



660 John Deere 9030 Series

Undercarriage Installation Instructions

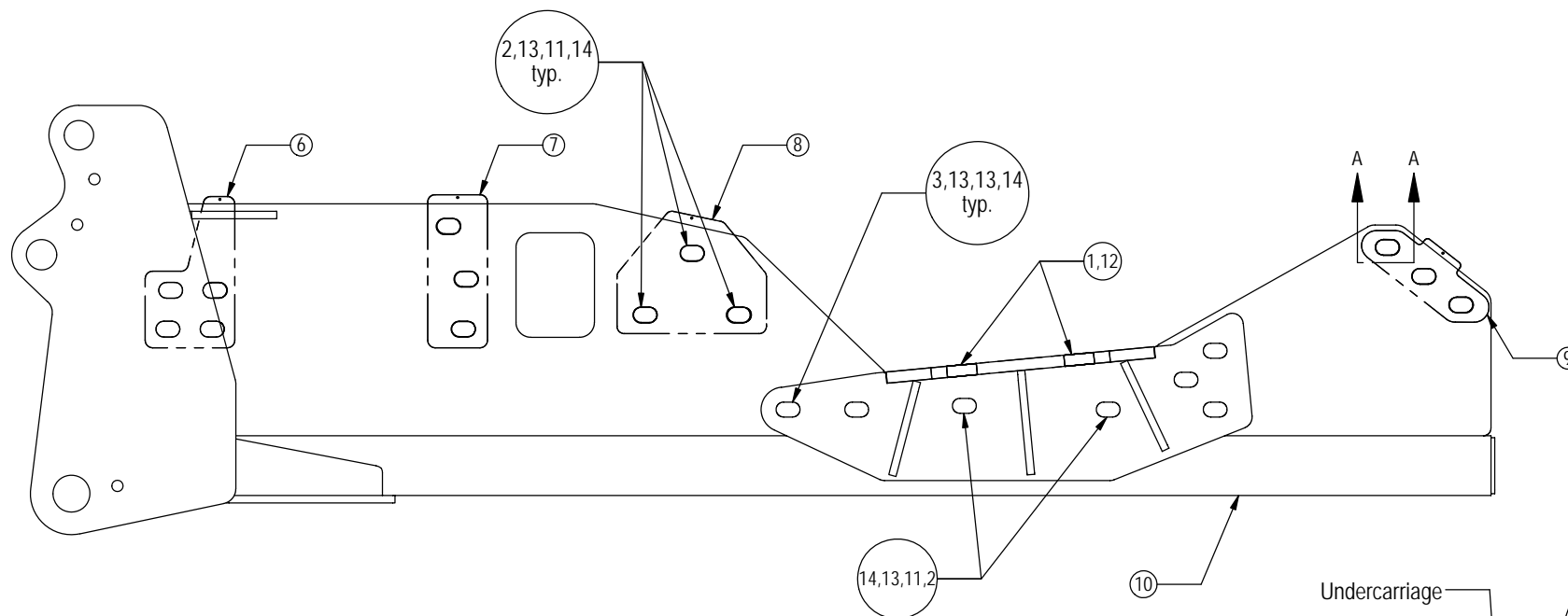
Caution:

- 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 performing installation.
 2. If applicable, remove front weights, weight bracket, toolbox, and front axle brace from front of tractor.
 3. Attach the left and right axle brackets (PN: 18-15380-R,L) to the axle with 6 - 24mm X 150mm bolts (PN: 16-1875) and 6 - axle mount washers (PN: 57-3098) into the vertical holes on each side. Finger tighten the 24mm bolts until the brackets are against the axle. Slide the brackets outward away from center of tractor to allow room to install the undercarriage.

