

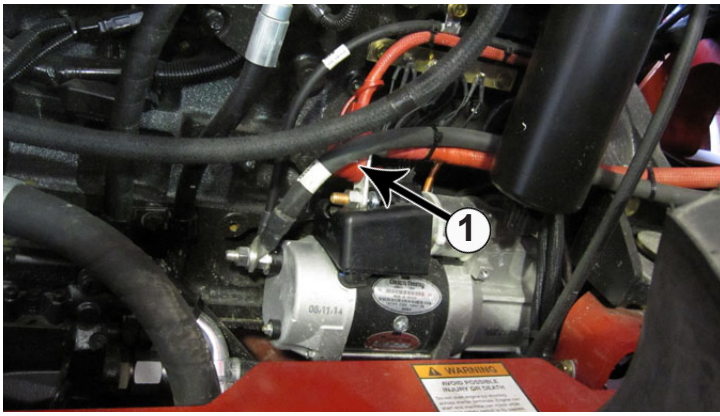


# 450 Buhler (Phase C2)

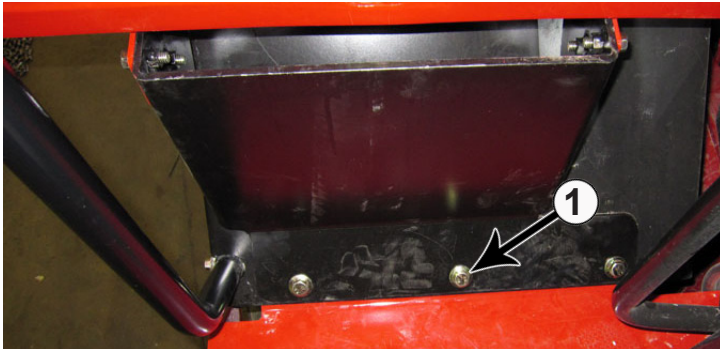
## Undercarriage Installation Instructions

### **Caution:**

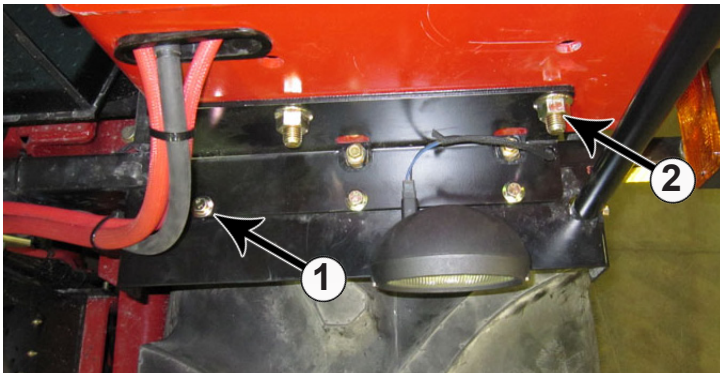
- Always use precaution when working around any equipment.
- Always wear safety glasses.
- Follow tractor manufacturer's safety guidelines when installing this product.
  1. Read all instructions prior to installation.
  2. Remove weights and weight bracket from front of tractor if necessary.
  3. Remove front toolbox/step and battery compartment. Refer to Page 2 for reinstalling the battery compartment.
  4. Position the undercarriage (U/C) under the tractor and center with the frame of the tractor.
  5. Enlarge existing holes on the front and rear sides of the tractor frame for the 1" bolts. See attached diagram for clarification.
  6. Lift the U/C and push back until the U/C is firmly against the tractor frame.
  7. Attach the rear of the U/C to the tractor frame with a 2 - 1" x 3" bolt (PN: 16-20562), 4 - 1" heavy washers (PN: 57-3682), and 2 - 1" nuts (PN: 70-20599).
  8. Install 6 - 1" x 3" bolts (PN: 16-20562) with a 1" ID washer (PN: 57-3682) on each bolt through the side holes of the U/C and into the holes of the tractor. See attached diagram for clarification.
  9. After all 12 bolts are through the tractor frame, attach with a 1" ID washer (PN: 57-3682) and 1" nut (PN: 70-20599) on each bolt.
  10. Verify that the U/C is tight up against the tractor frame.
  11. First torque the rear 1" bolts to 903 ft-lbs and then the front 1" bolts to 903 ft-lbs.
  12. After first 8 hours of use, re-torque all bolts.
  13. Check all fasteners regularly to ensure proper operation of equipment.



