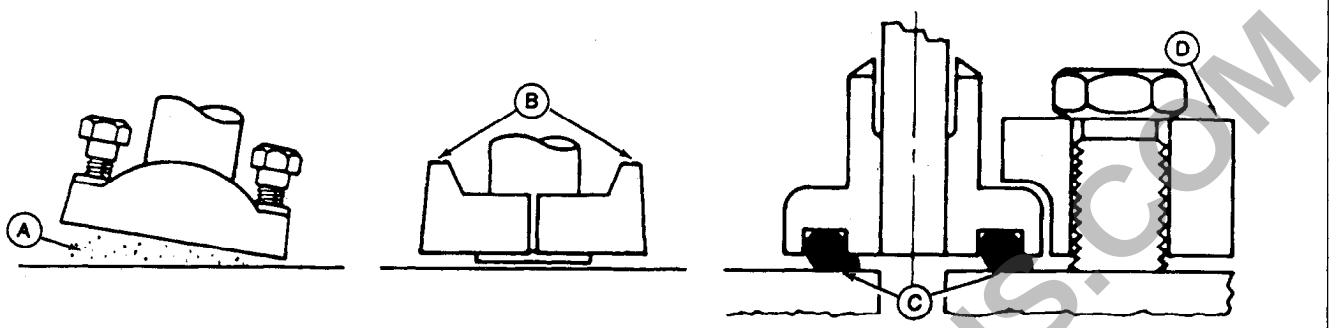
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METRIC SERIES FOUR BOLT FLANGE FITTING SERVICE RECOMMENDATIONS



A—Sealing Surface **B—Split Flange** **C—Pinched O-Ring** **D—Single Piece Flange**

1. Clean sealing surfaces (A). Inspect. Scratches cause leaks. Roughness causes seal wear. Out-of-flat causes seal extrusion. If defects cannot be polished out, replace component.

2. Install the correct O-ring (and backup washer if required) into groove using petroleum jelly to hold it in place.

3. Split flange: Loosely assemble split flange (B) halves. Make sure split is centrally located and perpendicular to port. Hand tighten cap screws to hold parts in place. Do not pinch O-ring (C).

4. Single piece flange (D): Place hydraulic line in center of flange and install four cap screws. Flange must be centrally located on port. Hand tighten cap screws to hold flange in place. Do not pinch O-ring.

5. After components are properly positioned and cap screws are hand tightened, tighten one cap screw, then tighten the diagonally opposite cap screw. Tighten two remaining cap screws. Tighten all cap screws as specified in chart below.

DO NOT use air wrenches. DO NOT tighten one cap screw fully before tightening the others. DO NOT overtighten.

Thread[1]	Torque[2] N·m	Torque[2] lb-ft
M6	12	9
M8	30	22
M10	57	42
M12	95	70
M14	157	116
M16	217	160
M18	334	246
M20	431	318

1. Metric standard thread.

2. Tolerance ± 10%. The torques given are enough for the given size connection with the recommended working pressure. Increasing cap screw torque beyond these amounts will result in flange and cap screw bending and connection failures.

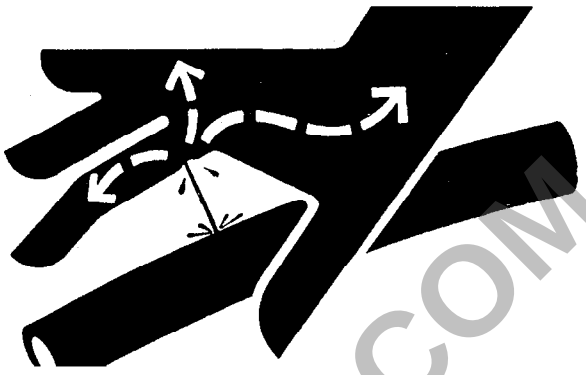
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018;T6890BB 04T;90 K175 260888

1T7;00IIII 09 111188

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REMOVE NON-POWERED FRONT AXLE



1. Raise loader and install boom lock bar.

2. Remove counterweights if equipped.

3. Remove both front wheels. (See Remove Front Wheel Assembly in Group 0120.)

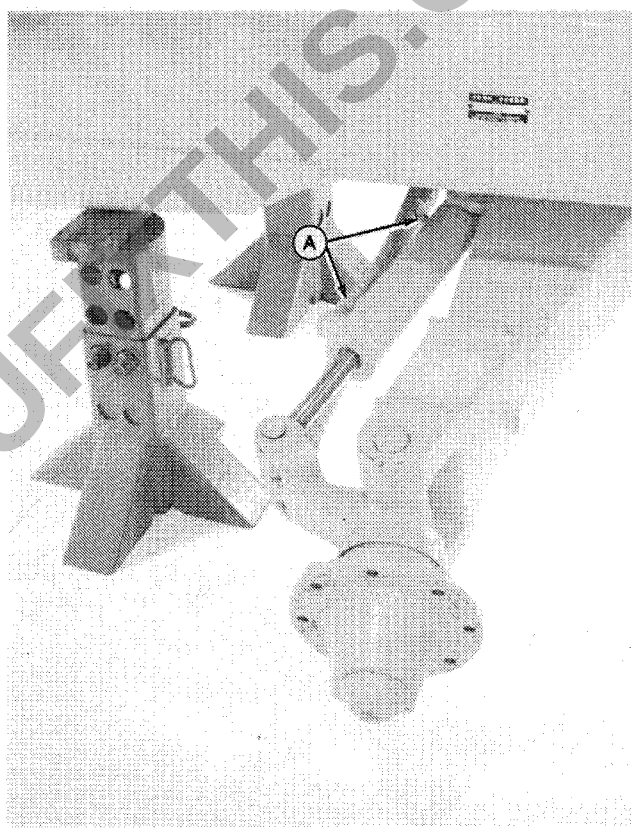
4. Install two floor stands with wooden blocks under main frame.

CAUTION: Escaping fluid under pressure can penetrate the skin causing serious injury. Relieve pressure before disconnecting hydraulic or other lines. Tighten all connections before applying pressure. Keep hands and body away from pinholes and nozzles which eject fluids under high pressure. Use a piece of cardboard or paper to search for leaks. Do not use your hand.

If ANY fluid is injected into the skin, it must be surgically removed within a few hours by a doctor familiar with this type injury or gangrene may result.

5. Operate all hydraulic control valves to release pressure in hydraulic system.

6. Disconnect lines (A). Cap and plug all openings to prevent dirt from entering the hydraulic system.

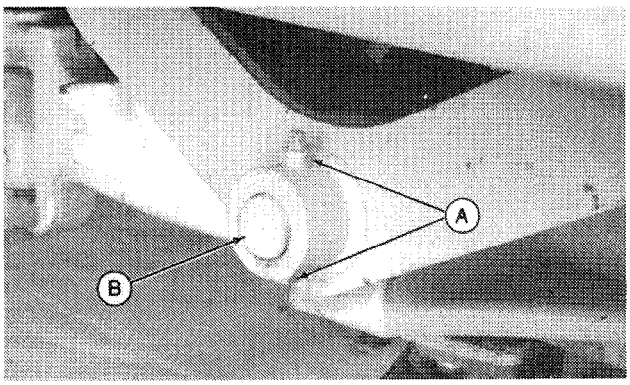


AB6;X9811 8AG;T91850 T47;0230 C6 240286

7. Place a scissors or service jack under axle.

8. Remove nut and cap screw (A).

9. Remove grease fittings from rear of pin (B). Remove pin to remove axle.



8AG;T6195AD T47;0230 C7 250985

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2T1;020230 13 070289

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10. Install steering arm, rolling drag torque bar, and cap screws hand tight. Install and tighten by hand only, two cap screws holding torque bar. Install remaining cap screws and tighten to specifications.

NOTE: To install torque bar on left hand steering knuckle, use two cap screws from right hand steering arm.

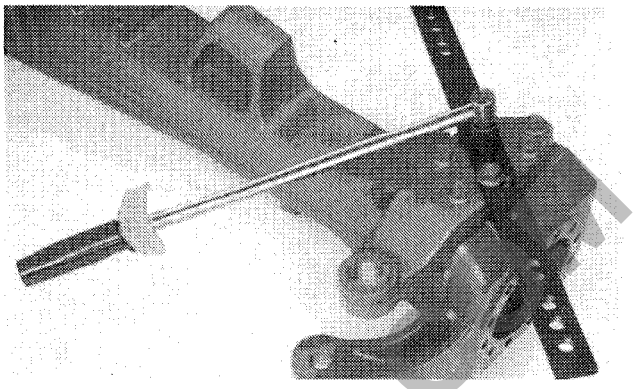
11. Install a torque wrench on the center cap screw to measure the rolling drag torque.

ROLLING DRAG TORQUE SPECIFICATION

Rolling Drag Torque	11—15 N·m (9—11 lb-ft)

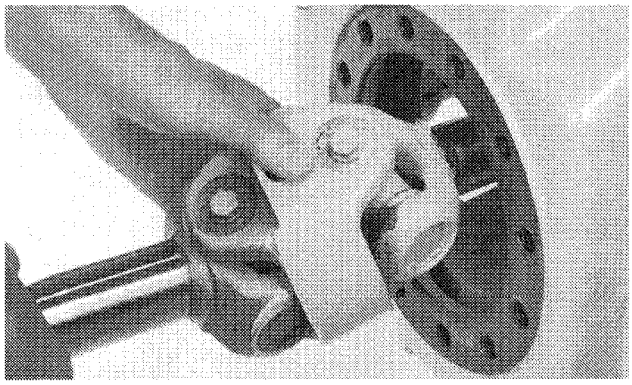
To adjust rolling drag torque, add or remove shims between upper and lower king pin and cover.

12. Remove torque bar and tighten two cap screws to specifications. Install grease fittings to upper and lower king pins. Apply recommended grease to fittings. (See Section I, Group IV.)



