

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 pointed drift when installing bushings and install same with outer ends flush with bore.

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 the rods (9) from steering arms (8 and 27) and remove the arms from steering knuckles.

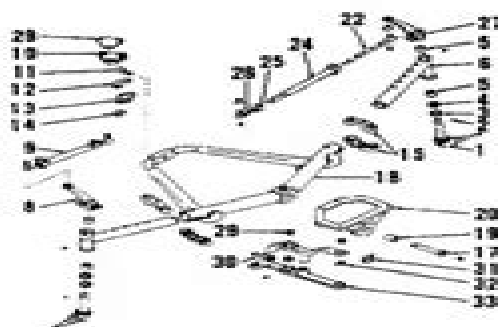


Fig. 5—Exploded view of Series 424, 444, 2424 and 2444 narrow band adjustable front axle and component parts.

- | | |
|----------------------|----------------------------|
| 1. Steering knuckle | 18. Axle main member |
| 2. Woodruff key | 19. Pivot bushing |
| 3. Felt washer | 20. Lower bracket |
| 4. Thrust bearing | 21. Tube |
| 5. Bushing | 22. Clamp |
| 6. Axle extension | 23. Tie rod end |
| 8. Steering arm R.H. | 24. Steering arm L.H. |
| 9. Tie rod end | 25. Speed |
| 11. Ball socket | 26. Steering arm support |
| 12. Shim | 27. Pivot bushing |
| 13. Cap | 28. Cylinder arm (forward) |
| 14. Lock plate | |
| 15. Axle clamp | |
| 17. Pivot pin | |

Remove Woodruff keys and lower steering knuckles out of axle.

The procedure for removing steering knuckles (1—Fig. 6) from the non-adjustable heavy duty axle is the same as the adjustable axle 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 axle.

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

for the steering knuckle.

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

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—Exploded view of Series 424, 444, 2424 and 2444 heavy duty non-adjustable front axle and component parts.

- | |
|-----------------------|
| 1. Steering knuckle |
| 2. Felt washer |
| 3. Thrust bearing |
| 4. Bushing |
| 5. Snap ring |
| 6. Steering arm R.H. |
| 7. Tie rod end |
| 8. Ball socket |
| 9. Shim |
| 10. Cap |
| 11. Lock plate |
| 12. Pivot pin |
| 13. Axle main member |
| 14. Pivot bushing |
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| 16. Tube |
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| 18. Tie rod end |
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| 20. Speed |

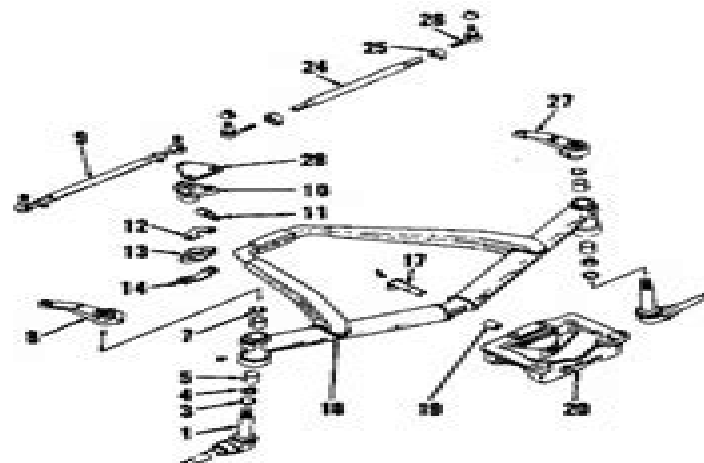
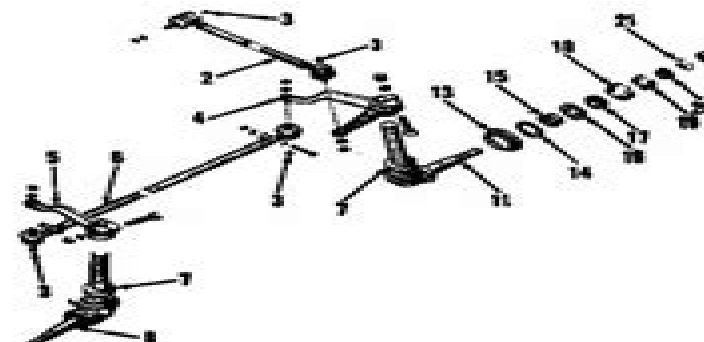


Fig. 7—Exploded view of Series B-275, B-414, 354, 364 and 384 steering knuckles, steering arms, tie rod and drag link used on models with no power steering. Models with power steering are similar.

- | |
|--------------------------|
| 1. Drag link |
| 2. Lower spring |
| 3. L.H. steering arm |
| 4. R.H. steering arm |
| 5. Tie rod |
| 6. Thrust bearing |
| 7. R.H. steering knuckle |
| 8. L.H. steering knuckle |
| 9. Shim |
| 10. Felt washer |
| 11. Steering speed |
| 12. Steering cap |
| 13. Steering cap |
| 14. Steering cap |
| 15. Retainer washer |



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