

# BCS & Grillo Cutter Bar Blade Identification

In order to ensure that you order the correct replacement cutter bar blade sections (individual teeth) OR complete blade assemblies, the following figures will allow you to match up the original blade to the proper part numbers. PLEASE READ THOROUGHLY!!!

**Fig. #1**  
2" wide



## Cutter Bar Blades, "Mulching" or "Sickle" type

This is the oldest type of BCS blade, in production from 1974 to 1994. (Strip that blades are riveted to is UNDERNEATH blade sections)

*D2001, 85315, or 48945 will be stamped into this blade.*

Individual Blade Section # 580.48945

Uses 5.3mm Dia. Rivets:

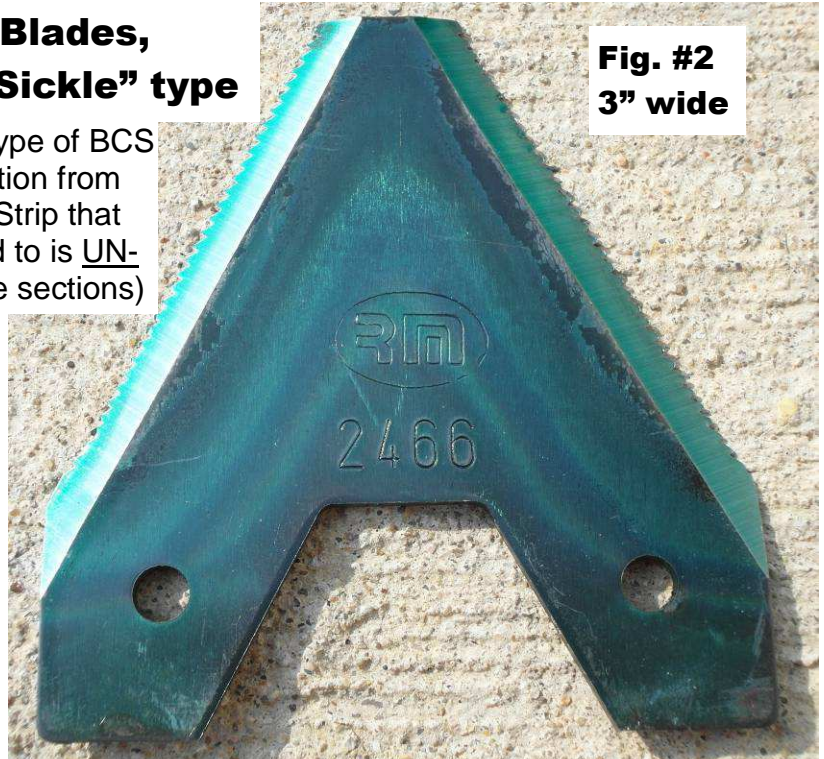
Long (5.3x18) # 331.12531

Short (5.3x14) # 331.12530

44" Complete Blade Assembly # 590.48946

50" Complete Blade Assembly # 590.48948

**Fig. #2**  
3" wide



*2466 or 212 will be stamped into this blade.*

Individual Blade section # 580.02466

Uses 5.3mm Dia. Rivets:

Short (5.3x14) # 331.12530

Long (5.3x18) # 331.12531

44" Complete Blade Assembly # 590.43544

50" Complete Blade Assembly # 590.43553



**Fig. #3**  
2" wide

## Cutter Bar Blades, 6.3 mm rivets, Combo/Europa type (Strip that blades are riveted to is ON TOP of blade sections)

*50696, 50684 or 59016 will be stamped into this blade type*

This is the blade type that was produced on BCS cutter bars from around 1997 to around late 2013. NOTE: Some older bars had "smooth-edged" teeth, rather than Serrated (the Serrated blades can be used in their place).

Individual Blade Section: # 563.50696

6.3mm Dia. Rivets: Short (6.3x13) # 331.12608, Long (6.3x16) # 331.12609

30" Blade Assembly—200 Series tractors-OLD (4 bolt blade coupling)590.50620

30" Blade Assembly—200 Series tractors-NEW(2 bolt blade coupling)590.59108

30" Blade Assembly—600, 700 & 800 Series # 590.48928

39" Blade Assembly—600, 700 & 800 Series # 590.48926

45" Blade Assembly—600, 700 & 800 Series # 590.48909

53" Blade Assembly—600, 700 & 800 Series # 590.48906

**NOTE:** Some Replacement blade assemblies have individual blades with 5.3mm diameter rivets, rather than 6.3mm!! These teeth would be stamped with 59015 (see Fig. 4). If 6.3mm blades / rivets need to be used on a blade strip with 5.3mm dia. Holes, simply drill out the holes in the strip to 17/64".