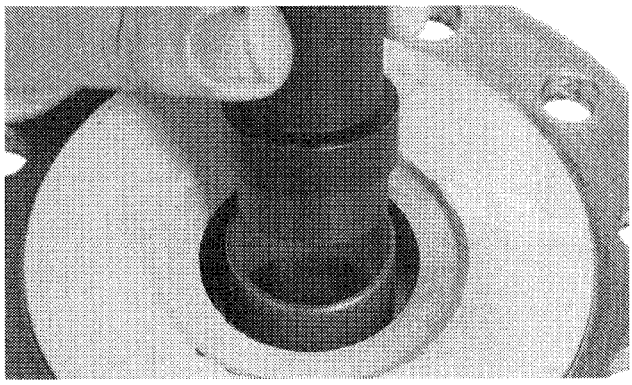
6NA;T6141AB T47;0240 C33 290886

13. Install axle shaft.



6NA;T94826 T47;0240 120 171083

14. Install new bushing in hub carrier, if replacement is necessary, using 39 mm and 34 mm disks.



6NA;T94884 T47;0240 121 231085

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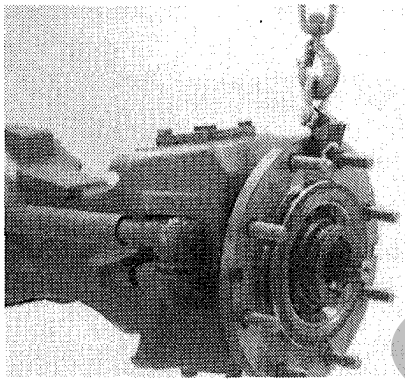
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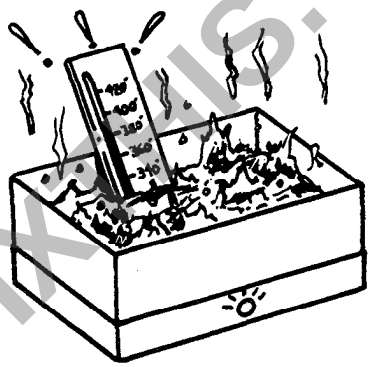
22. Install corner hub.

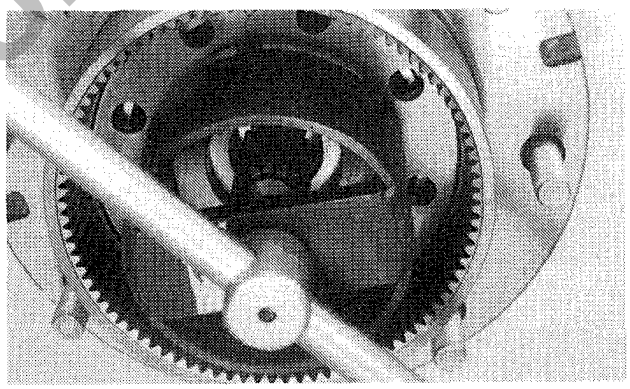
CAUTION: DO NOT heat oil over 182°C (360° F.) Oil fumes or oil can ignite above 193°C (380°F). Use a thermometer. DO NOT allow a flame or heating element to come in direct contact with the oil. Heat the oil in a well-ventilated area.

Heat outer bearing cone to 95°C (203° F) and install on steering knuckle housing.

24. Install ring gear and ring nut with chamfered edge out. Tighten with JT30014 Ring Nut Socket.







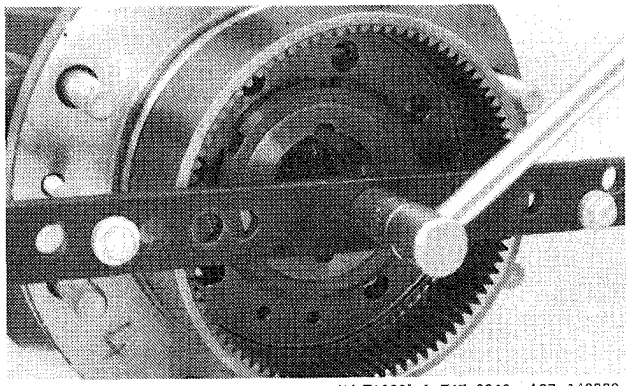
6NA;T6382IG, T81191, T6382IH 140289

25. Install rolling drag torque bar using two M10 x 140 cap screws.

26. Adjust ring nut torque to obtain correct rolling drag torque.

ROLLING DRAG TORQUE SPECIFICATION

New bearings	16—20 N·m (12—15 lb-ft)
Used bearings	11—14 N·m (8—10 lb-ft)



6NA;T6382I I T47;;0240 -A87 140289

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17. Install end cap cap screws and tighten to specification.

ROD GUIDE CAP SCREW TORQUE SPECIFICATION

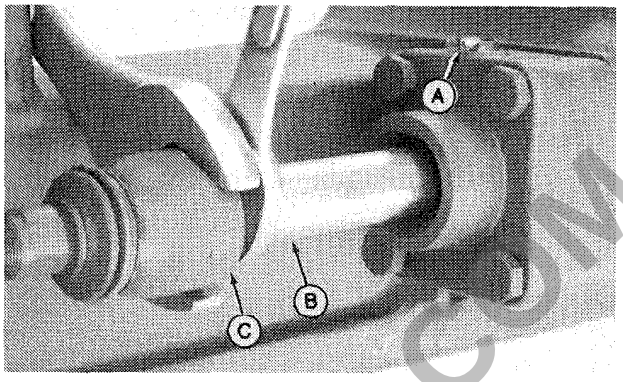
Torque. . . . . 190 N·m (140 lb-ft)

18. Apply thread lock/sealer to the first three threads of ball joint (C). Connect ball joint to piston rod (B) and tighten to specification.

PISTON ROD TO BALL JOINT TORQUE SPECIFICATION

Torque. . . . . 250 N·m (184 lb-ft)

19. Connect hydraulic lines to ports (A).



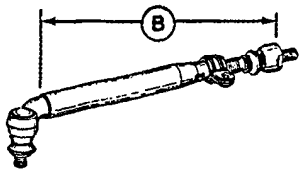
6NA;T6382I J T47;;0260 -A57 140289

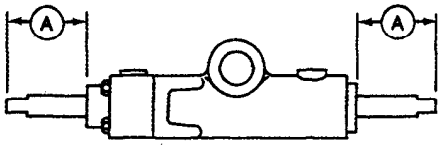
ADJUST TRACKING ANGLE TO ZERO—APL 745 AXLE

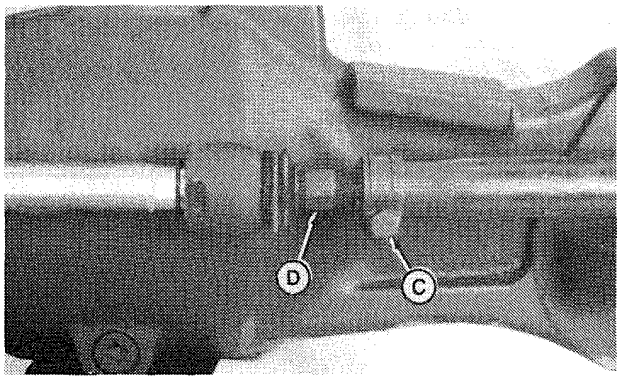
1. Center piston rod so distances (A) are equal.

2. Measure distances (B). If necessary, loosen nut (C) and turn steering rod (D) on appropriate side to equalize these distances to within a millimeter.

3. With axle installed on machine, check and adjust toe-in, and adjust steering stop screws. (See Section 2, Group 0240).







A—Centering Distance
B—Centering Distance
C—Nut
D—Steering Rod

6NA;T6382J X T6382J Z T47;;0260 -A58 160288

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SERVICE EQUIPMENT AND TOOLS—Continued

NOTE: Order tools from your SERVICE-GARD™ Catalog. Some tools may be available from a local supplier.

Name	Use
*(JT38064) Driver	Install grease seals into spindle on non-powered axles.
*(JT38047) Driver	Install bearing cone onto pinion shaft MFWD.
*(JT38058) Driver	Install oil seal in differential housing on MFWD.
*(JT38065) Driver	Install axle shaft seal.
*(JT38059) Driver	Install axle shaft seal.
*(JT38056) Driver	Install bearing on output shaft in transmission.
*(JT38060) Driver	Install seal on output shaft in transmission.
*(JT38061) Driver	Install bearing cone on differential drive shaft.
*(JT38062) Driver	Install bearing cone on transmission drive shaft.
*(JT38036) Driver	Install bearing cone fro fourth speed gear in transmission.
*(JT38667) Driver	Install bearing cone on to cutch pack shaft.
*(JT38055) Driver	Install bearing cone on idler shaft.

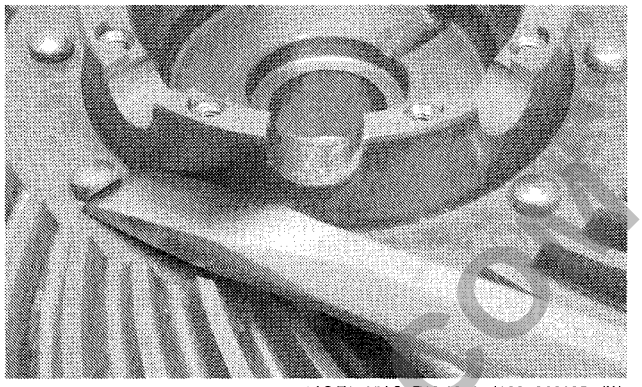
Fabricated tool, dealer made. (See Section 99 for instructions to make tool.)

