



450 & 450HD Case STX Quad 375-500

Undercarriage Installation Instructions

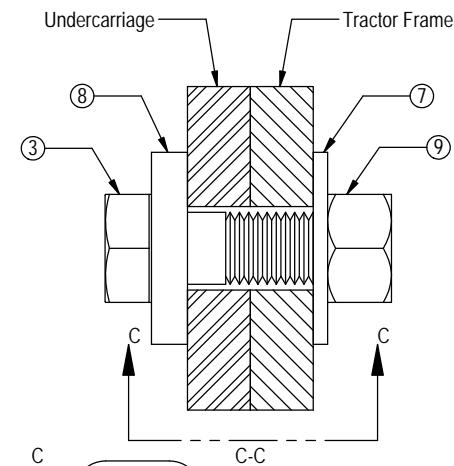
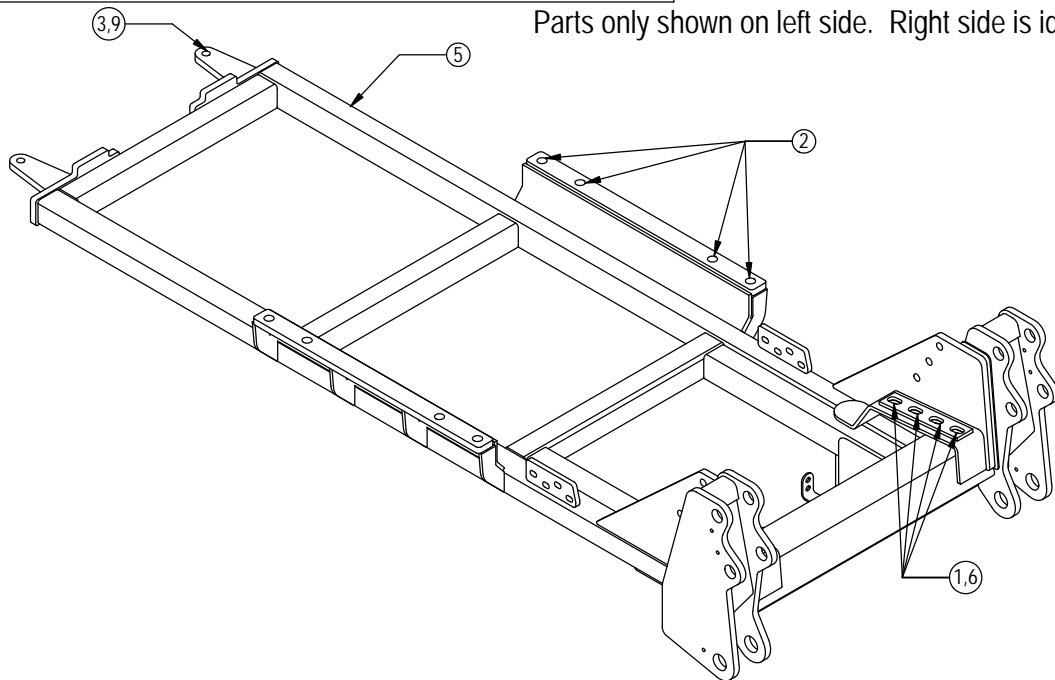
Caution:

- 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 4 - 24mm bolts closest to the center of the tractor and spacers from the front axle on the left and right side of the tractor. Discard the bolts.
 4. Position the undercarriage (U/C) under tractor, center on the frame of the tractor. Lift U/C to within 3/4" of touching the tractor frame.
 5. Start 8 - 20mm x 90mm bolts (PN: 16-1510) with a 0.91" ID heavy washer (PN: 57-11659) on each of the bolts into the vertical slots at front of U/C. Turn in until washers contact U/C. See attached diagram for clarification.
 6. Raise rear of U/C up until the two-rear mounting ears touch up against the cross member of the tractor. **Be sure that the vertical push plates are firmly against the cross member.**
 7. 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) and 1" nuts (PN: 70-20599). Tighten finger tight.
 8. Insert 4 - 24mm x 300mm bolts (PN: 16-1574) into the axle on each side of the tractor.
 9. Once all bolts have been started, torque the two rear ear 1" bolts to 903 ft·lbs.
 10. Torque the 8 - 24mm bolts to 909 ft·lbs.
 11. Torque the 8 - 20mm front vertical bolts to 432 ft·lbs.
 12. Using the side frame holes as guides, drill 6 - 1" holes through side of tractor frame.

