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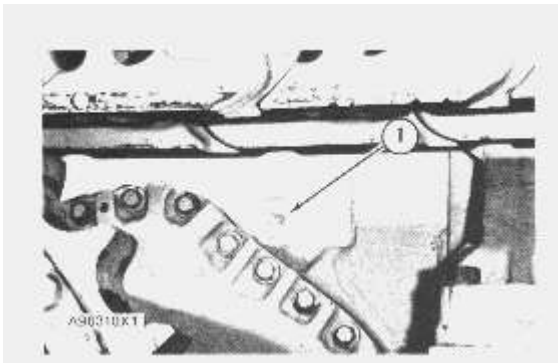
Remove Steering Clutches

Tools Needed		A
2B9886	Hydraulic Jack	1

START BY:

a) remove brake hydraulic controls and actuating mechanisms

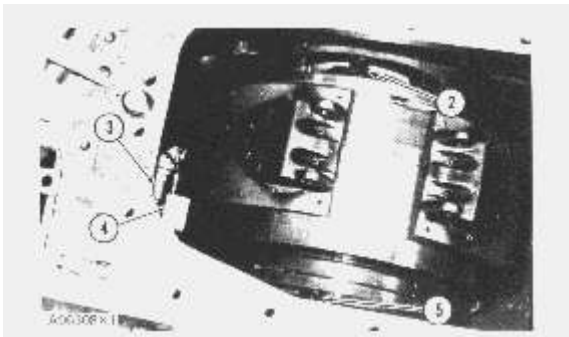
1. Drain the oil from the steering clutch case.



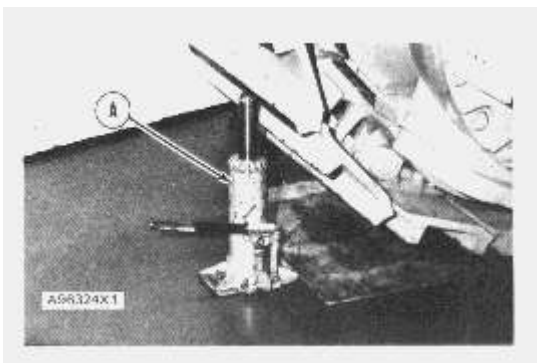
2. Remove plug (1) from the side of the steering clutch case.

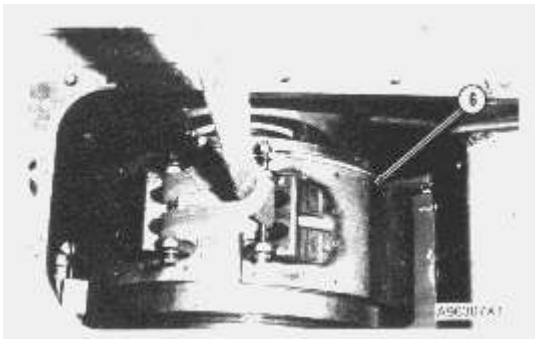
NOTICE

Remove all of the bolts (2) and (5) except for one on each side of the steering clutch. The machine must be moved forward or backward to remove all of the bolts.



3. Remove bolts (5) that hold the steering clutch to the steering clutch hub. Remove bolts (2) that hold the steering clutch to the flange through the opening in the bevel gear case from which plug (1) was removed. Use tool (A) to move the machine to turn the steering clutch to remove the bolts.
4. If so equipped, disconnect oil line (3) from fitting (4).

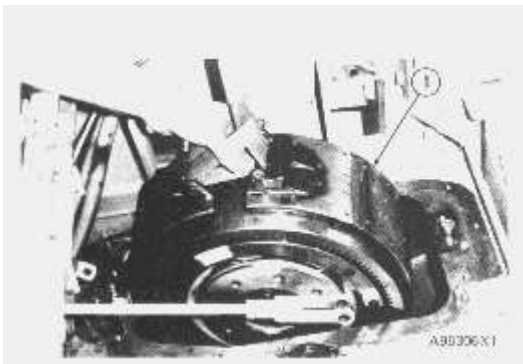




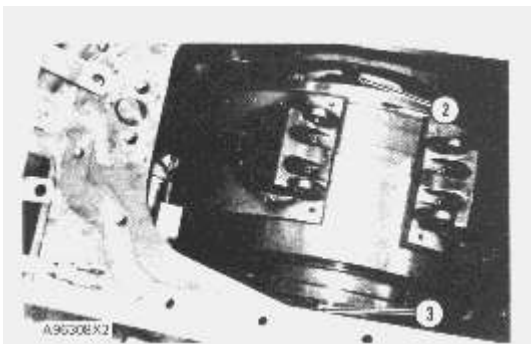
5. Install two 3/8"-16 NC \times 4 in. long bolts and nuts in the brake bands as shown. Fasten a hoist to the brake bands and remove the last two bolts that hold the steering clutch in position. Remove steering clutch (6) from the machine. The weight is 175 lb. (79 kg).