T48;0350 C268 140386

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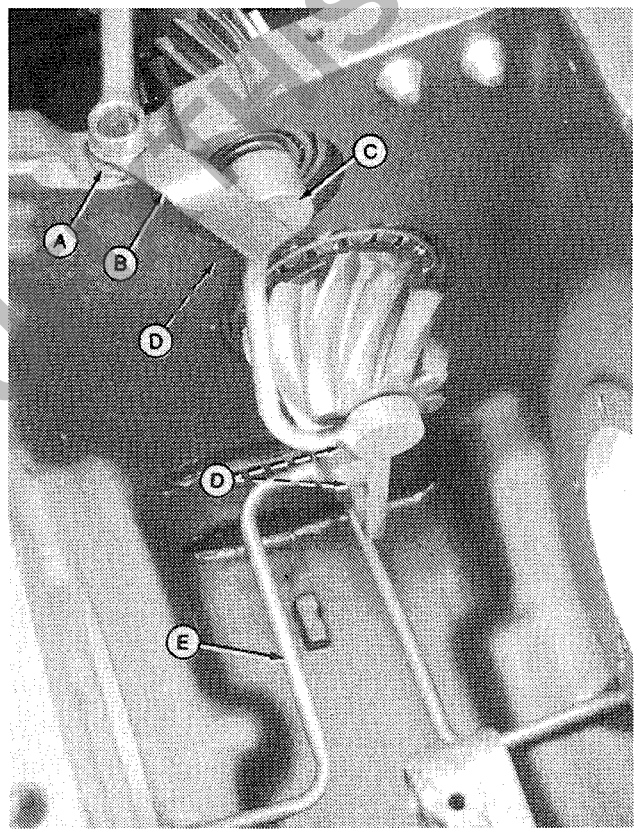
6. Remove rivets if replacement of housing is necessary. Use a press to remove old housing from ring gear.



6AG;T6135AG T48;0350 J103 130685 JW

REMOVE LUBRICATION OIL LINES

1. Remove cap screw to remove clamp (B) and washer (A).
2. Remove oil line (C).
3. Remove oil line (E) and three O-rings (D).



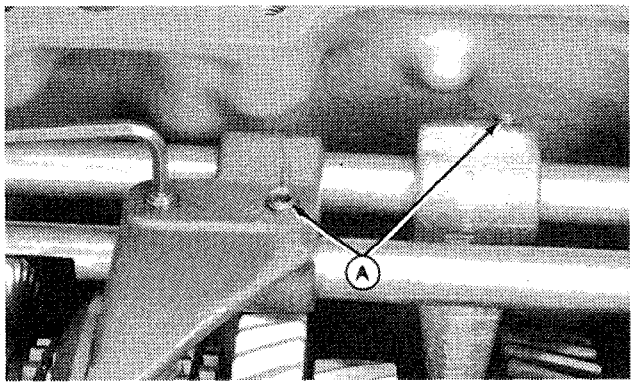
A—Washer
B—Clamp
C—Oil Line
D—O-Ring (3 used)
E—Oil Line

3AG;T91973 T48;0350 1396 180583

REMOVE SHIFTER SHAFTS

IMPORTANT: Be sure transaxle is in neutral.

1. Remove three set screws (A).

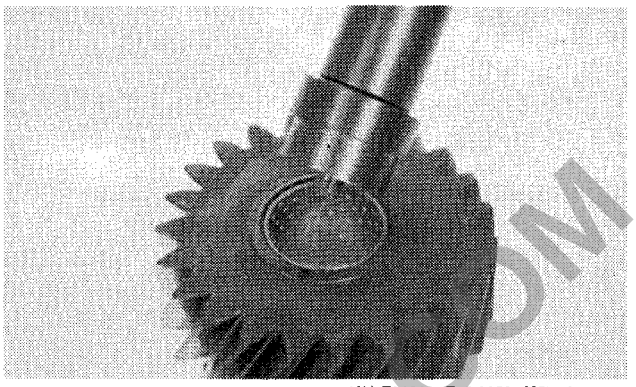


1AH;T91974 T48;0350 1397 300186

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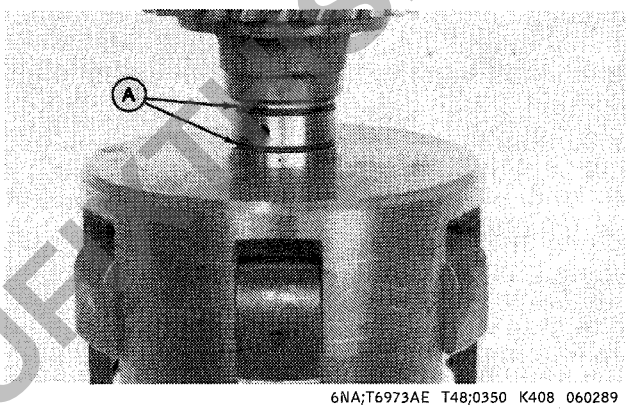
8. Install new bushing even with end of gear using 35 mm disk and 39 mm disk from driver set.



6NA;T94803 T48;0350 M57 310186

9. Install two O-rings (A).

10. Install clutch drive shaft in hub.

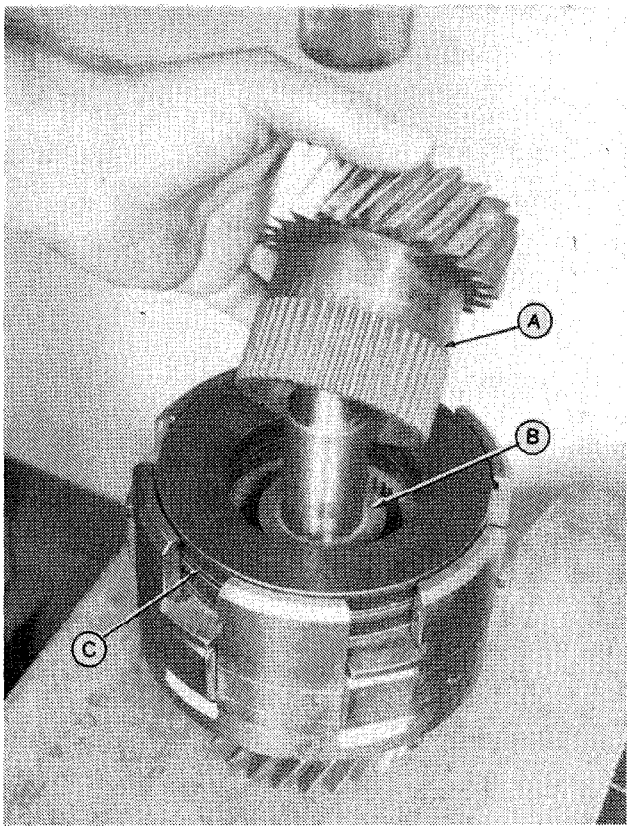


6NA;T6973AE T48;0350 K408 060289

11. Apply clean hydraulic oil to thrust washer (B) before installing.

12. Starting with O.D. of first conical washer against piston, alternately install the four conical washers (C).

13. Install the gear (A). Splines of gear must engage teeth of the seven disks.



6NA;T6973AF T48;0350 K409 060289

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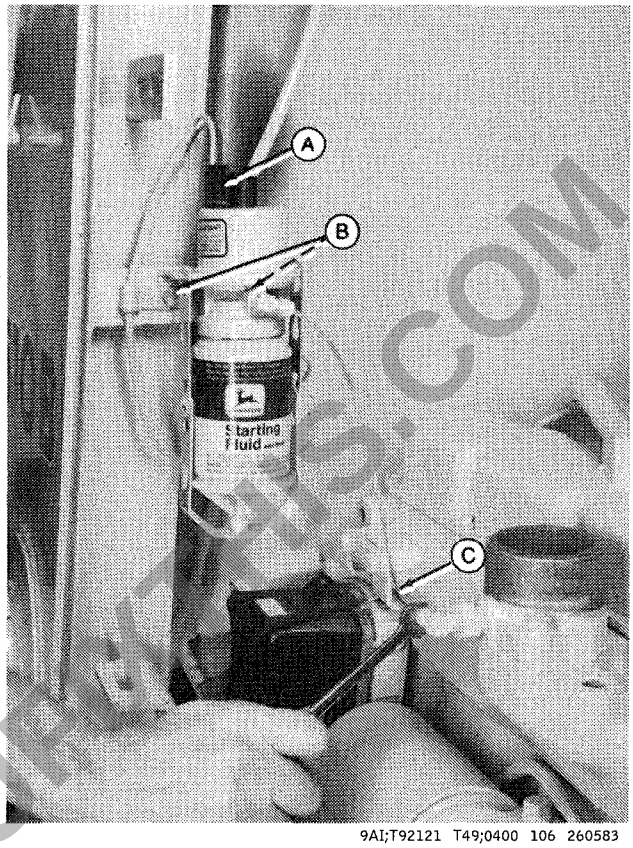
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INSTALL COLD WEATHER STARTING AID

1. Install starting aid and cap screws (B). Tighten cap screws.

2. Connect wiring lead (A).

3. Connect line (C).

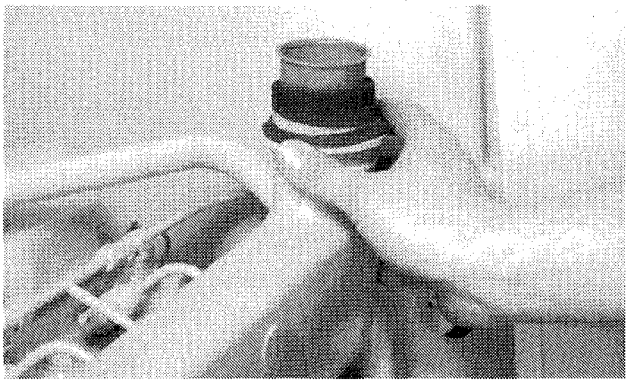


9AI;T92121 T49;0400 106 260583

INSTALL MUFFLER AND AIR CLEANER

NOTE: Installation of muffler and air cleaner on turbo-charged units is basically similar.

