660 Case STX Quad 480-535 Cast Yoke
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 existing toolboxes and tow cable holder if equipped.
3. Remove the 2 - 24mm bolts and spacers from the front axle on the left and right side of the tractor. Discard the spacers.
4. Install the yoke brackets (PN: 18-5170-R,L) (see attached diagram for correct orientation). Dip the previously removed 24mm bolts in W30 oil and install with a heavy flat washer (PN: 57-20819) on each bolt and tighten finger tight.
5. Remove the bottom 2 bolts from the front nose casting on each side of the tractor for undercarriage (U/C) clearance.
6. Insert 6 - 20mm x 90mm bolts (PN: 16-1510) with a 0.91” ID heavy washer (PN: 57-11659) on each of the bolts into the front vertical slots at the front of the U/C. See attached diagram for clarification. Caution: When lifting the undercarriage, be aware of the 20mm x 90mm bolts so that you do not damage the threads.
7. Position the undercarriage under tractor and center on the frame of the tractor. Lift U/C to within 3/4” of touching the tractor frame.
8. Push the U/C back until the vertical push plates are firmly against the cross member. Clamp the rear mounting ears to the cross member to prevent movement of the U/C.
9. Insert the 20mm x 90mm bolts (PN: 16-1510) with washers from Step #6 into the tractor frame. Tighten until frame is tight vertically.
10. Reinstall the front nose casting bolts removed in Step #5.
11. Verify that the rear mounting ears and the vertical push plates are still tight against the cross member and that the yoke bracket holes line up with the U/C holes.
12. Using the two holes in the ears as guides, drill 2 - 1” holes through the cross member and install 2 - 1” x 3” bolts (PN: 16-20562) with a 1” nut (PN: 70-20599) on each bolt. Tighten finger tight.
13. Using the U/C as a guide, drill the 8 - 1” holes through the side of the tractor frame. 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.
14. Attach each yoke bracket to the U/C with 4 - 3/4" x 3" bolts (PN: 16-20222), 8 - 3/4" ID heavy washers (PN: 57-3680), and 4 - 3/4" nuts (PN: 70-20607) in the bottom 4 holes. Use a 1" x 3-1/2" bolt (PN: 16-20564), 2 - 1" heavy washers (PN: 57-3682), and a 1" nut (PN: 70-20599) in the top hole of each yoke bracket.

15. Attach the side plates of the U/C to the tractor frame with 2 - 1" x 3" bolts (PN: 16-20562), 4 - 1" heavy washers (PN: 57-3682), and 2 - 1" nuts (PN: 70-20599) on each side of the U/C. See attached diagram for clarification.

16. Insert 4 - 1" x 3-1/2" bolts (PN: 16-20564) with a 1" heavy washer (PN: 57-3682) on each bolt into the 4 side holes on each side of the U/C and the drilled holes in the tractor frame. See attached diagram for clarification.

17. After all 8 bolts are through the tractor frame, attach with a 1" heavy washer (PN: 57-3682) and 1" nut (PN: 70-20599) on each bolt.

18. Once all bolts have been installed, torque the two rear ear 1" bolts to 903 ft·lbs.

19. Torque the 4 - 24mm bolts to 555 ft·lbs. and the 8 - 3/4" yoke bracket bolts to 257 ft·lbs.

20. Torque the 6 - 20mm front vertical bolts to 432 ft·lbs., and the remaining 1" bolts to 903 ft·lbs.

21. After first 8 hours of use, re-torque all bolts.

22. Check all fasteners regularly to ensure proper operation of equipment.
Drill tractor frame and install 4 - 1” bolts on each side.

Some items not shown for clarity.

Reuse original bolts.

Be sure push plates are firmly against cross member.

Drill cross member and install 2 - 1” x 3” bolts.

Item No. | Qty. | Part No. | Description
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1 | 6 | 16-1510 | 20mm x 2.5mm x 90mm Metric Hex Bolt Gr 10.9
2 | 8 | 16-20222 | 3/4” x 3” Hex Bolt Gr 5 NC
3 | 6 | 16-20562 | 1” x 3” Hex Bolt Gr 8 NC
4 | 10 | 16-20564 | 1” x 3-1/2” Hex Bolt Gr 8 NC
5 | 1 | 18-5170-R | 660 STX Quad 480 / 535 Bracket Right
6 | 1 | 18-5170-L | 660 STX Quad 480 / 535 Bracket Left
7 | 1 | 54-13100 | 660 STX / TJ 480 / 535 Quad and Wheeled UC
8 | 6 | 57-11659 | 0.91” ID x 2.50” OD x 0.50” Thick CZ Plated - Trimmed Washer
9 | 4 | 57-20819 | 1” Flat Washer Heavy Duty Gr 8 (USS)
10 | 28 | 57-3682 | 1.00” ID x 2.50” OD x 0.375” Heavy Washer CZ Plated
11 | 16 | 57-3680 | 0.75” ID x 2.00 OD x 0.375” Heavy Washer CZ Plated
12 | 8 | 70-20607 | 3/4” Hex Center Lock Nut Gr 2 NC
13 | 16 | 70-20599 | 1” Hex Nut Gr 8 NC