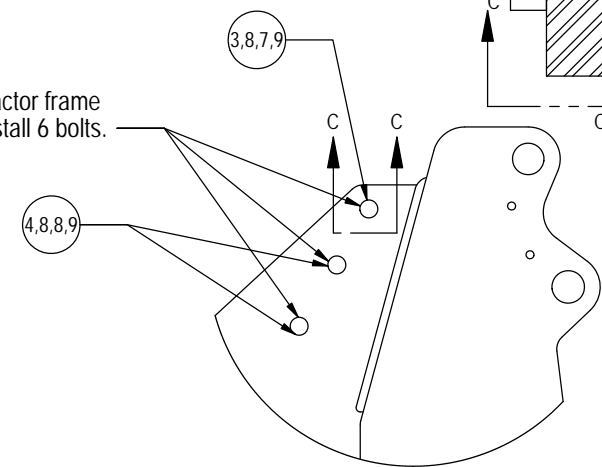
Caution: When drilling, be aware of all parts behind the material being drilled so that you do not mistakenly hit or puncture components on engine side of tractor frame.
 13. Install 2 - 1" x 3" bolts (PN: 16-20562) with a 1" ID heavy washer (PN: 57-3682) on each bolt in the top two holes. Install 4 - 1" x 3-3/4" bolts (PN: 16-20565) with a 1" ID heavy washer (PN: 57-3682) on each bolt in the bottom four holes. See attached diagram for clarification.
 14. After all 6 bolts are through the tractor frame, attach with a 1" flat washer (PN: 57-20819) on the top two bolts, a 1" ID heavy washer (PN: 57-3682) on the bottom four bolts, and a 1" nut (PN: 70-20599) on each bolt.
 15. Torque all 1" bolts to 903 ft·lbs.
 16. After first 8 hours of use, re-torque all bolts.
 17. Check all fasteners regularly to ensure proper operation of equipment.

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



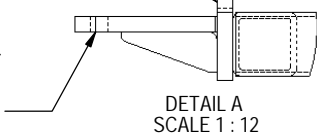
Drill tractor frame and install 6 bolts.



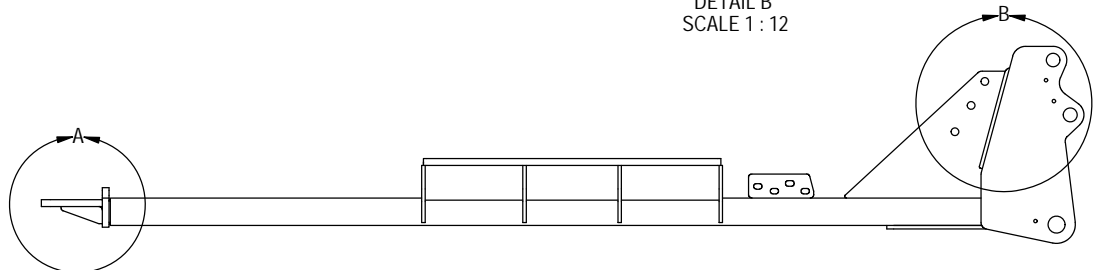
DETAIL B
SCALE 1:12

Be sure push plates are firmly against cross member.

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



DETAIL A
SCALE 1:12



Item No.	Qty.	PN	Description
1	8	16-1510	20mm x 2.5mm x 90mm Metric Hex Bolt Gr 10.9
2	8	16-1574	24mm x 3.0mm x 300mm Metric Hex Bolt Gr 10.9 Plated (STX Quad)
3	4	16-20562	1" x 3" Hex Bolt Gr 8 NC
4	4	16-20565	1" x 3-3/4" Hex Bolt Gr 8 NC
5A	1	54-13030	450 - STX 375-500 Quad UC
5B	1	54-12110	450HD - STX 375-500 Quad UC
6	8	57-11659	0.91" ID x 2.50" OD x 0.50" Thick CZ Plated - Trimmed Washer
7	2	57-20819	1" Flat Washer Heavy Duty Gr 8
8	10	57-3682	1.00" ID x 2.50" OD x 0.375" Heavy Washer CZ Plated
9	8	70-20599	1" Hex Nut Gr 8 NC

Item #A for 450 and #B for 450HD undercarriage.

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TITLE	450 & 450HD - STX 375-500 Quad	DWG. NO.	13030R2-A
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