1. Install new seal.



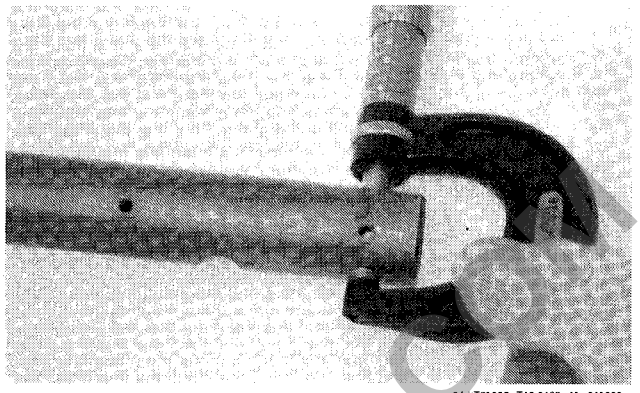
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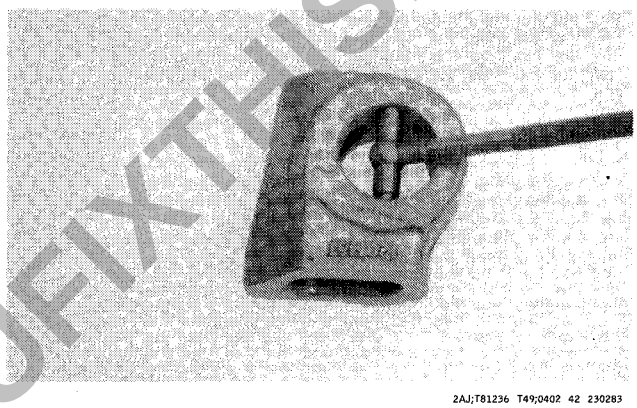
2. Measure rocker arm shaft at each rocker arm. New rocker arm shaft diameter is 19.99—20.01 mm (0.787—0.788 in.)

If rocker arm shaft is smaller than 19.94 mm (0.785 in.), install a new shaft.



2AJ;T81235 T49;0402 41 041083

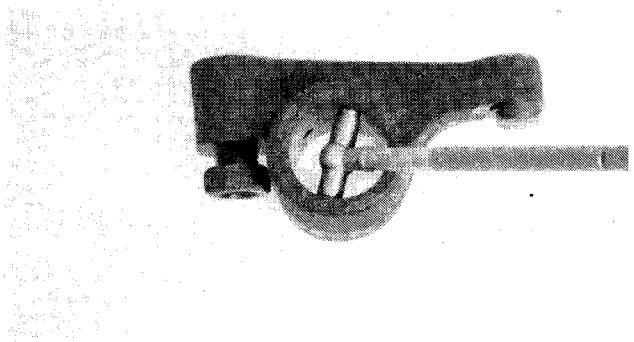
3. Measure each rocker arm shaft support diameter. If diameter is over 20.17 mm (0.794 in.), install a new support.



2AJ;T81236 T49;0402 42 230283

4. Measure rocker arm diameter. New rocker arm diameter is 20.07—20.12 mm (0.790—0.792 in.).

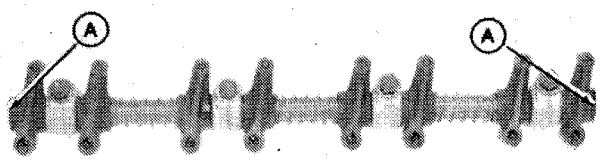
If rocker arm diameter is over 20.17 mm (0.794 in.), install a new rocker arm.



2AJ;T81237 T49;0402 43 041083

ASSEMBLE ROCKER ARM ASSEMBLY

1. Install wavy washer (A) between end rocker arms and plugs.



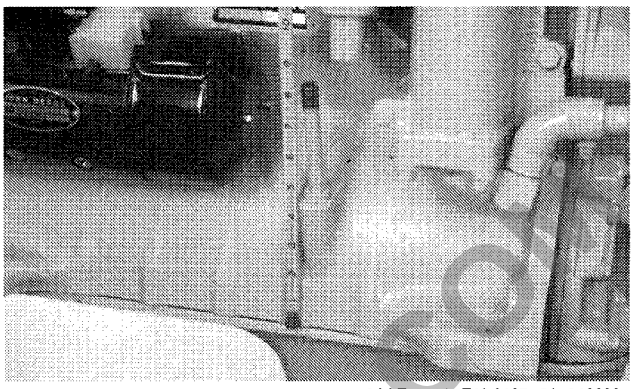
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REMOVE AND INSTALL DIPSTICK NIPPLE

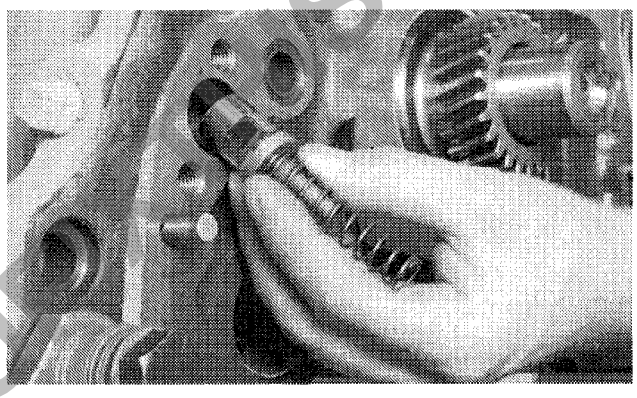
1. Loosen lock nut and remove dipstick nipple.
2. Install dipstick nipple and adjust to height of 210 mm (8.25 in.) from oil pan rail to center of hole in nipple. Tighten lock nut.



3AJ;T91268 T49;0407 54 140383

REMOVE AND INSTALL OIL BYPASS VALVE (410B)

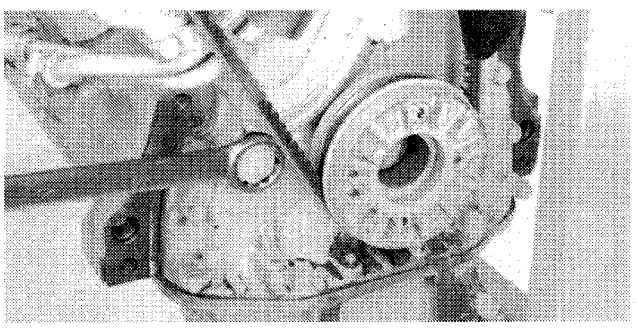
1. Remove timing gear cover (Group 0402).
2. Remove oil bypass valve and spring.
3. Inspect valve and spring for damage.
4. Bypass valve spring test length must be 34 mm (1.34 in.) when compressed with 101 ± 10N (23 ± 2.3 lb force). Replace parts if necessary.
5. Install oil bypass valve and spring.
6. Install timing gear cover (Group 0402).



3AJ;T87436 T49;0407 55 140383

REMOVE AND INSTALL OIL PRESSURE REGULATING VALVE AND SEAT (410B)

1. Remove oil pressure regulating valve plug.



3AJ;T88877 T49;0407 56 140383

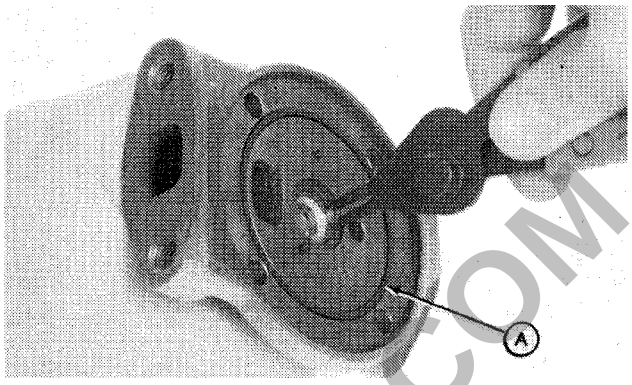
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ASSEMBLE TURBOCHARGER

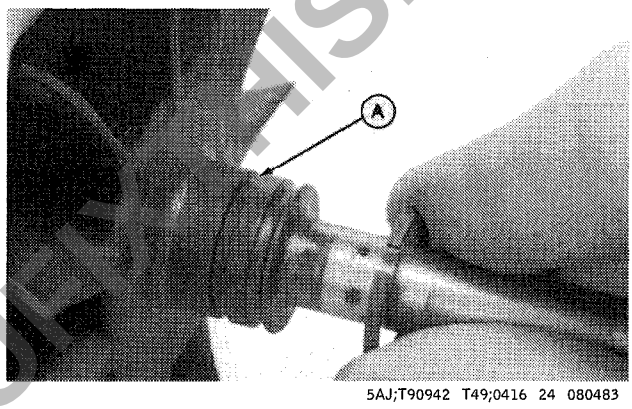
1. Lubricate bearings with clean engine oil and install in center housing.

2. Install new bearing snap rings with rounded shoulder against bearing.



5AJ;T90939 T49;0416 23 080483

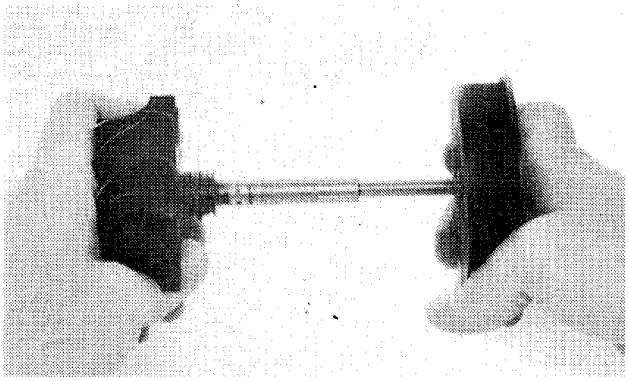
3. Install piston ring in ring groove (A) on shaft.



