



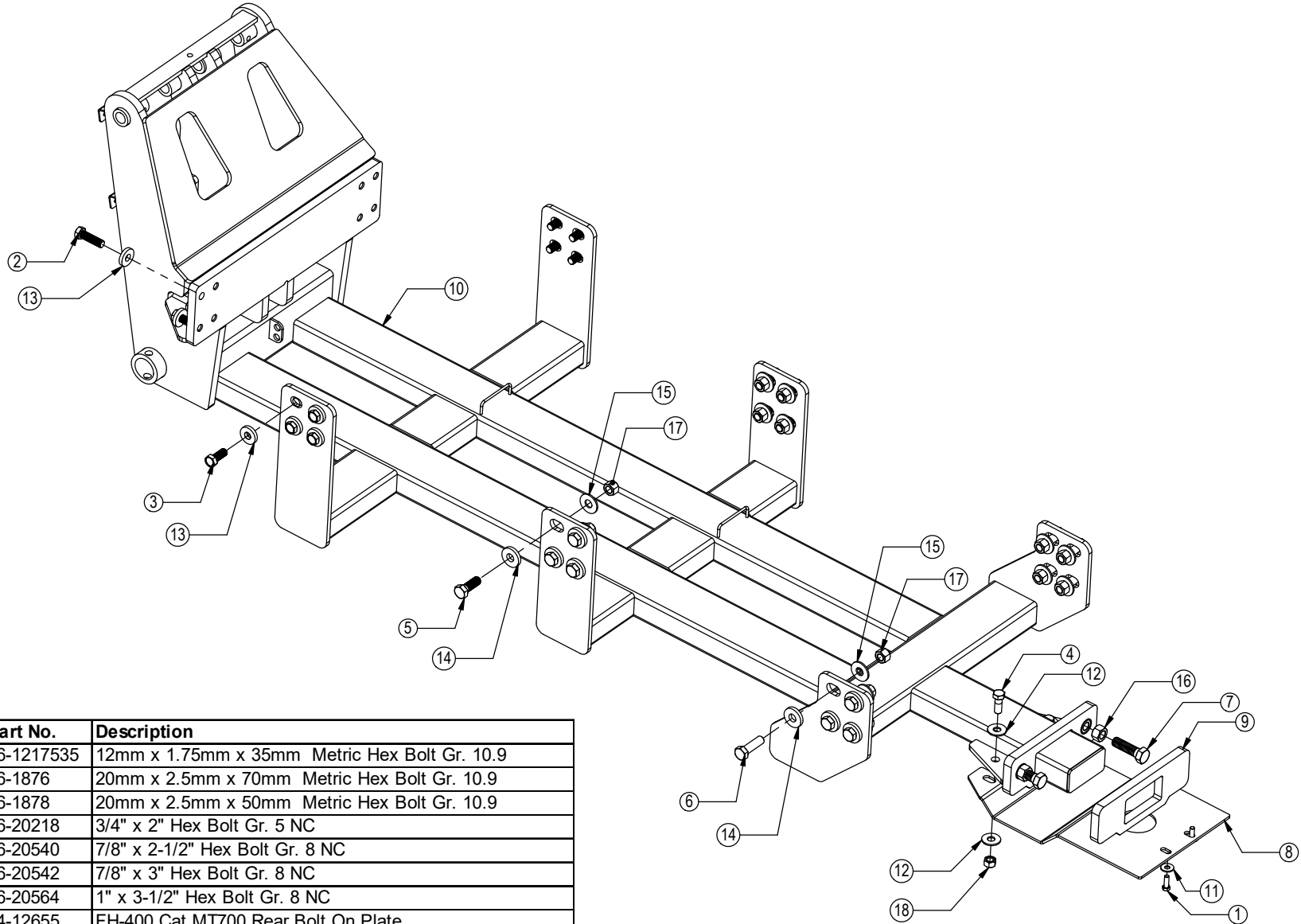
FH-400 CAT MT700E Series

Undercarriage Installation Instructions

Caution:

- Always use precaution when working around any equipment.
- Always wear safety glasses.
- Follow tractor manufacturer's safety guidelines when installing this product.
 1. Read all instructions prior to installation.
 2. Remove weights and weight bracket from front of tractor if necessary.
 3. Install 2 - 1" x 3-1/2" bolts (PN: 16-20564) and 2 - 1" nuts (PN: 70-20589) on the rear plate on the undercarriage. Tighten the bolt as far as it will go. See attached diagram for any clarification.
 4. Set the rear push plate (PN: 44-17688) over the rear tube and up against the bolts. This will be tightened up against the tractor frame in a later step.
 5. Position the undercarriage (U/C) under the tractor and center with the frame of the tractor.
 6. Lift the U/C until the holes on the tractor line up with the holes on the U/C.
 7. At the front of the tractor, start 8 - 20mm x 70mm bolts (PN: 16-1876) with a 3/4" heavy washer (PN: 57-3680) on each bolt in the holes. See attached diagram for any clarification.
 8. Start 8 - 20mm x 50mm bolts (PN: 16-1878) with a 3/4" heavy washer (PN: 57-3680) on each bolt in the holes of the first side plates and the tractor frame. Hand tighten until the washers are in contact with the U/C.
 9. Insert 8 - 7/8" x 2-1/2" bolts (PN: 16-20540) with a 7/8" heavy washer (PN: 57-3681) on each bolt through the holes of the second side plates and the tractor frame. Install a 7/8" heavy duty washer and hand tighten a 7/8" hex nut (PN: 70-20598) onto each bolt.
 10. Insert 8 - 7/8" x 3" bolts (PN: 16-20542) with a 7/8" heavy washer (PN: 57-3681) on each bolt through the holes of the third side plates and the tractor frame. Install a 7/8" heavy duty washer and hand tighten a 7/8" hex nut (PN: 70-20598) onto each bolt.
 11. Once all bolts are finger tight and the U/C lines up correctly with the tractor frame, torque all 7/8" bolts to 600 ft-lbs. and all 20mm bolts to 432 ft-lbs.
 12. Push the rear push plate up against the frame of the tractor. Unscrew the 1" x 3-1/2" bolts until they are tight against the rear push plate. Torque the 1" bolts to 90-95 ft-lbs.
 13. Tighten the nuts up tight against the push pole. Use the nuts to lock the bolts in place.
 14. Remove the 2 bolts from the pan underneath the tractor just behind where the undercarriage ends.
 15. Attach the rear bolt on plate (PN: 44-12655) to the undercarriage with 2 - 3/4" x 2" bolts (PN: 16-20218), 4 - 3/4" flat washers (PN: 57-20747), and 2 - 3/4" nuts (PN: 70-20607).
 16. Install 2 - 12mm x 35mm bolts (PN: 16-1217535) and 2 - 1/2" flat washers (PN: 57-20744) through the rear holes of the bolt on plate and of the holes that the bolts were removed from in Step #14. Torque the 3/4" bolts to 257 ft-lbs. and the 12mm bolts to 109 ft-lbs.
 17. After first 8 hours of use, re-torque all bolts.
 18. Check all fasteners regularly to ensure proper operation of equipment.

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Item No.	Qty.	Part No.	Description
1	2	16-1217535	12mm x 1.75mm x 35mm Metric Hex Bolt Gr. 10.9
2	8	16-1876	20mm x 2.5mm x 70mm Metric Hex Bolt Gr. 10.9
3	8	16-1878	20mm x 2.5mm x 50mm Metric Hex Bolt Gr. 10.9
4	2	16-20218	3/4" x 2" Hex Bolt Gr. 5 NC
5	8	16-20540	7/8" x 2-1/2" Hex Bolt Gr. 8 NC
6	8	16-20542	7/8" x 3" Hex Bolt Gr. 8 NC
7	2	16-20564	1" x 3-1/2" Hex Bolt Gr. 8 NC
8	1	44-12655	FH-400 Cat MT700 Rear Bolt On Plate
9	1	44-17688	FH-400 Cat MT700 Plate, Rear Push
10	1	54-17670	FH-400 UC Challenger MT700E
11	2	57-20744	1/2" Flat Washer
12	4	57-20747	3/4" Flat Washer
13	16	57-3680	2.00" OD x .75" ID x .375" Heavy Washer CZ Plated
14	16	57-3681	2.25" OD x .875" ID x .375" Heavy Washer CZ Plated
15	16	57-20818	7/8" Flat Washer Heavy Duty Gr 8 (USS)
16	2	70-20589	1" Hex Nut Gr. 5 NC
17	16	70-20598	7/8" Hex Nut Gr. 8 NC
18	2	70-20607	3/4" Hex Center Lock Nut Gr 2 NC



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