



Case STX Quadtrac

Ag Pro 660HD Undercarriage Installation Instructions

For Models:

Case STX Quadtrac: 480, 485, 530, 535

Purchase Date
Serial Number
Model Number
Tractor Model
Dealer

To The Owner

This manual contains information concerning the installation of the undercarriage. You have purchased dependable, long lasting equipment, but only by proper care and operation can you expect to receive the performance and long service built into our products. Please have all operators read this manual carefully and keep the manual available for ready reference. If you have any questions or concerns, contact Grouser Products.

Caution:

- Always use caution when working around any equipment.
- Always wear safety glasses.
- Follow tractor manufacturer's safety guidelines when installing this product.
- Use paint where necessary to prevent rust.
- Do not modify or permit anyone else to modify or alter the equipment and its components without first consulting Grouser Products.

Note:

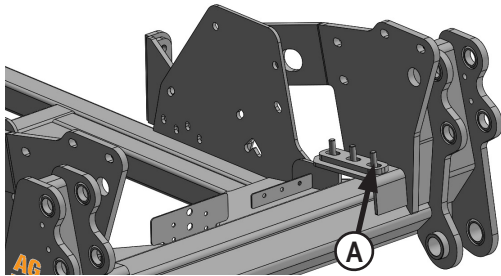
- When installing hardware, only finger tighten until all hardware is in place.
- A full diagram of the assembly with the full list of parts is on pages 6-7.
- Unstrap and remove any components that are attached for shipping.
- Read all instructions prior to performing installation.
- Tractor frame not shown in some diagrams for clarity.



Serial Number Location

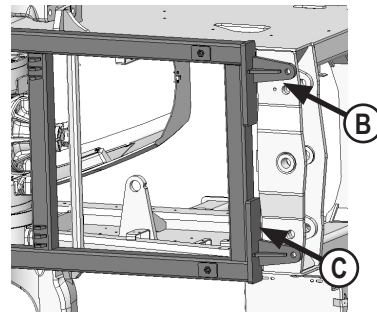
Installation

1. If applicable, remove front weights, weight bracket, tow cable, tow cable holder and toolbox from front of tractor.
2. Remove the bottom two bolts from the front nose casting on each side of the tractor to have clearance for installing the undercarriage.

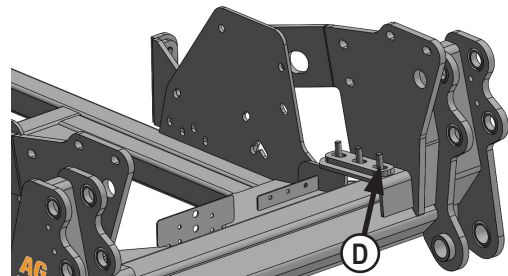


3. Insert 6 - 20mm x 90mm bolts and 6 - trimmed washers in the front vertical slots at the front of the undercarriage (A).
4. Position undercarriage under tractor and center on the frame of the tractor. Lift undercarriage to within 3/4" of touching the tractor frame.

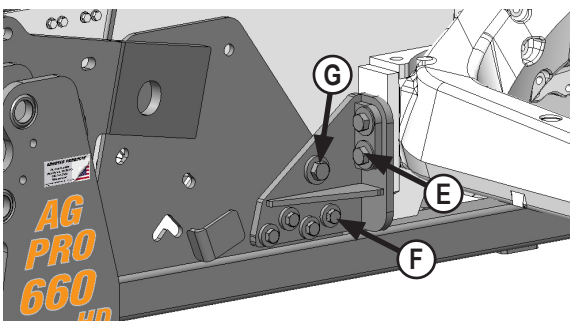
NOTE: When lifting the undercarriage, watch for any potential pinching of hoses or any other components to prevent any damage. Be aware of the 20mm x 90mm bolts so that you do not damage the threads.



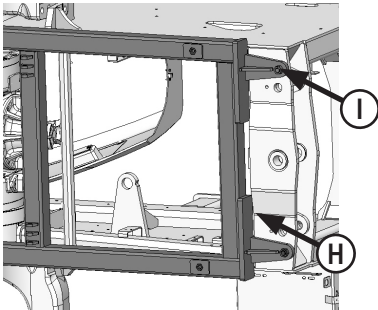
5. Lift the rear of the undercarriage until the two mounting ears touch up against the tractor's cross member (B).
6. Push the undercarriage back until the vertical push plates are firmly against the cross member (C). Clamp the rear mounting ears to the cross member to prevent movement of the undercarriage.