5AJ;T90942 T49;0416 24 080483

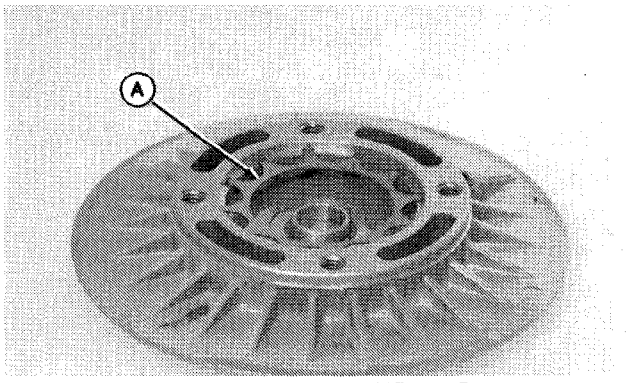
4. Install wheel shroud.

Do not use force to compress piston ring into place. A gentle rocking and pushing action will allow the piston ring to seat and the shaft to bottom. Use pick to aid in compressing the ring, if difficulty is encountered.



5AJ;T90943 T49;0416 25 080483

5. Check thrust spring (A) to make sure it is positioned in back plate.



5AJ;T90944 T49;0416 26 080483

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ESSENTIAL TOOLS

NOTE: Order tools from your SERVICE-GARD™ Catalog. Some tools may be available from a local supplier.

Number	Name	Use
JDE-147 JDG-51	Manifold Pressure Tester Adapter	To pressurize air intake system

T49;0520 K15 170286

SPECIFICATIONS

Item	Measurement	Specification
Air Intake System	Test Pressure	14—21 kPa (140—210 mbar) (2—3 psi)

T49;0520 K16 170286

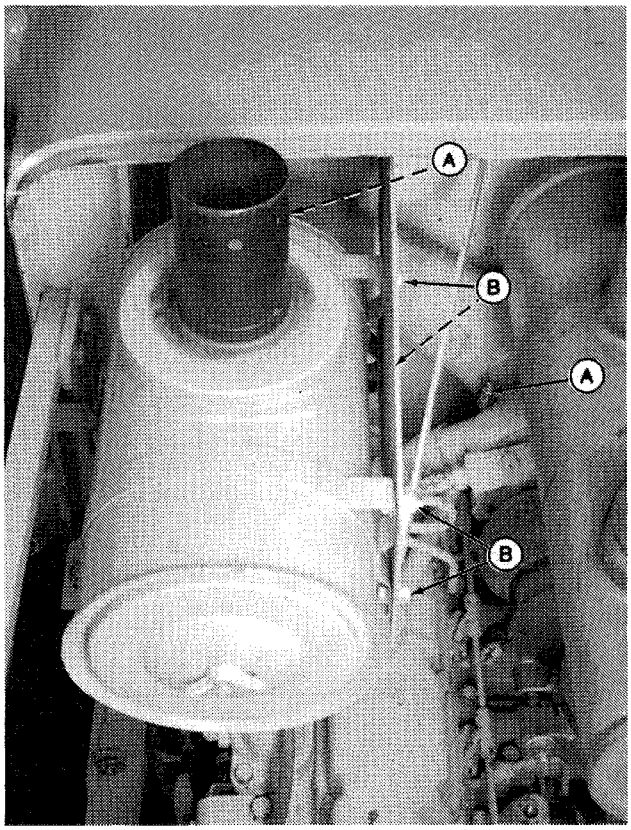
REMOVE AND INSTALL AIR CLEANER

1. Loosen two clamps (A) to remove air cleaner hose.

2. Remove four cap screws and nuts (B) to install air cleaner.

3. Install air cleaner and four cap screws and nuts. Tighten cap screws and nuts.

4. Install hose and two hose clamps. Tighten clamps.



5AJ;T92028 T49;0520 06 170583

T13;0520 01 170286

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NOTE: Steering cylinder can be serviced on unit. Axle shown removed for clarity of photograph.

1. Operate all hydraulic control valves to release pressure in hydraulic system.

CAUTION: Escaping fluid under pressure can penetrate the skin causing serious injury. Relieve pressure before disconnecting hydraulic or other lines. Tighten all connections before applying pressure. Keep hands and body away from pinholes and nozzles which eject fluids under high pressure. Use a piece of cardboard or paper to search for leaks. Do not use your hand.

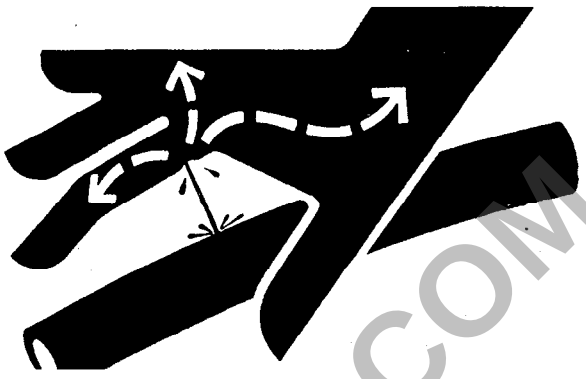
If ANY fluid is injected into the skin, it must be surgically removed within a few hours by a doctor familiar with this type injury or gangrene may result.

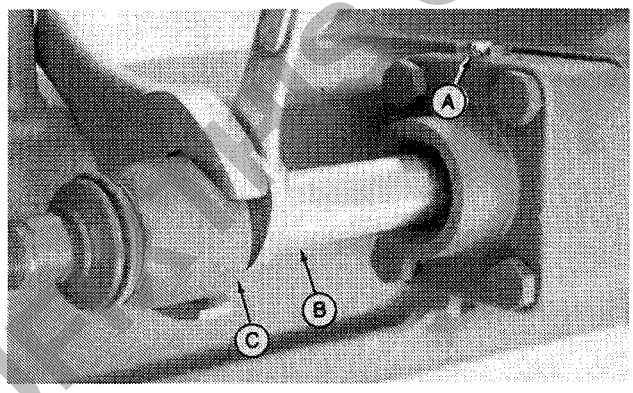
2. Disconnect line from cylinder end cap connection (A). Close openings using caps and plugs.

CAUTION: To avoid personal injury, handle butane torch with care. Follow necessary precautions when working with an open flame.

IMPORTANT: To avoid damaging seals, do not overheat piston rod. Use a butane torch with low flame. Stop before heat reaches seals.

3. Heat piston rod (B) near ball joints (C) to break down sealant on threads. Disconnect ball joints from piston rod.





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ADJUST PARK BRAKE



1. Park machine on level surface and lower all equipment to the ground.

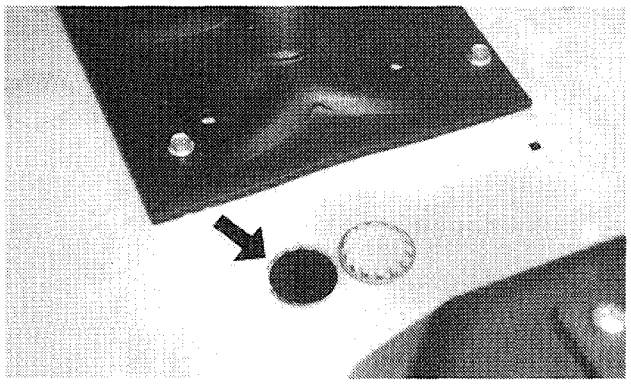
2. Put transaxle in neutral and lock reverser lever in neutral.

3. Shut the engine off and block wheels to prevent movement.

NOTE: Park brake must not be engaged while adjusting.

4. Position park brake lever with latch in bottom notch.

2AL;T5985AJ T51;1115 J90 030785 JW

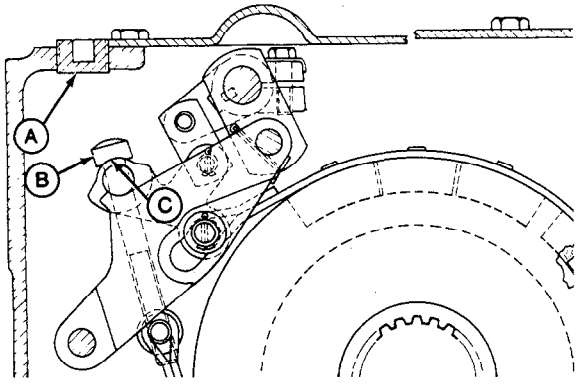


5. Remove button plug from hole (arrow) in cab floor behind seat.

6. Remove plug (A) from top rear of transaxle..

7. Use a wide blade screw driver and adjust set screw (B) clockwise until it cannot be tightened another half turn.

8. Loosen set screw approximately 2½ turns making certain concave surface (C) on bottom of set screw head mates with convex surface of pivot pin. It will feel like a detented position.



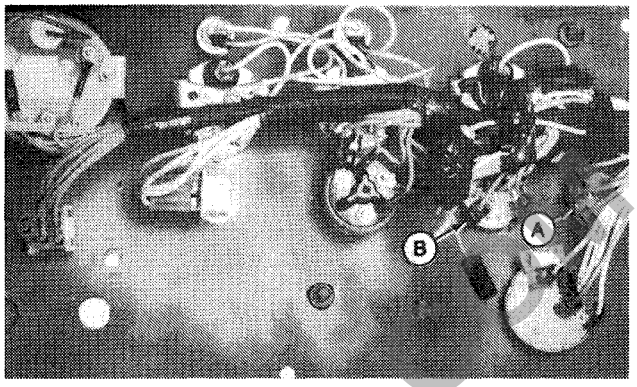
2AL;T5985AJ, T6148AC T51;1115 J91 150785 JW

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5. Remove front wiper switch (A) or rear wiper switch (B) from panel and disconnect wire leads.