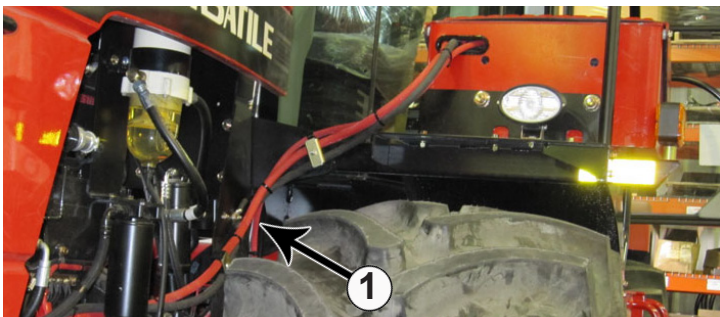
1. Turn battery cables for easier routing (1).



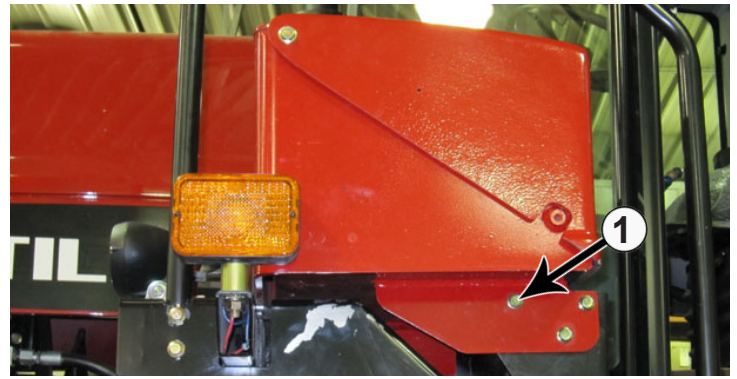
2. Install the rear battery relocation bracket (PN: 18-12853) on the left fender using the original hardware on the fender (1).



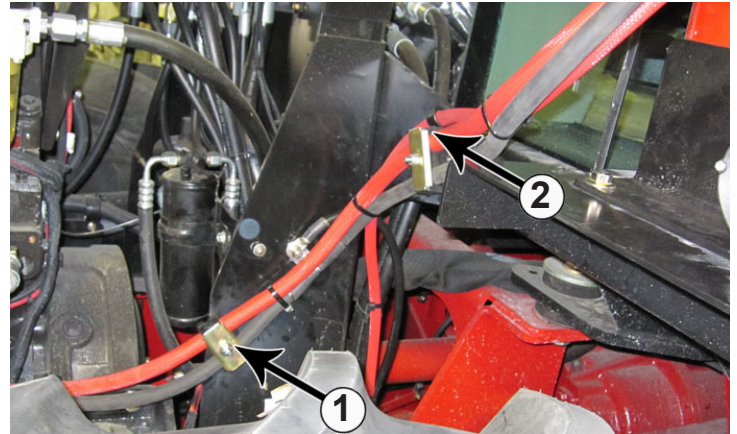
3. Install the front battery relocation bracket (PN: 18-12852) on the left fender using the original hardware on the fender (1). Attach the battery compartment to the front bracket with the original battery compartment hardware (2).