Install Steering Clutches

Tools Needed		A
2B9886	Hydraulic Jack	1



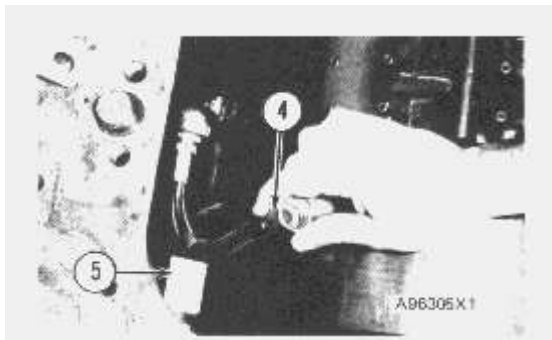
1. Install two 3/8"-16 NC \times 4 in. long bolts in the brake bands and fasten a hoist as shown.



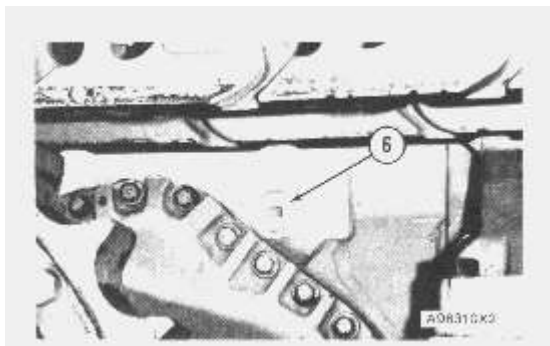
2. Put steering clutch (1) in position between the steering clutch hub and the flange. Install two bolts (2) and (3) to hold the steering clutch in position. Remove the hoist and bolts from the brake band.

3. Put 5P3931 Anti-Seize Compound on the threads of all the bolts. Install the bolts that hold the steering clutch in position. Tighten the bolts to a torque of 200 ± 20 lb.ft (270 ± 25 N·m).

NOTE: Use tool (A) or move the machine to install the bolts that hold the steering clutch in position.



4. If so equipped, connect oil line (4) to fitting (5).



5. Install plug (6) in the steering clutch case.

6. After the brake actuating mechanism is installed, fill the steering clutch case and bevel gear case with oil to the correct level. See MAINTENANCE GUIDE.

END BY:

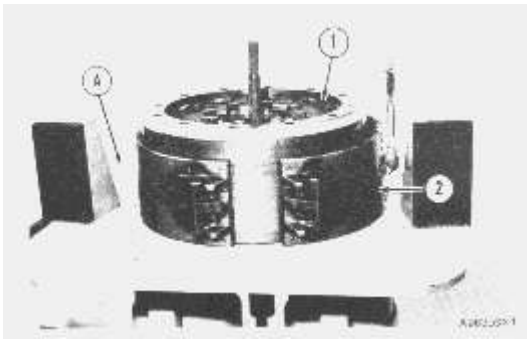
a) install brake hydraulic controls and actuating mechanisms

Disassemble Steering Clutches

Tools Needed		A	B	C
FT610	Steering Clutch Stand	1		
5F5304	Plate		1	
5F5096	Plate			1
5F7353	Washer			2

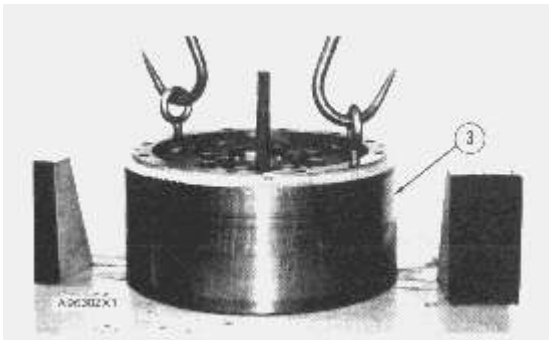
START BY:

a) remove steering clutches

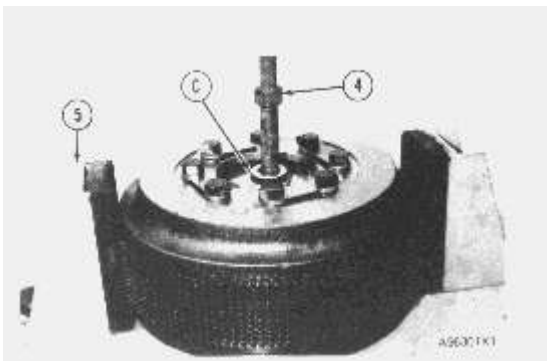


1. Put tool (B) over the stud of tool (A). Fasten a hoist and put steering clutch (1) in position on tool (A) and (B).

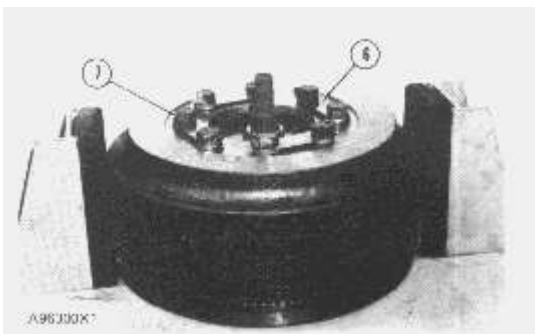
2. Remove brake band (2) from the outer drum.