6. Install switch in instrument panel and tighten nut.

7. Connect wire leads to switch terminals.



WIPER SWITCH CONNECTIONS

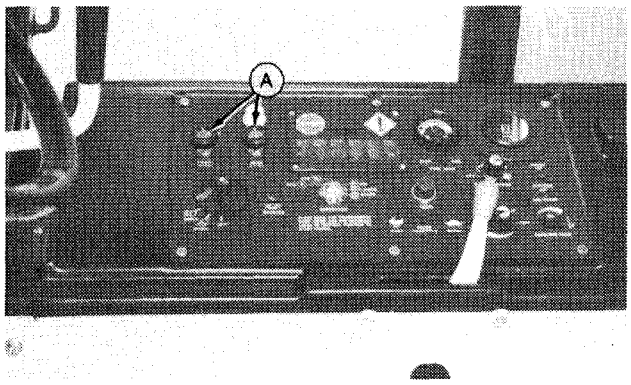
Front Wiper Switch		Rear Wiper Switch	
Terminal No.	**Wire No.**	**Terminal No.**	**Wire No.**
1	605	1	
2	69	2	66
3	600	3	65
4	606	4	
5	68	5	64
W	67 and 67A	W	67A
B	110	B	107

8. Connect wire harness to blower resistor and install instrument panel cover.

9. Install instruction panel, heater control knob and wiper switch knob.

6AL;T90606 T52;1674 J39 040488

REMOVE AND INSTALL WIPER SWITCH—410C/510C



1. Remove heater knob (A) (if equipped) and six instrument panel screws.

2. Remove wiper switch knob and nut.

3. Disconnect wire leads to remove switch.

4. Connect wire leads to switch terminal.

	Front Wiper Switch	Rear Wiper Switch
Terminal No.	**Wire No.**	**Wire No.**
1	601 Orange	606 Orange
2	602 Orange	607 Orange
3	603 Orange	
4	604 Orange	
5	605 Orange	608 Orange
B	15D and 15E Red	15E Red
W	Washer Lead	

5. Install switch, nut, and knob.

6. Install instrument panel and heater knob (A) (if equipped).

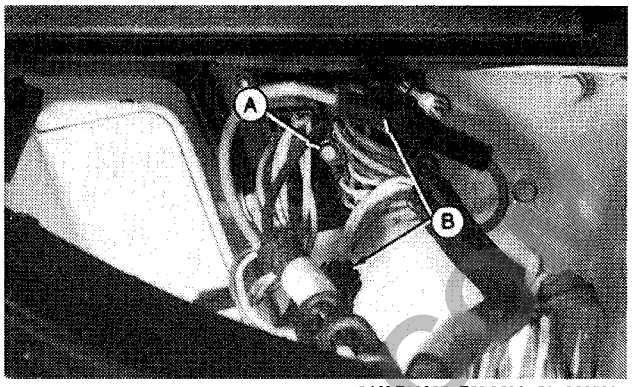
6AL;T6118A02 T52;1674 K108 060289

2T1;161674 09 090289

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15. Disconnect wiring harnesses (B) and remove cap screw (A).



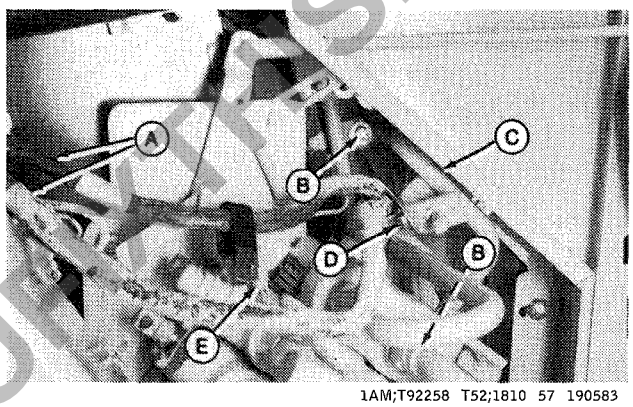
1AM;T92257 T52;1810 56 190583

16. Remove cap screw (D) and nut.

17. Disconnect wiring lead (E), and disconnect wiring harnesses (A).

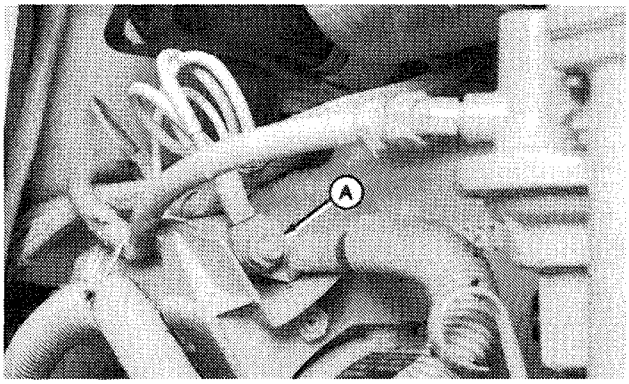
18. Loosen cap screws (B) and nuts to remove bracket (C).

A—Wiring Harness (2 used)
B—Cap Screw (2 used)
C—Bracket
D—Cap Screw
E—Wiring Lead



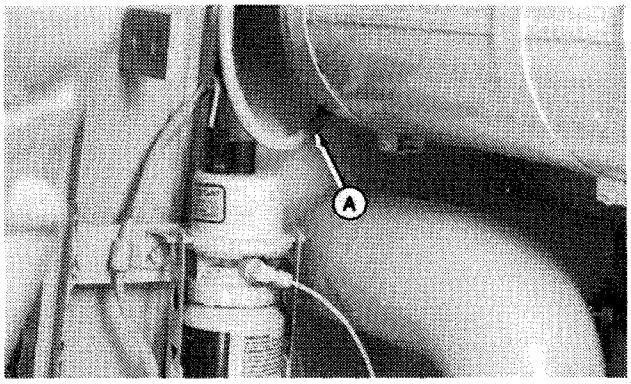
1AM;T92258 T52;1810 57 190583

19. Disconnect battery cable from starter (A).



1AM;T92259 T52;1810 58 190583

20. Disconnect hose (A).

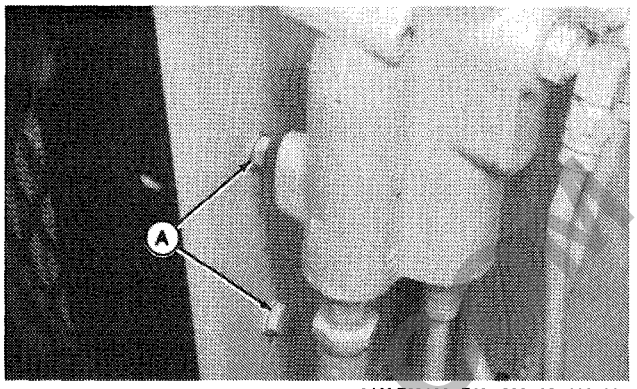


1AM;T92260 T52;1810 59 190583

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16. Install cap screws (A), washer and nuts.



2AM;T91029 T52;1830 08 090583

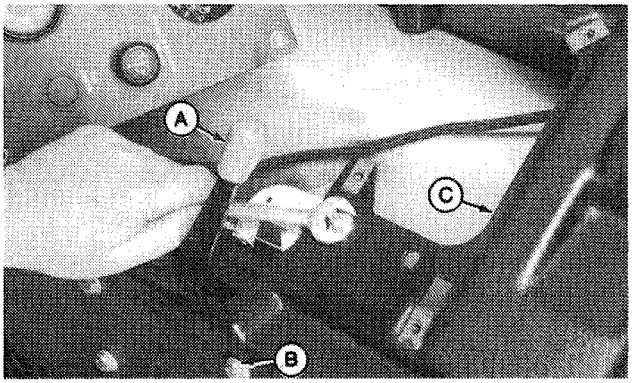
17. Install stabilizer valve and tighten cap screws.



2AM;T91028 T52;1830 09 090583

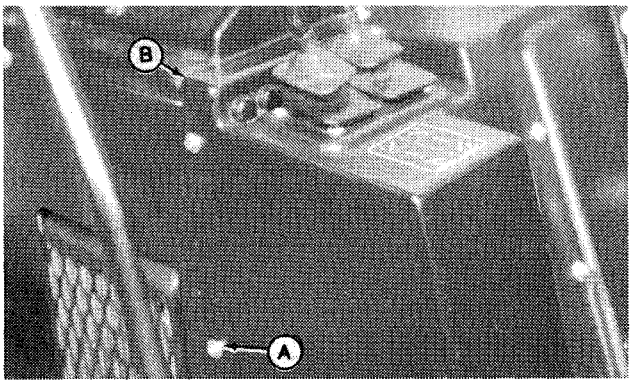
18. Slide housing (C) over side instrument panel and install using five cap screws (B).

19. Install engine speed control lever knob (B).



2AM;T91027 T52;1830 10 090583

20. Install console housing (B) and tighten cap screws (A).

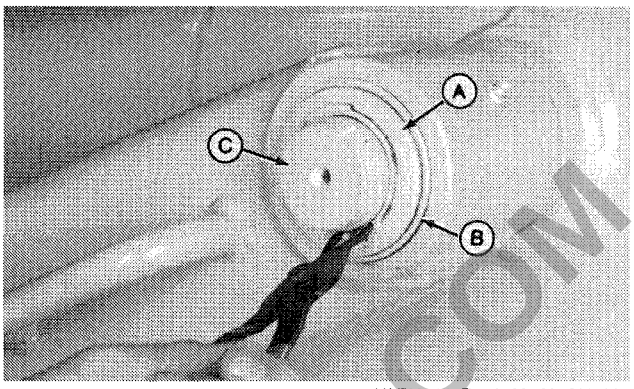


2AM;T90638 T52;1830 11 090583

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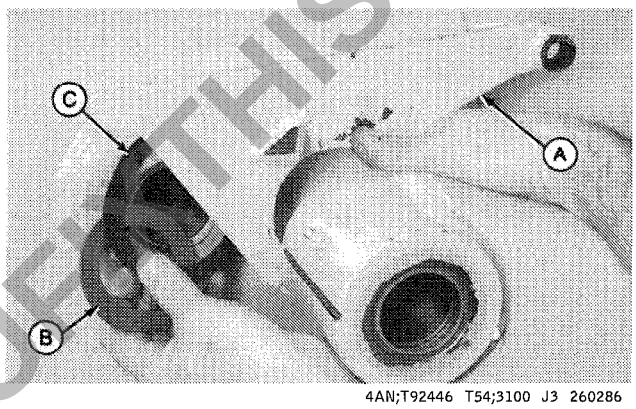
7. Remove snap ring to remove washer (A), spacers (B), and pin (C).



