



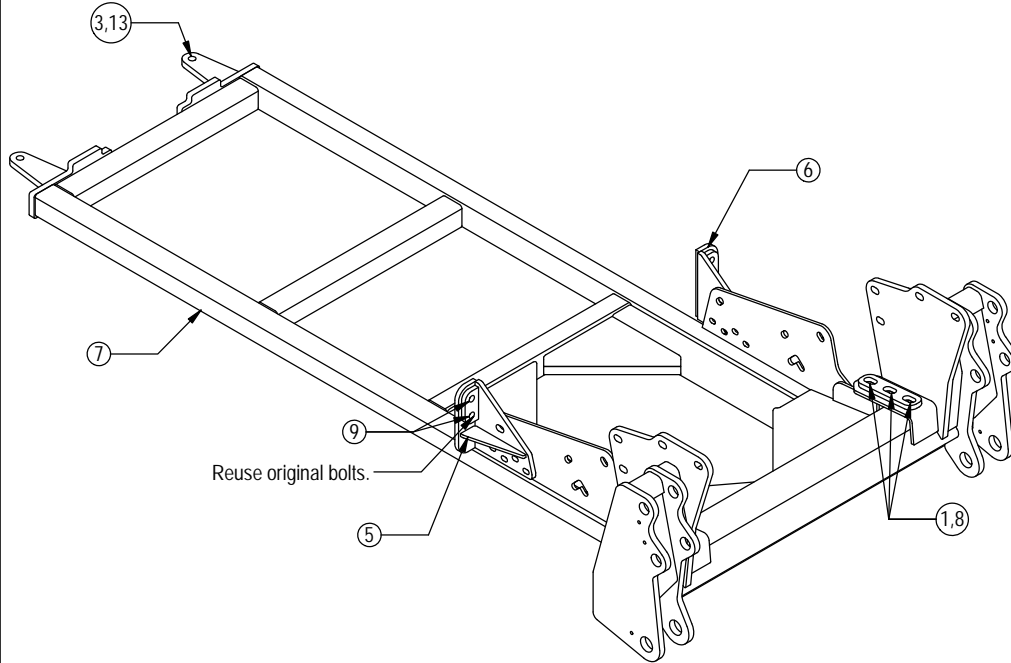
# 660 Case STX Quad 480-535 Cast Yoke Undercarriage Installation Instructions

## **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.

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Be sure push plates are firmly against cross member.

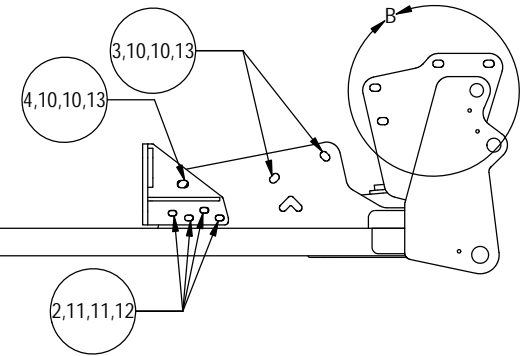
Drill cross member and install 2 - 1" x 3" bolts.

DETAIL A  
SCALE 1 : 14

Drill tractor frame and install 4 - 1" bolts on each side.

Some items not shown for clarity.

DETAIL B  
SCALE 1 : 14



Item No.	Qty.	Part No.	Description
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



**GROUSER PRODUCTS INC.**

755 2nd Ave NW  
West Fargo, ND 58078  
WWW.GROUSER.COM

Phone 701.282.7710  
Fax 701.282.8131

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