7. Install the front 20mm x 90mm bolts and washers from Step #3 into the tractor frame. Tighten until frame is tight vertically. (D).
8. Reinstall the front nose casting bolts removed in Step #2.

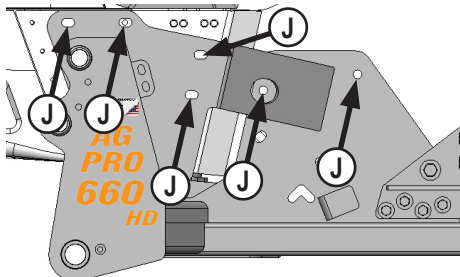


9. Remove the 2 - 24mm bolts and spacers from the front axle on the both sides of the tractor. Discard the spacers.
10. Dip the previously removed 24mm bolts in W30 oil. Attach the quad brackets to the front axles with the oiled 24mm bolts and 1" heavy duty washer (E).
11. Attach the quad brackets to the undercarriage with 8 - 3/4" x 3" bolts, 16 - 3/4" heavy washers, and 8 - 3/4" nuts in the bottom four holes (F).
12. Install 2 - 1" x 3-1/2" bolts, 4 - 1" heavy washers, and 2 - 1" nuts in the top quad bracket hole and the tractor frame (G).



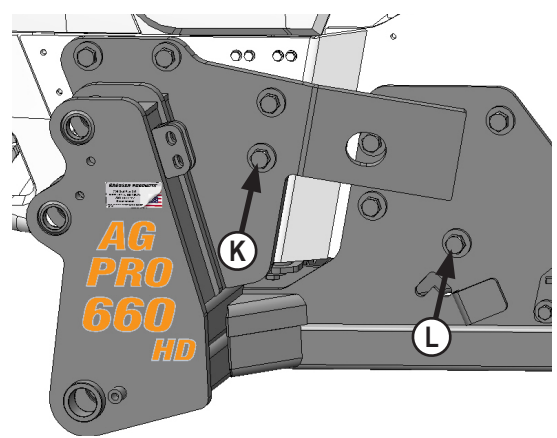
NOTE: Be sure that the vertical push plates are firmly against the cross member (H).

13. Using the two holes in the rear ears as guides, drill 2 - 1" holes through the cross member. Install 2 - 1" x 3" bolts and 2 - 1" nuts (I).
14. Torque the rear 1" bolts (I) to 903 ft-lbs.
15. Torque the front vertical 20mm bolts (D) to 432 ft-lbs.
16. Torque the 24mm axle bolts (E) to 555 ft-lbs.
17. Torque the 3/4" quad bracket bolts (F) to 257 ft-lbs and the 1" bolts to 903 ft-lbs (G).

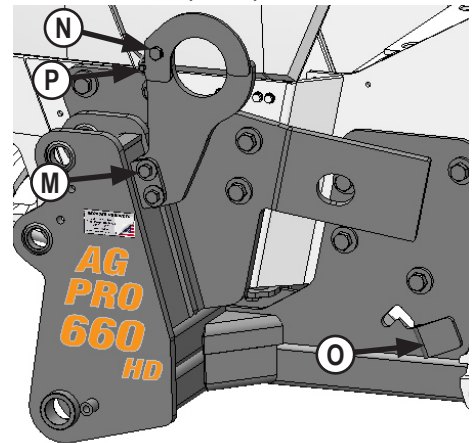


Caution: When drilling, be aware of all parts behind the material being drilled so that you do not mistakenly hit or puncture components on engine side of tractor frame.

18. Using the undercarriage as a guide, drill 12 - 1" holes through the side of the tractor frame (J).



19. Attach the front side plates of the undercarriage to the tractor frame with 8 - 1" x 3-1/2" bolts, 16 - 1" Heavy washers, and 8 - 1" nuts (K).
20. Install 8 - 1" x 3" bolts, 16 - 1" Heavy washers, and 8 - 1" nuts in the 4 side holes of the undercarriage and tractor frame (L).
21. Torque the side 1" bolts (K & L) to 903 ft-lbs.