4AN;T92445 T54;3100 06 200583

8. Using the hoist, raise loader to remove actuator (A), washer (B), and spring washer (C). Washer (B) (410B and 510B only).

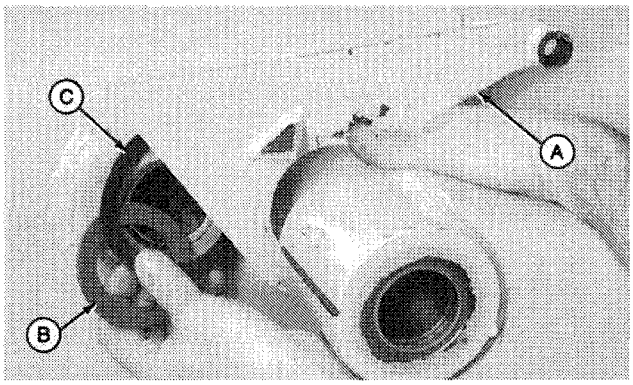
9. Remove loader.



4AN;T92446 T54;3100 J3 260286

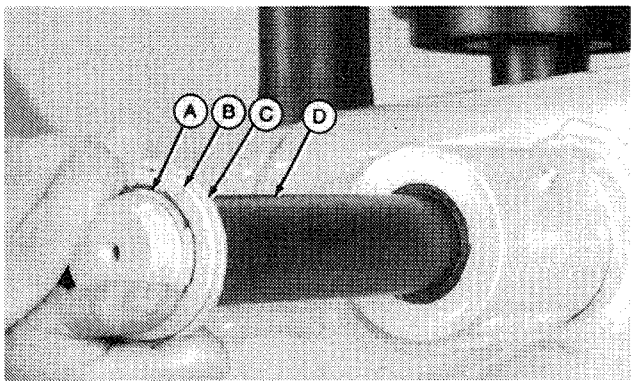
INSTALL LOADER

1. Install loader assembly, spring washer (C), [washer (B) (410B and 510 only)], and actuator (A).



4AN;T92446 T54;3100 J5 100386

2. Install pin (D), spacer (C), washer (B), and snap ring (A). Install washer and snap ring on other side.



4AN;T92448 T54;3100 10 200583

A—Snap Ring
B—Washer
C—Spacer
D—Pin

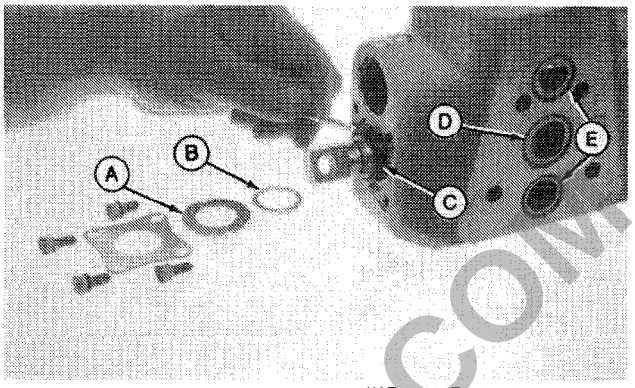
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11. Install O-rings (C, D, and E).

12. Install backup ring (B) and washer (A).

13. Install retainer screws.



7AV;T90136 T58;3160 220 060683

DISASSEMBLE BOOM SECTION (GRESEN)—410B/510B

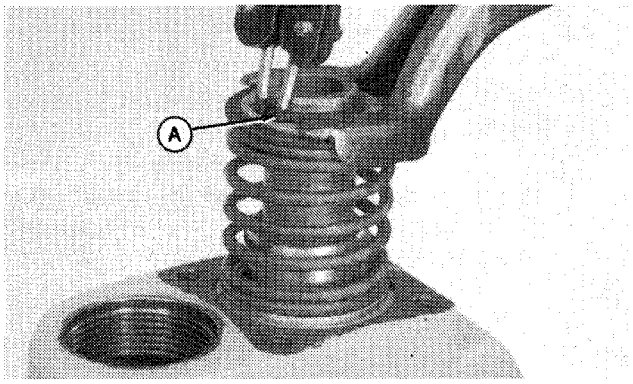
1. Remove four cap screws to remove end cap.



7AV;T90141 09T;3160 K122 070289

2. Use a spring compressor to hold spring.

3. Remove snap ring (A).

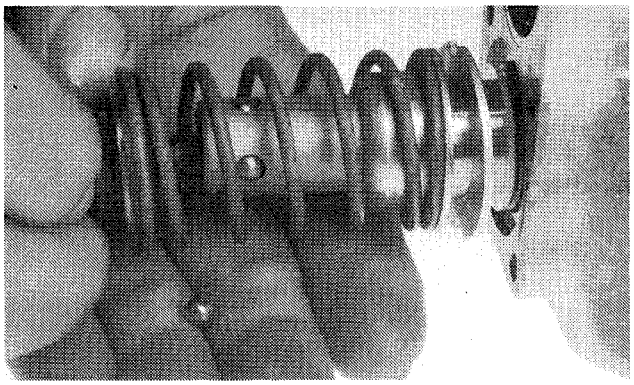


7AV;T90143 T58;3160 222 060683

4. Release spring compressor to remove collar bushing, spring guides, spring, and four balls.

NEW SPRING SPECIFICATIONS

Free length (approximate)	59.9 mm (2.358 in.)
Test length at 173.5 ± 18 N (39 ± 4 lb force)	21.2 mm (0.835 in.)



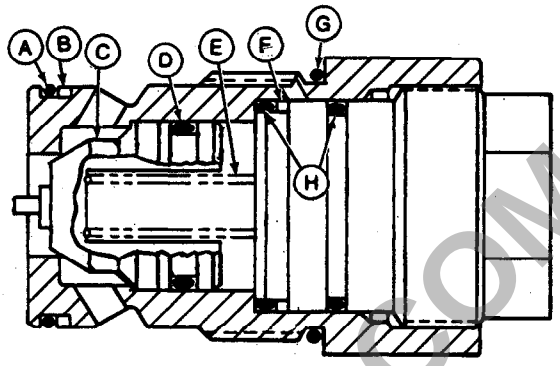
7AV;T90144 T58;3160 223 060683

2T1;313160 19 210289

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CROSS SECTION OF BOOM ANTI-CAVITATION PLUG—410C/510C

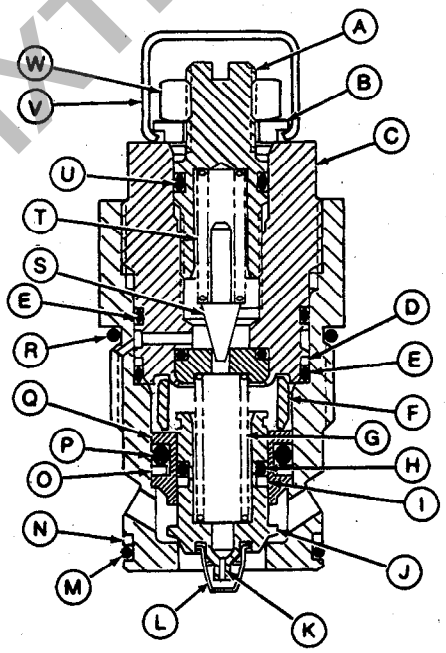


A—O-Ring
B—Back-Up Ring
C—Poppet
D—O-Ring
E—Spring
F—Back-Up Ring
G—O-Ring
H—O-Ring

7AV;T6295AQ 09T;3160 K146 070289

CROSS SECTION OF BUCKET CIRCUIT RELIEF VALVE—410C/510C

NOTE: Marked RP30RV



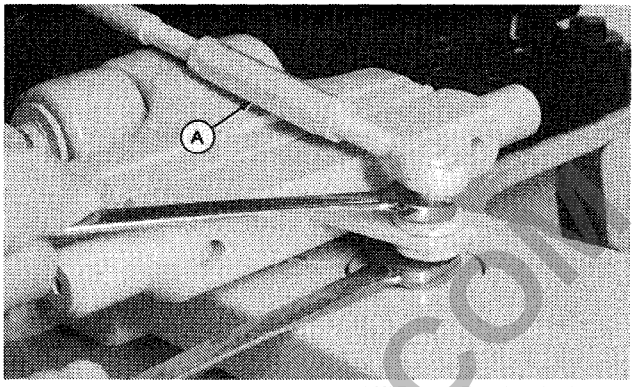
A—Adjusting Screw
B—Washer
C—Pilot Body
D—Backup Ring
E—O-Ring (2 used)
F—Spacer
G—Spring
H—O-Ring
I —Backup Ring
J—Relief Poppet
K—Orifice
L—Screen
M—O-Ring
N—Backup Ring
O—Backup Ring
P—O-Ring
Q—Piston
R—O-Ring
S—Pilot Poppet
T—Spring
U—O-Ring
V—Cap
W—Nut

7AV;T6295AR 09T;3160 K147 070289

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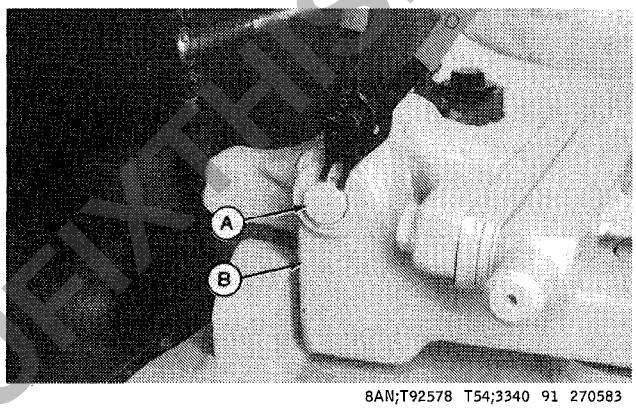
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8. Remove nut to diconnect linkage (A).