3. Install two 5/8\"-11 NC forged eyebolts in the outer drum. Remove outer drum (3). The weight of the outer drum is 110 lb. (50 kg).

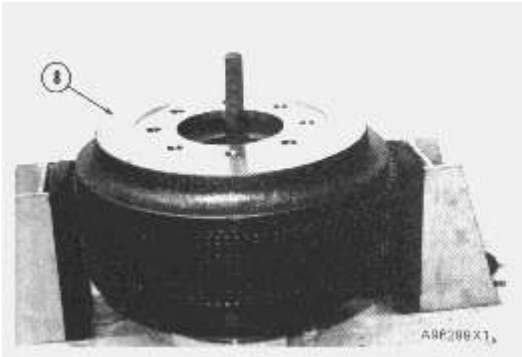


4. Install tooling (C) and nut (4) over the stud of tool (A). Put disc aligners (5) of tooling (A) in position.



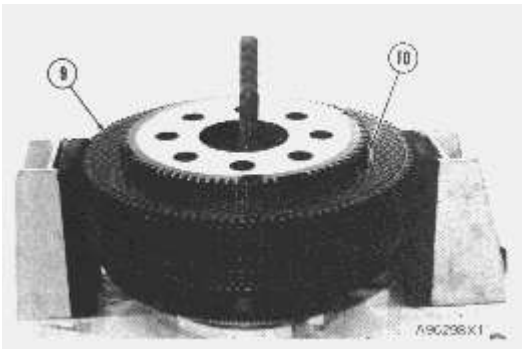
5. Put enough force on the steering clutch to put the springs under compression. Bend locks (6) down and remove bolts (7) and locks (6).

6. Release the compression from the springs. Remove nut (4) and tooling (C).

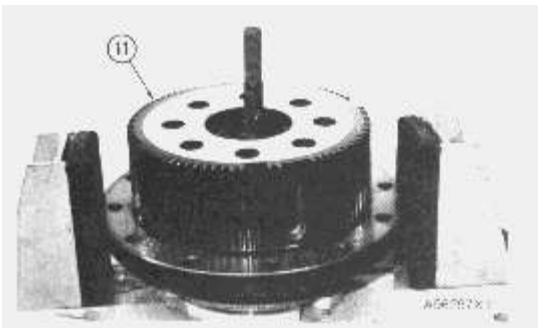


7. Remove pressure plate (8).

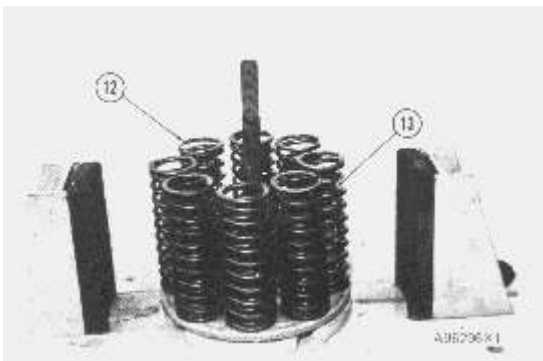
NOTE: Find dimension of stack height to measure for wear. See SPECIFICATIONS.



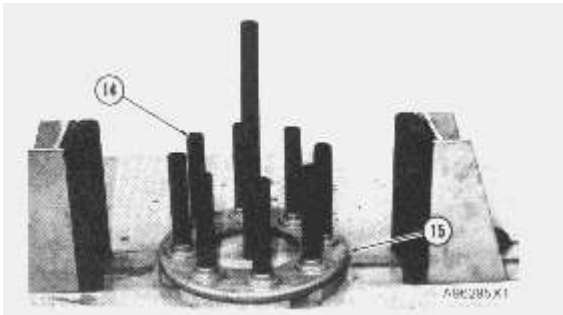
8. Remove twelve disc assemblies (9) and eleven discs (10) from the inner hub.



9. Remove inner drum (11) from the springs.



10. Remove eight outer springs (12) and eight inner springs (13) from the retainer.

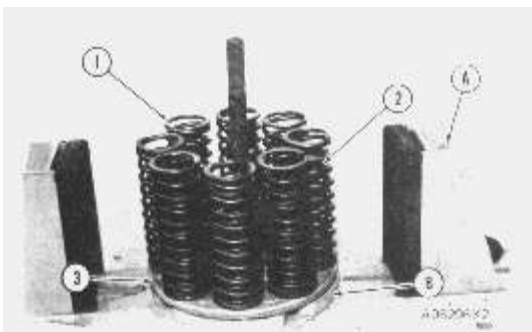


11. Remove eight sleeves (14) from retainer (15).

12. Remove retainer (15).

Assemble Steering Clutches

Tools Needed		A	B	C
FT610	Steering Clutch Stand	1		
5F5304	Plate		1	
5F5096	Plate			2
5F7353	Washer			2



1. Put tool (B) over the stud of tool (A).

2. Put retainer (3) on tool (B). Make sure that the bosses for the springs are up.

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