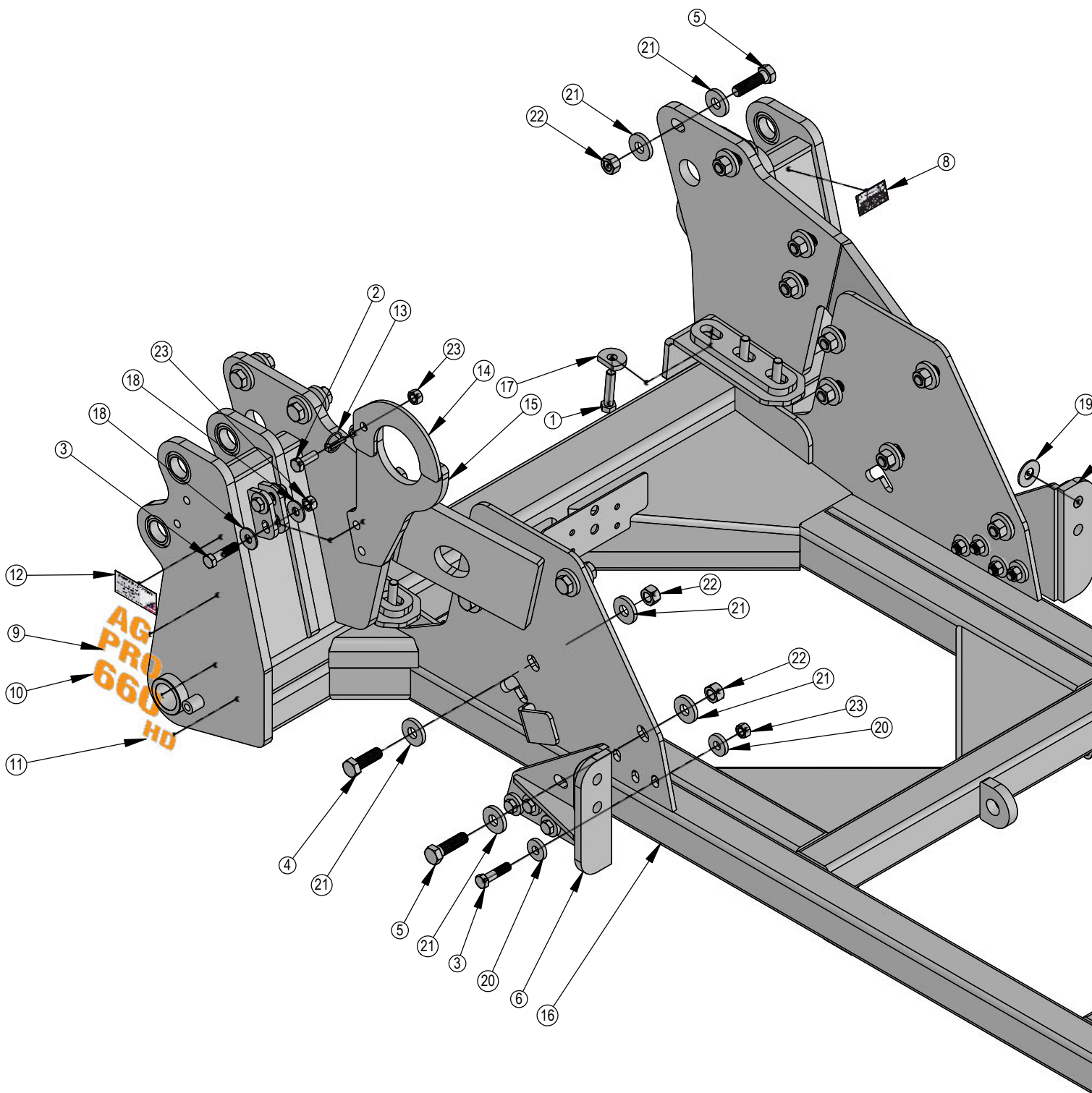
22. If tow cable is available, install the tow cable bolting plate between the plates on the left of the undercarriage with 2 - 3/4" x 3" bolts, 4 - 3/4" flat washers, and 2 - 3/4" lock nuts (M). Torque the 3/4" bolts to 257 ft-lbs.
23. Attach the latching plate to the bolting plate with a 3/4" x 2" bolt and 3/4" lock nut (N).
24. Place the tow cable between the undercarriage and the L-shaped plate on the left side in front of the quad bracket (O). Hook the tow cable on the tow cable bolting plate. Position the latching plate so the cable stays in place. Lock the latching plate with a lynch pin (P).