4. Route the cables as shown (1). They will be attached and secured in a later step.



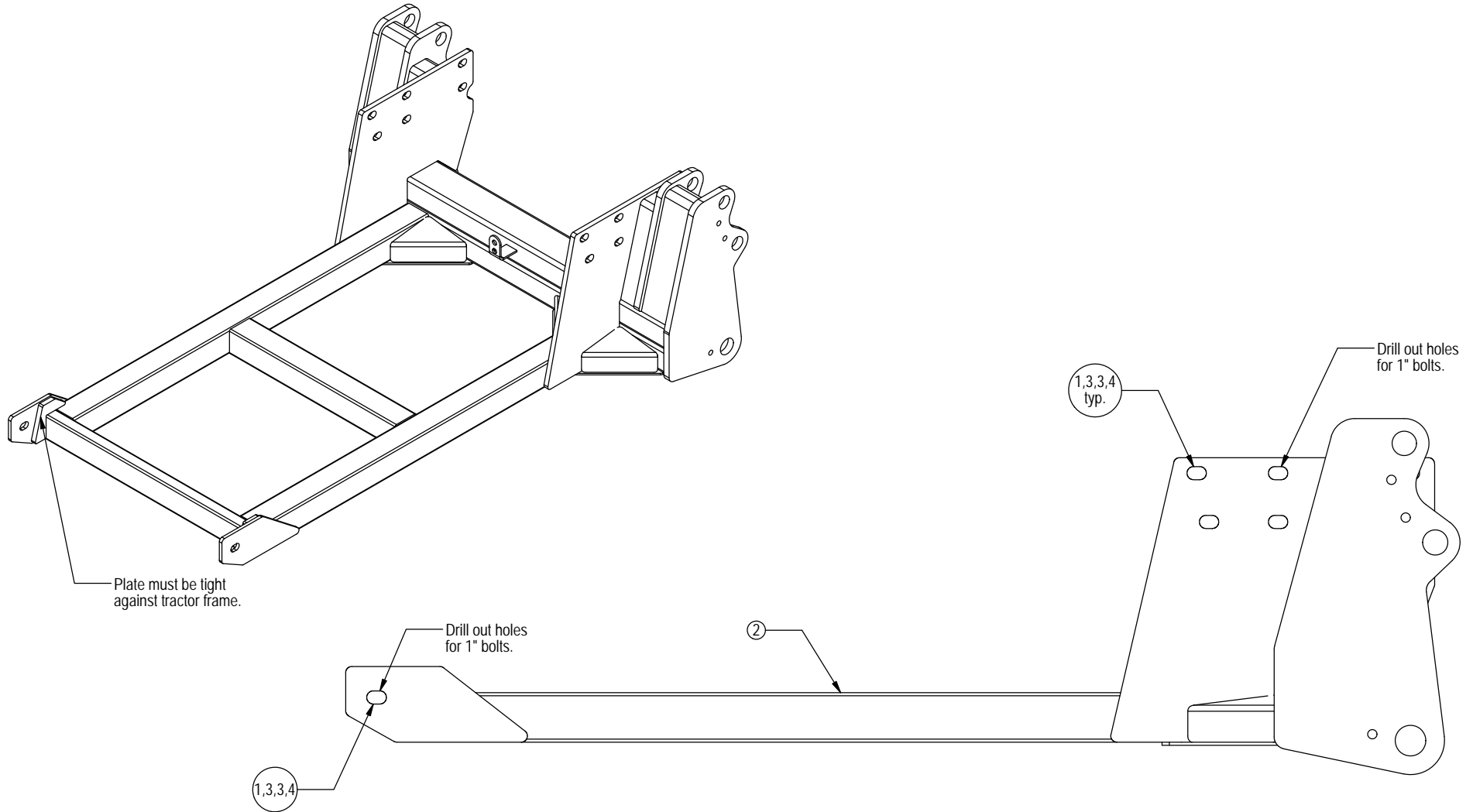
5. Attach the battery compartment to the rear bracket with 3 - 3/8" bolts (PN: 16-35C616) on each side (1).



6. Weld a 5/16" bolt (PN: 16-20036) in approximately each of the locations in the above photo. Use a hose clamp (PN: 18-3074), a plate (PN: 18-3075), and a nut (PN: 70-20581) to secure the battery cables (1 & 2). Include a P-Clamp (PN: 18-10561) behind the top hose clamp to secure a 3rd cable (2).

Qty.	Part No.	Description
2	16-20036	5/16" x 1-1/2" Hex Bolt Gr 5 NC
6	16-35C616	3/8" x 1" Flanged Bolt
1	18-10561	P-Clamp
1	18-12852	Front Battery Relocation Bracket
1	18-12853	Rear Battery Relocation Bracket
2	18-3074	Hose Hold Down Clamp
2	18-3075	Hose Hold Down Clamp Plate
2	70-20581	5/16" Hex Nut NC

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Item No.	Qty.	Part No.	Description
1	14	16-20562	1" x 3" Hex Bolt Gr 8 NC
2	1	54-12850	450 Buhler (Phase C2) Undercarriage
3	28	57-3682	2.50" OD x 1.00" ID x .375" Washer
4	14	70-20599	1" Hex Nut Gr 8 NC



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TITLE: 450 Buhler (Phase C2)

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