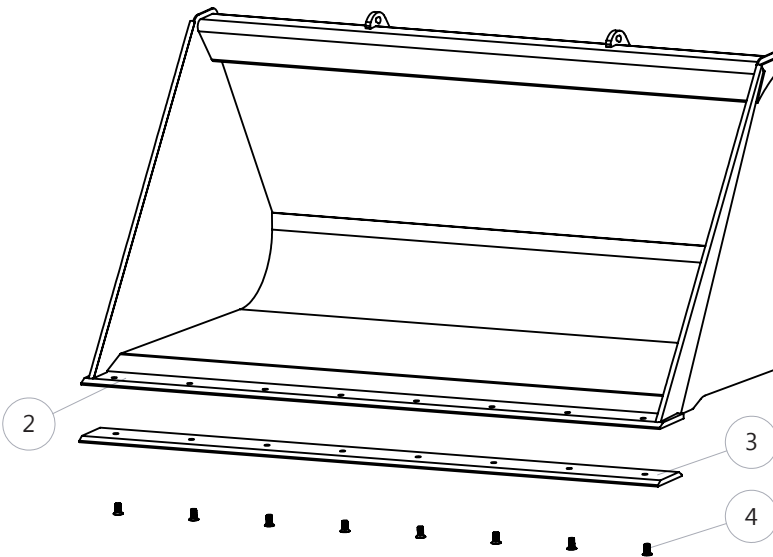
To prevent injury to yourself or others, welding should only be carried out according to EN 287 or AWS standards by an authorised welder.

- Do not weld with the attachment installed on the machine.
- Remove flammable material from the area around the attachment being welded.
- Provide screening to prevent radiation harming others.
- Ensure that the appropriate personal protective equipment (PPE) is worn.
- Always connect the earth clamp to the component being welded.
- Ensure the wear edge is level and square to the bucket.
- Do not stop and start welds at high stress areas. Avoid stress raising features, such as sudden changes of direction, welds with poor penetration and undercuts.
- Ensure the weld is sufficiently strong to hold the wear edge in place when in use.
- Allow the wear edge to cool before use.

Parts Diagram



Model Shown BK25-80



Bolt On Wear Edge option - Model Shown BK25-80D

Parts List

Welded Wear Edges

Item	Part No.	Description
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BK BKC 10 to 20 Bucket Ranges

1	WE150_??*	150x20mm HB500 Wear Edge
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BK BKC 25 to 30 Bucket Ranges

1	WE200_??*	200x20mm HB500 Wear Edge
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Bolt On Wear Edges

Item	Part No.	Description
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BK BKC 10 to 20 Bucket Ranges

2	WE150_DT_??*	150x20mm HB500 Drilled & Tapped Wear Edge
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3	WE150_BC_??*	150x20mm HB500 Bolt On Reversible Wear Edge
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4	WE_CB	Wear Edge Countersunk Bolt
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BK BKC HB 25 to 50 Bucket Ranges

2	WE200_DT_??*	200x20mm HB500 Drilled & Tapped Wear Edge
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3	WE200_BC_??*	200x20mm HB500 Bolt On Reversible Wear Edge
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4	WE_CB	Wear Edge Countersunk Bolt
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Plough Bolt Wear Edges

Item	Part No.	Description
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PB 10 to 20 Bucket Range

2	WE150_DS_??*	150x20mm HB500 Drilled Wear Edge
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3	WE150_PB_??*	150x20mm HB500 Plough Bolt Reversible Wear Edge
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4	WE_PB	Wear Edge Plough Bolt, Washer & Nut Set
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PB 25 to 30 Bucket Range

2	WE200_DS_??*	200x20mm HB500 Drilled Wear Edge
---	--------------	----------------------------------

3	WE200_PB_??*	200x20mm HB500 Plough Bolt Reversible Wear Edge
---	--------------	---

4	WE_PB	Wear Edge Plough Bolt, Washer & Nut Set
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*Replace '??' with 3rd & 4th numbers in the Part Number (see Product Identification).

Warranty

Our products are warranted for a period of 12 months from the date of delivery. The warranty does not apply to wear parts. Any work carried out on our products while under warranty must be done with written agreement from X-Form Engineering. At our discretion, we may require that the product be returned to us for rectification work and apply transport charges.

X-Form Engineering shall not be liable in any circumstances for any loss, injury, or expense, whether direct or indirect, which may arise for any reason whatsoever in connection with any goods supplied or work done.

X-Form Engineering Limited

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sales@xformeng.com



Declaration of Conformity

In accordance with UK Government guidance

Document Ref: XF_UKCA_BK_2026

Product: Bucket

Model(s): BK / BKC / HB / PB Ranges

Manufacturer: X-Form Engineering Limited
Church Road, Griston, Norfolk, IP25 6QA, England

This declaration is issued under the sole responsibility of the manufacturer.

Object of Declaration: Telehandler / loader agricultural material re-handling bucket. Fabricated from high strength steel and wear resistant edges.

The object of the declaration described above is in conformity with the relevant UK Statutory Instruments (and their amendments):

2008 No. 1597 Supply of Machinery (Safety) Regulations 2008

The manufacture applied the procedure for assessment of conformity with internal checks on manufacture. A conformity assessment body was not involved.

Additional Information: Technical documentation for the product is available from the manufacturer.

Authorised Signature: *Chris Leslie*
Chris Leslie | Technical Director of X-Form Engineering

Place of Issue: Church Road, Griston, Norfolk, IP265 6QA, England

Date Issued: 1st June 2026



Declaration of Conformity

EC Machinery Directive 2006/42 EC

Document Ref: XF_CE_BK_2026

Manufacturer: X-Form Engineering Limited
Church Road
Griston
Norfolk
IP25 6QA
England

Product: Telehandler / loader agricultural material re-handling bucket.
Fabricated from high strength steel and wear resistant edges.

Model(s): BK / BKC / HB / PB Bucket Ranges

Directive(s): 2006/42/EC Machinery Directive
Transposed Harmonised Standards: BS EN 1553 (2000)

We declare that the product named above complies with the relevant sections of the above referenced directive(s), including all the applicable essential health and safety requirements of the directive.

Signed: *Chris Leslie*

Name: Chris Leslie

Position: Technical Director of X-Form Engineering Limited

Date: 1st June 2026