Paragraphs 3-5

remove weight from front tires. Remove pivot pin retaining cap screw and drive out pivot pin. Unbolt and remove stay rod ball socket cap (13). Raise front of tractor and roll front axle assembly forward from under tractor.

STEERING KNUCKLES

Series B-275-B-414-354-364-384

3. The steering knuckles can be removed from the axle extensions after steering arms and wheel assemblies have been removed.

After being pressed into place, ream inside diameter of new knuckle bushings (1-Fig. 1 or 2) to 1.359-1.360. Outside shaft diameter of new steering knuckle (8 or 11--Fig. 7) is 1.357-1.358. Operating clearance between knuckle shafts and bushings is 0.001-0.003. Use a piloted drift when installing bushings and install same with outer ends flush with beere.

Series 424-444-2424-2444

4. To remove the steering knuckles (1-Fig. 4 or 5) from tractors equipped with adjustable front axle, first support. front of tractor and remove front wheel assemblies. Disconnect tie rods (9) from steering arms (8 and 27) and remove the arms from steering knuckles.

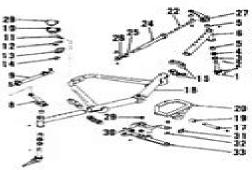


Fig. 5.—Exploded view of Series 424, 444, 2424 and 2444 narrow bread adjustable front sale and component perts.



Remove Woodruff keys and lower steering knuckles out of axie.

The procedure for removing steering knuckles (1-Fig. 6) from the nonadjustable heavy duty axie is the same as the adjustable axie with the following exceptions: The steering arms and steering knuckles are splined instead of having Woodruff keys. Snap rings (7) must also be removed before steering knuckles can be removed from axie.

Steering knuckle bushings (5-Fig. 4. 5 and 6) should be installed with a closely fitting mandrel and sized after installation, if necessary, to provide a recommended clearance of 0.002-0.004

INTERNATIONAL HARVESTER

for the steering knuckle.

When installing thrust bearings (4) on steering knuckles, make certain that open end of outer race is facing down-

TIE-ROD, DRAG LINK AND TOE-IN

All Models

5. On early B-275 models the tie-rod and drag link ends are of the non-adjustable type and excessive wear is corrected by renewal of the complete tie-rod and/or drag link. On later B-275

Fig. 6—Employed riew of Series 424, 444, 2424 and 2444 heavy duty non-ad-Instable front asia and COMMISSION OF BAYES.

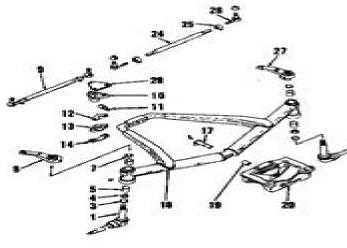
- Stating knockle Folt weather Threat bearing Snap ring
- Steering arm N.M. Tim roof anny. Smil nucket. Nati

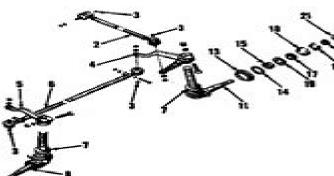
- Strim
 Cup
 Lock plate
 Pivet pin
 Axis main membe
 Pivet bushing
- Lower bolster Tube Clamp

- Tim ried mad Standing arm L.M.

Fig. 7—Exploded view of Series 8-275, 8-414, 354, 364 and 384 steering Eneckies, steering some, tie rod and drag link used on models with no power stearing. Models with power stearing are similar.

- Drug Sich.
- Greate String L.H. steering arm R.H. steering arm The red
- The raid Threat bearing & E.H. steering & L.E. steering in Post, attack Felk wanter Starring spaces Oil seal





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