



# FH-400 John Deere 30 Series with IVT

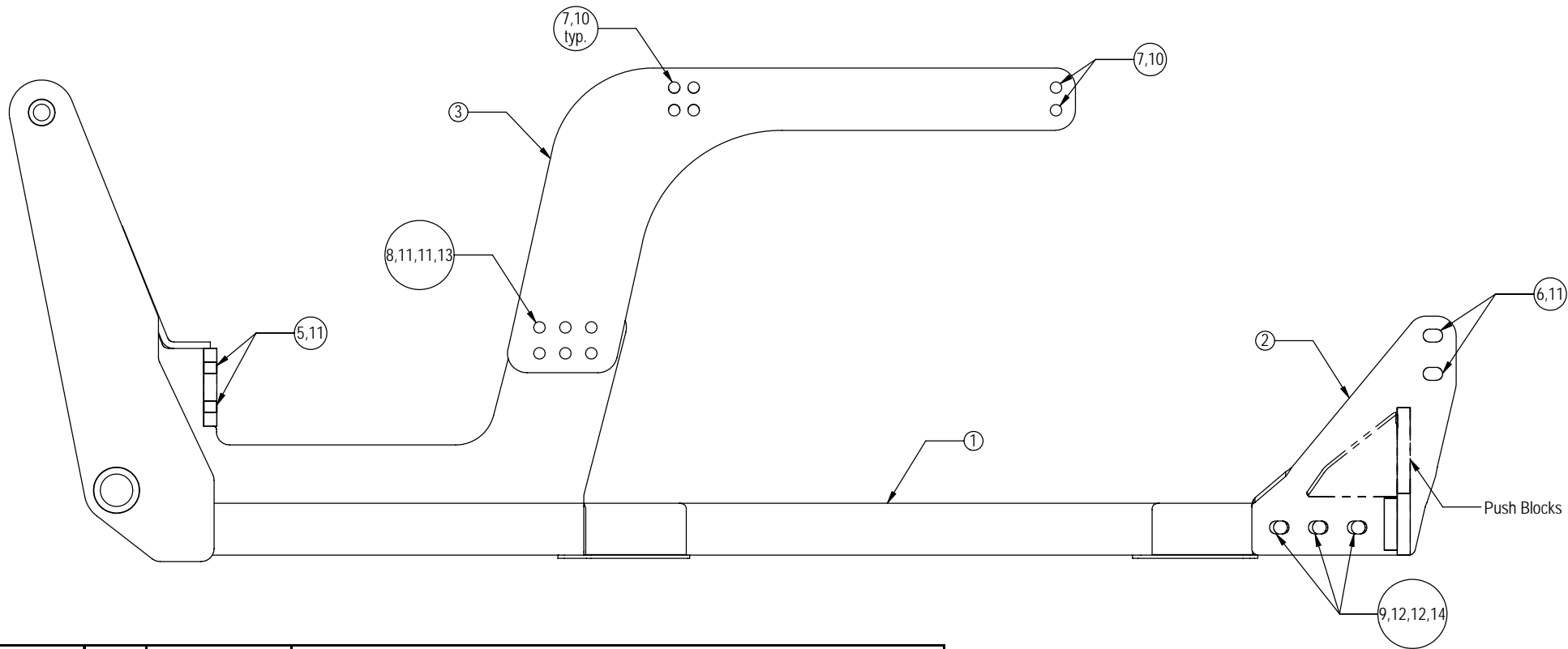
## Undercarriage Installation Instructions

### 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. Remove toolbox from left side of tractor.
  4. Attach the rear bracket (PN: 18-11499) to the undercarriage (U/C) with 6 - 1" x 2-1/2" bolts (PN: 16-20560), 12 - 1" flat washers (PN: 57-20819), and 6 - 1" nuts (PN: 70-20599). Tighten finger tight. See attached diagram for clarification.
  5. Position the 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 U/C holes.
  7. At the front of the tractor, use 4 - 20mm x 70mm bolts (PN: 16-1876) with a 3/4" washer (PN: 57-20747) on each bolt to attach the U/C to the front of the tractor. See attached diagram for clarification.
  8. Raise rear of undercarriage until holes on the tractor line up with the U/C holes.  
**Be sure that the push blocks are tight against bolt heads at rear of U/C.**
  9. Attach the toolbox and the rear of U/C to the tractor with 4 - 20mm x 50mm bolts (PN: 16-1878) with a 3/4" washer (PN: 57-20747) on each bolt.
  10. Attach the right rail (PN: 46-3647) to the right side of the undercarriage with 6 - 3/4" x 2-1/4" bolts (PN: 16-20219), 12 - 3/4" washers (PN: 57-20747) and 6 - 3/4" center lock nuts (PN: 70-20607). See attached diagram for clarification.
  11. Attach the left rail (PN: 46-3646) to the left side of the undercarriage with 6 - 3/4" x 2-1/4" bolts (PN: 16-20219), 12 - 3/4" washers (PN: 57-20747) and 6 - 3/4" center lock nuts (PN: 70-20607). See attached diagram for clarification.
  12. Start 6 - 16mm x 90mm bolts (PN: 16-1620090) with a 5/8" flat washer (PN: 57-20746) on each bolt through the top holes of the left and right rail and the tractor frame. See attached diagram for clarification.
  13. Once all bolts are installed, torque all 20mm bolts to 432 ft-lbs., all 16mm bolts to 269 ft-lbs., all 1" bolts to 903 ft-lbs., and all 3/4" bolts to 257 ft-lbs.
  14. After first 8 hours of use, re-torque all bolts.
  15. Check all fasteners regularly to ensure proper operation of equipment.


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REVISIONS:



Item No.	Qty.	Part No.	Description
1	1	54-11379	FH-400 UC JD 8030
2	1	18-11499	FH-400 JD 8030 - IVT - Tail Section
3	1	46-3646	FH-400 JD 8020 w/ ILS Side Plate Rail Left Weld
4	1	46-3647	FH-400 JD 8020 w/ ILS Side Plate Rail Right Weld
5	4	16-1876	20mm x 2.5mm x 70mm Metric Hex Bolt Gr 10.9
6	4	16-1878	20mm x 2.5mm x 50mm Metric Hex Bolt Gr 10.9
7	12	16-1620090	16mm x 2.00mm x 90mm Metric Hex Bolt Gr 10.9 Coarse
8	12	16-20219	3/4" X 2-1/4" Hex Bolt Gr 5 NC
9	6	16-20560	1" X 2-1/2" Hex Bolt Gr 8 NC
10	12	57-20746	5/8" Flat Washer
11	32	57-20747	3/4" Flat Washer
12	12	57-20819	1" Flat Washer Heavy Duty Gr 8 (USS)
13	12	70-20607	3/4" Hex Center Lock Nut Gr 5 NC
14	6	70-20599	1" Hex Nut Gr 8 NC

Parts only shown on left side. Right side is identical.

 <b>GROUSER PRODUCTS INC.</b> 755 2nd Ave NW Phone 701.282.7710 West Fargo, ND 58078 Fax 701.282.8131 WWW.GROUSER.COM		
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