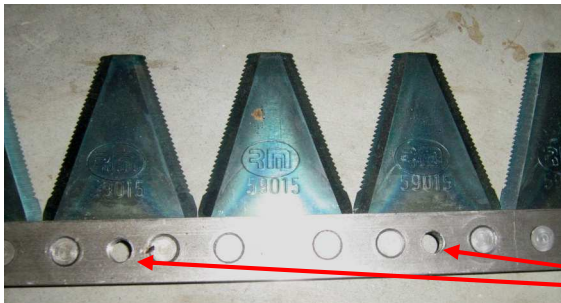


# Cutter Bar Blades, 5.3 mm rivets, Combo/Europa type

(Strip that blades are riveted to is ON TOP of blade sections)

In 1995, when BCS first started producing “Tapered-3-tooth PTO” tractors and implements, the cutter bars were changed to a different blade coupling system and blade section type. This was mostly disastrous, as the new couplings proved to be troublesome in that they loosened up more often (this blade type can be identified by that fact that the 2 bolts holding the blade coupling to the blade assembly have DIFFERENT size heads, and lacked a “serrated plate” that the blade coupling bolted down to...we call this type a “**bolt-on blade coupling**”).

The blade sections on this type of blade were also installed differently: instead of rivets being installed from the bottom and hammering on the top of the rivets, **these were designed to have the rivets go down from the top and be hammered on the bottom-side.** (Any excess rivet head material that won't fit into the “countersunk” hole in the bottom of the blades needs to be removed with a grinder so the blade will lay flat on the lower stationary blades.) These blades can be identified by the large hole between the rivet placement holes and the stamping **59015**. BCS abandoned the “Bolt-on” coupling system by 1997. *(If you have this style blade and want to change over to the newer type (figure 3) blade type with it's stronger blade coupling type, this is possible, but multiple components must be changed; ask Earth Tools for a quote.)*



**Figure 4A:** “Bolt-on” type blade; note that there is no “serrated plate” on the blade to attach the blade coupling to...instead, the bolt-holes are drilled directly in the “strip.”



**Figure 4B:** “Standard” type blade; note the “serrated plate” riveted to the blade to attach the blade coupling onto, with threaded bolt-holes in plate for mounting blade coupling.



**Fig. #4**  
**2” wide**

**59015 will be stamped into this blade.**

Individual Blade section # 563.59015

**Uses 5.3mm Dia. Rivets:**

Long (5.3x18) # 331.12531 Short (5.3x14) # 331.12530

### These Blade Assemblies for “Bolt-on” blade coupling type ONLY:

30” Blade Assembly—600, 700 & 800 Series # 590.59030

39” Blade Assembly—600, 700 & 800 Series # 590.59031

45” Blade Assembly—600, 700 & 800 Series # 590.59032

53” Blade Assembly—600, 700 & 800 Series # 590.59033

(For Replacement Blade Assemblies to fit Grillo single-action cutter bars, use the part numbers from the previous table (blade type 563.50696, figure 3))

**NOTE:** The **59015** blade sections are also current production on all **Grillo** brand single-action cutter bars, and fit some of the **replacement** blade assemblies sold for BCS single-action units as well. **ALSO**, they can be used on any Older-style BCS Combo/Europa style cutter bars that had 5.3mm Dia. Rivets (many units produced before 1990) **When used in THESE applications, rivets are installed with the standard method (In from the bottom, hammered on top)!!!**

**Fig. #5**  
**3" wide**



## **BCS Double Action (Duplex) Cutter Bar Blades**

With the advent of their Double-Action (both upper AND lower blade assemblies move) cutter bars in 2006, BCS introduced new blades and rivets. These blades are thicker than the single-action blades, but use 5.3mm Diameter rivets...typically, the rivets on this style act as "shear pins" and if a hard object is encountered, will break before the blades do. **NOTE: These rivets get installed from the TOP, and hammered down on the BOTTOM. ALSO, it is very important that the correct length rivets be used in the correct locations:**

**331.25312 (short rivet- 12mm long):**  
Blade & strip ONLY

**331.25314 (medium rivet- 14mm long):**  
Blade, strip and center strip for blade drive coupling

**331.25316 (long rivet- 16mm long):**  
Blade, strip and "sockets" for blade tensioners

**28096 will be stamped into this blade.**  
Individual Blade section # 580.28096

- 47" Upper Blade Assembly— # 590.58625
- 59" Upper Blade Assembly— # 590.58585
- 71" Upper Blade Assembly— # 590.58611

## **BCS "LASER" Cutter Bar Blades**

(Strip that blades are riveted to is ON TOP of blade sections)

BCS changed their single-action cutter bars in late 2013 to a new construction they call the "Laser" cutter bars. These use different upper AND lower teeth than any previous BCS, as well as different rivets and blade coupling strip. In short, virtually **NOTHING** will interchange from older BCS cutter bars. **Rivets on this style blade can be installed from EITHER direction, top or bottom.**

**58716 will be stamped into this blade type**

Individual Blade Section: # 563.58716

- 30" Blade Assembly—# 590.58724T
- 39" Blade Assembly—# 590.58728T
- 45" Blade Assembly—# 590.58739T
- 53" Blade Assembly—# 590.58740T

**6.3mm Dia. Rivets:** Short (6.3x13) # 331.26513, Long (6.3x16) # 331.26516

**Fig. #6**  
**2" wide**