8AN;T92577 T54;3340 90 270583

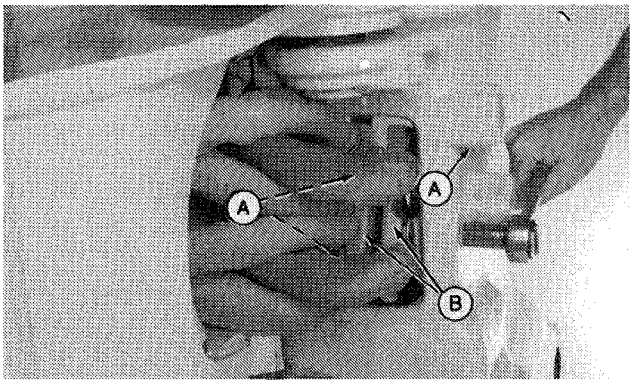
9. Remove snap ring and pin (A) to remove pivot assembly (B).



8AN;T92578 T54;3340 91 270583

10. Put identification marks on hoses and hose positions in clamps to aid in assembly.

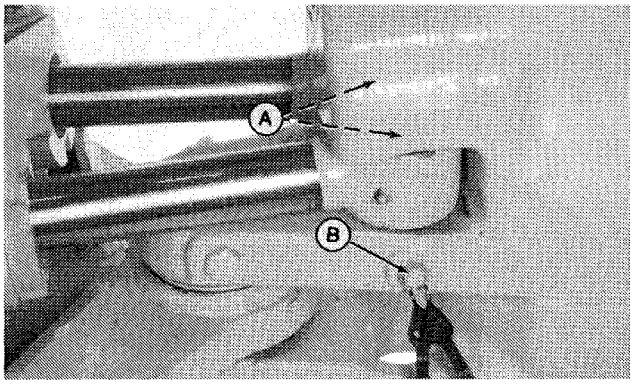
11. Remove four cap screws (A) to remove clamps (B).



8AN;T92579 T54;3340 92 270583

12. Remove snap ring to remove pin (B).

13. Remove cylinder pins (A).



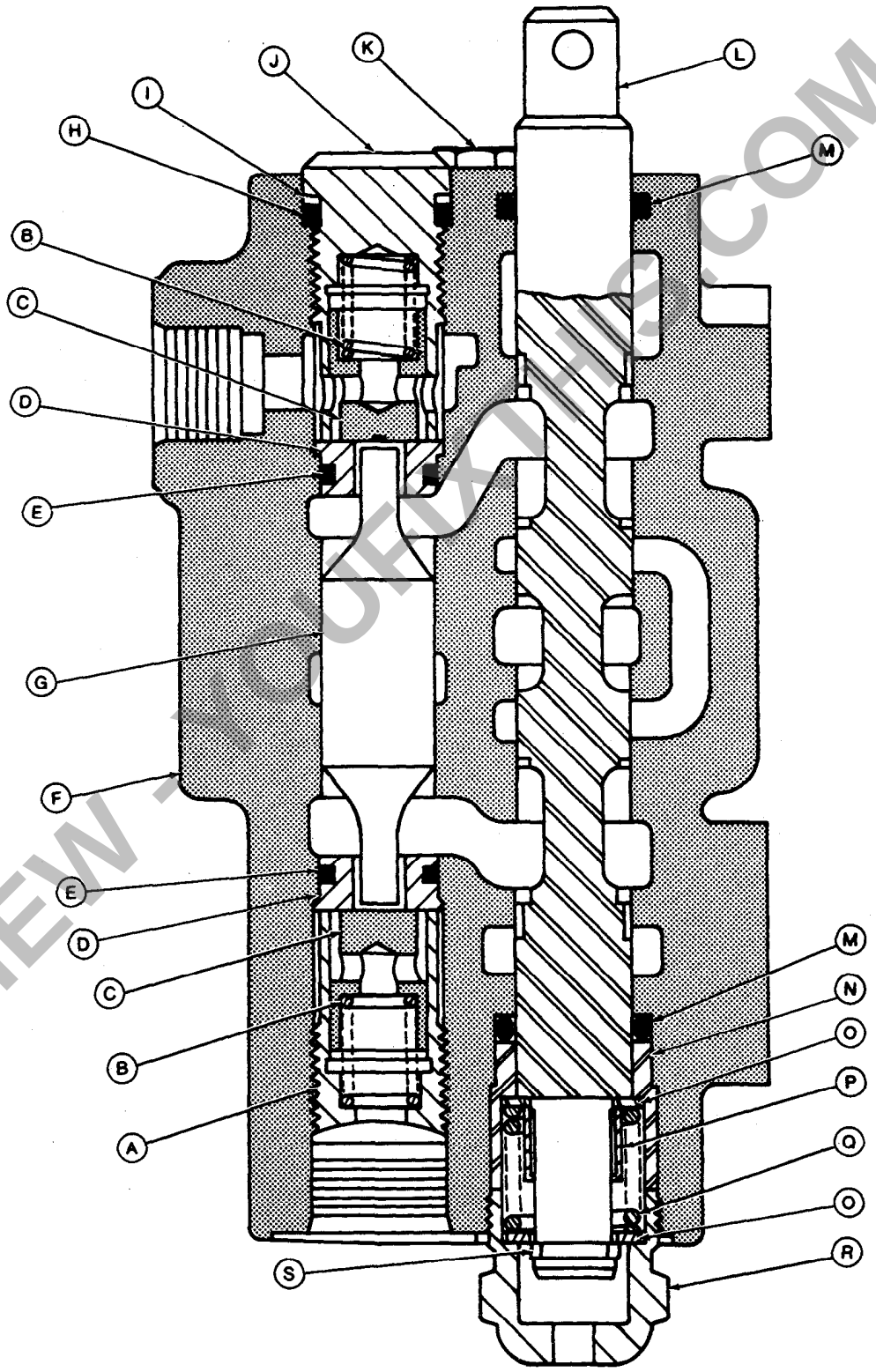
8AN;T92580 T54;3340 93 270583

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CROSS SECTION OF STABILIZER CONTROL VALVE

A—Lockout Seat Retainer (2 used)
B—Spring (4 used)
C—Lockout Poppet (4 used)
D—Seat (4 used)
E—O-Ring (4 used)
F—Valve Body
G—Lockout Plunger (2 used)
H—O-Ring (2 used)
I—Backup Ring (2 used)
J—Lockout Seat Retainer (2 used)
K—Thermal Relief Valve (2 used)
L—Spool (2 used)
M—O-Ring (4 used)
N—Bushing (2 used)
O—Washer (4 used)
P—Spacer (2 used)
Q—Spring (2 used)
R—Cap (2 used)
S—Snap Ring (2 used)



7AV;T88570 T58;3360 J60 190386

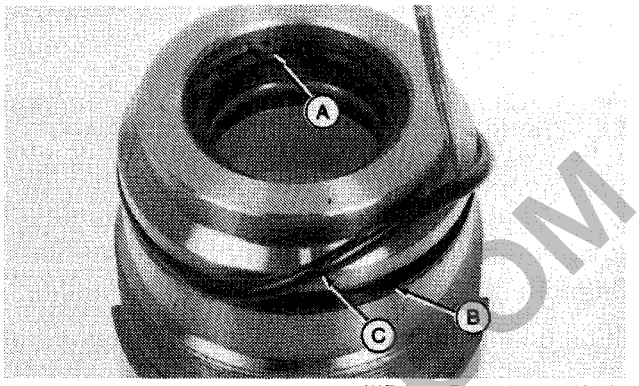
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4. Install the snap ring (A).

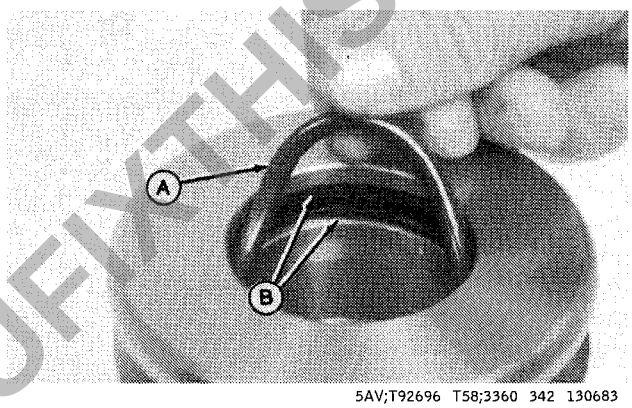
5. Install the backup ring (B) with concave side toward O-ring. Install the O-ring (C). Also install O-ring and backup ring in cylinder end. Apply petroleum jelly on O-ring and backup ring.

6. Install rod guide on rod.



5AV;T92695 T58;3360 341 130683

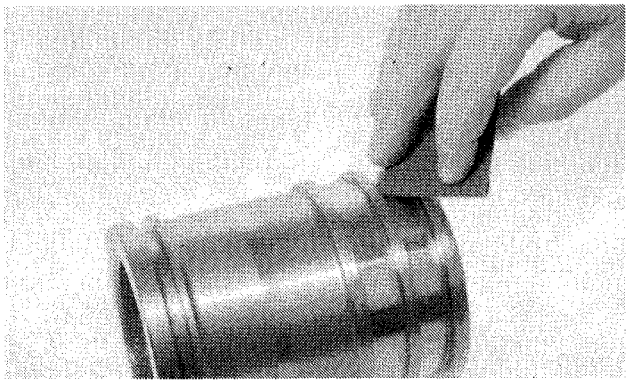
7. Install O-ring (A). Install the backup rings (B) with concave side toward O-ring. Apply petroleum jelly on O-ring and backup rings.



5AV;T92696 T58;3360 342 130683

IMPORTANT: To prevent damage of cap seal during assembly, the lands on piston must be clean and free of nicks or burrs.

8. Inspect the piston lands. If necessary, clean the lands of any nicks or burrs that can cut cap seal.



5AV;T92697 T58;3360 343 130683

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