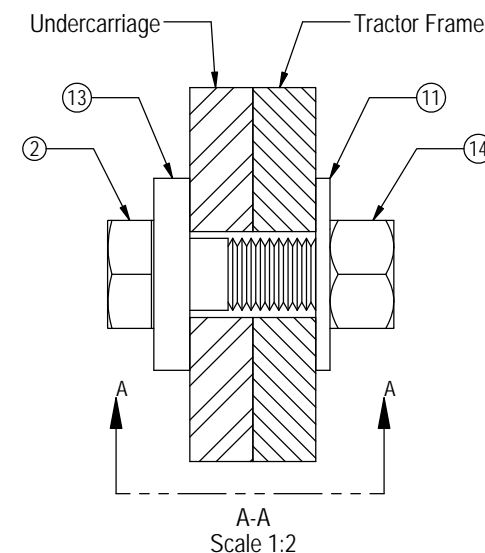
NOTE: Some tractors only have 4 holes in the axle. The installation instructions are still compatible, but only use 4 bolts and washers instead of 6 in Step #3.
 4. **Before lifting the undercarriage in place, install 2 - 7/8" X 2-1/2" bolts (PN: 16-20540) with a 7/8" flat washer (PN: 57-20818) on each bolt from the inside of the undercarriage into the 2 center bolting locations where the axle brackets will be attached to the undercarriage on each side. Refer to attached diagram for any clarification. Be careful when lifting undercarriage into place that these bolts don't hit the axle brackets.**
 5. Position undercarriage (U/C) under tractor, center on the frame of the tractor. Lift U/C until holes in U/C line up with holes in the side of the tractor frame.

NOTE: Add spacers between the U/C and the tractor frame if necessary. See attached diagram for the proper location and orientation of each spacer.
 6. Install 13 - 7/8" X 2-1/2" bolts (PN: 16-20540) with a 7/8" heavy washer (PN: 57-3681) on each bolt through the holes on each side of the U/C and the tractor frame. See attached diagram for any clarification.
 7. After all the bolts are through the tractor frame, attach with a 7/8" heavy flat washer (PN: 57-20818) and a 7/8" nut (PN: 70-20598) on each bolt.
 8. Slide the axle brackets toward the center of the tractor and attach the left and right axle brackets to the U/C with a 7/8" heavy washer (PN: 57-3681) and a 7/8" nut (PN: 70-20598) on each bolt that was installed in Step #4.
 9. Install 5 - 7/8" X 3" bolts (PN: 16-20542) with a 7/8" heavy washer (PN: 57-3681) on each bolt for the remaining holes in each of the axle brackets. Bolts can be installed from the outside
 10. After all the bolts are through the U/C holes, attach with a 7/8" heavy washer (PN: 57-3681) and a 7/8" nut (PN: 70-20598) on each bolt.
 11. Torque the 24mm bolts to 909 ft-lbs.
 12. Torque the 7/8" bolts on the axle bracket to 600 ft-lbs. and then torque the remaining 7/8" bolts to 600 ft-lbs.
 13. After first 8 hours of use, re-torque all bolts.
 14. Check all fasteners regularly to ensure proper operation of equipment.

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Note: Install all bolts before tightening.
Item #A for 660 and #B for 660HD Undercarriage.



| Item No. | Qty. | Part No. | Description |
|----------|------|------------|---|
| 1 | 12 | 16-1875 | 24mm x 3.0mm x 150mm Metric Hex Bolt Gr. 10.9 |
| 2 | 30 | 16-20540 | 7/8" x 2-1/2" Hex Bolt Gr 8 NC |
| 3 | 10 | 16-20542 | 7/8" x 3" Hex Bolt Gr 8 NC |
| 4 | 1 | 18-15380-L | 660 JD 9030 & 9R Axle Bracket Left |
| 5 | 1 | 18-15380-R | 660 JD 9030 & 9R Axle Bracket Right |
| 6 | 2 | 44-11846 | 660 - JD 9030 - Shim Plate - Front |
| 7 | 2 | 44-11847 | 660 - JD 9030 - Shim Plate - Mid-Front |
| 8 | 2 | 44-11848 | 660 - JD 9030 - Shim Plate - Mid-Rear |
| 9 | 2 | 44-11849 | 660 - JD 9030 - Shim Plate - Rear |
| 10A | 1 | 54-13290 | 660 UC JD 9030 Series |
| 10B | 1 | 54-12130 | 660HD UC JD 9030 Series |
| 11 | 30 | 57-20818 | 7/8" Flat Washer Heavy Duty Gr. 8 (USS) |
| 12 | 12 | 57-3098 | 2.50" O.D. x 1.05" I.D. x .50" Washer CZ Plated (JD Axle Washer) |
| 13 | 50 | 57-3681 | 2.25" O.D. x .875" I.D. x .375" Washer CZ Plated (JD Axle Washer) |
| 14 | 40 | 70-20598 | 7/8" Nex Nut Gr 8 NC |



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TITLE: 660 & 660HD JD 9030 Series Assy.

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