Assembling Lift Components

1. Refer to the Blade Owner's Manual & Parts Book for instructions on how to assemble the lift components.

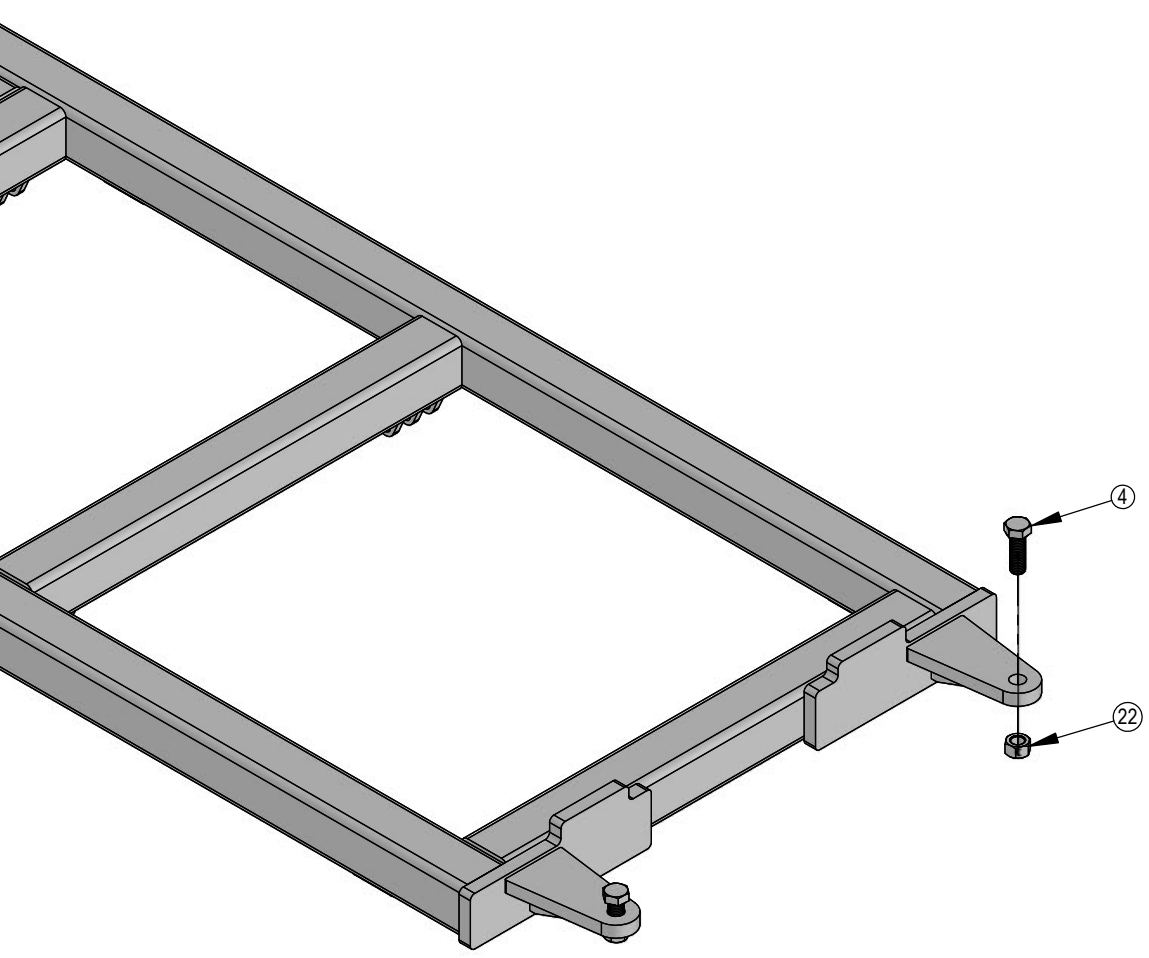
Maintenance

1. After first 8 hours of use, re-torque all bolts.
2. Check all fasteners regularly to ensure proper operation of equipment.
3. Inspect all equipment for existing or potential damages every 10 hours or less.



ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	6	16-1510	20mm x 2.5mm x 90mm Hex Bolt
2	1	16-20218	3/4" x 2" Hex Bolt Gr.5 NC
3	10	16-20222	3/4" x 3" Hex Bolt Gr.5 NC
4	10	16-20562	1" x 3" Hex Bolt Gr.8 NC
5	10	16-20564	1" x 3-1/2" Hex Bolt Gr.8 NC
6	1	18-5170-L	Quad Bracket - Left
7	1	18-5170-R	Quad Bracket - Right
8	1	NA	Grouser Dozer Metal Serial Tag
9	2	27-14840	Grouser Name Plate Decal
10	2	27-14841-660	Grouser Name Plate Decal
11	2	27-15588	HD Decal
12	1	27-18887	Grouser Name Plate Decal
13	1	43-9360	7/16" x 1-3/4" Lynch Pin
14	1	44-12789	Plate
15	1	44-12790	Plate
16	1	54-18205	Belly Pan Ready UC
17	6	57-11659	Trimmed Washer
18	4	57-20747	3/4" Flat Washer
19	4	57-20819	1" Flat Washer Heavy Duty Gr 8 (USS)
20	16	57-3680	3/4" ID x 2.00 OD x .375" Heavy Washer CZ Plated
21	36	57-3682	1.00" ID x 2-1/2" OD x .375" Heavy Washer CZ Plated
22	20	70-20599	1" Hex Nut Gr 8 NC
23	11	70-20607	3/4" Center Lock Hex Nut Gr 2 NC

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DWG. NO.: 18205-A

Improvements

Grouser Products Inc. is continually striving to improve its products. We reserve the right to change prices, specification, or equipment at any time without notice. We also reserve the right to make improvements or changes when it becomes practical and possible to do so without incurring any obligation to make changes or additions to the equipment sold previously.

Warranty

Grouser Products warrants to the original purchaser of each item that the product be free from defects in material and workmanship under normal use and service for a period of **two (2) years for Agriculture Series Blades and one (1) year for Heavy Duty Series from date of original retail delivery.**

The obligation of the consumer under this warranty:

1. To read the operators manual and to operate, lubricate, maintain and store equipment in accordance with the instructions listed in the operators manual.
2. To inspect equipment and if any part needs repair or replacement when continued use would cause damage or wear to other parts or safety.
3. All equipment or parts claimed to be defective in material or workmanship must be made available for inspection at the place of business of a dealer authorized to handle the equipment covered by this warranty, or, upon request by Grouser Products, shipped to the Grouser Products factory in West Fargo, North Dakota.

The obligation of the dealer under this warranty:

1. Complete warranty registration form and submit within 30 days of sale.
2. Contact Grouser Products for authorization prior to performing any warranty repairs or part replacement.
3. Complete warranty request form and submit with photos and supporting documentation.

The obligation of Grouser Products under this warranty:

1. Repair or replace, any equipment or parts, in the judgment of Grouser Products to be defective in material or workmanship.
2. Grouser Products will cover the cost of parts and ground shipping at dealer invoice only.
3. Grouser Products shall have no obligation to bear the cost of labor or transportation in connection with replacement or repair of any such defective parts.

This warranty does not cover:

1. Depreciation or damage caused by normal wear, accident, improper assembly, improper adjustments.
2. Improper maintenance including lack of proper lubrication, or improper use. Including loose bolts, nuts, or fitting due to over tightening or vibration after 20 hours of operation.
3. Repairs or alterations without authorization from a Grouser Products representative.
4. Grouser Products shall have no liability if the equipment has been altered or reworked without the written authorization of Grouser Products.

Grouser Products' parts, which are furnished under this warranty and properly installed, shall be warranted to the same extent as the original parts under this warranty if, and only if, such parts are found to be defective within the original warranty period covering the original equipment.

NO EMPLOYEE OR REPRESENTATIVE OF GROUSER PRODUCTS IS AUTHORIZED TO CHANGE THE WARRANTY IN ANY WAY OR GRANT ANY OTHER WARRANTY.

Contact Us

As always, if you have any questions about your system or other products made by Grouser, feel free to contact us.



755 2nd Ave NW - West Fargo, ND 58078
+1 701-282-7710 | info@grouser.com
www.grouser.com