



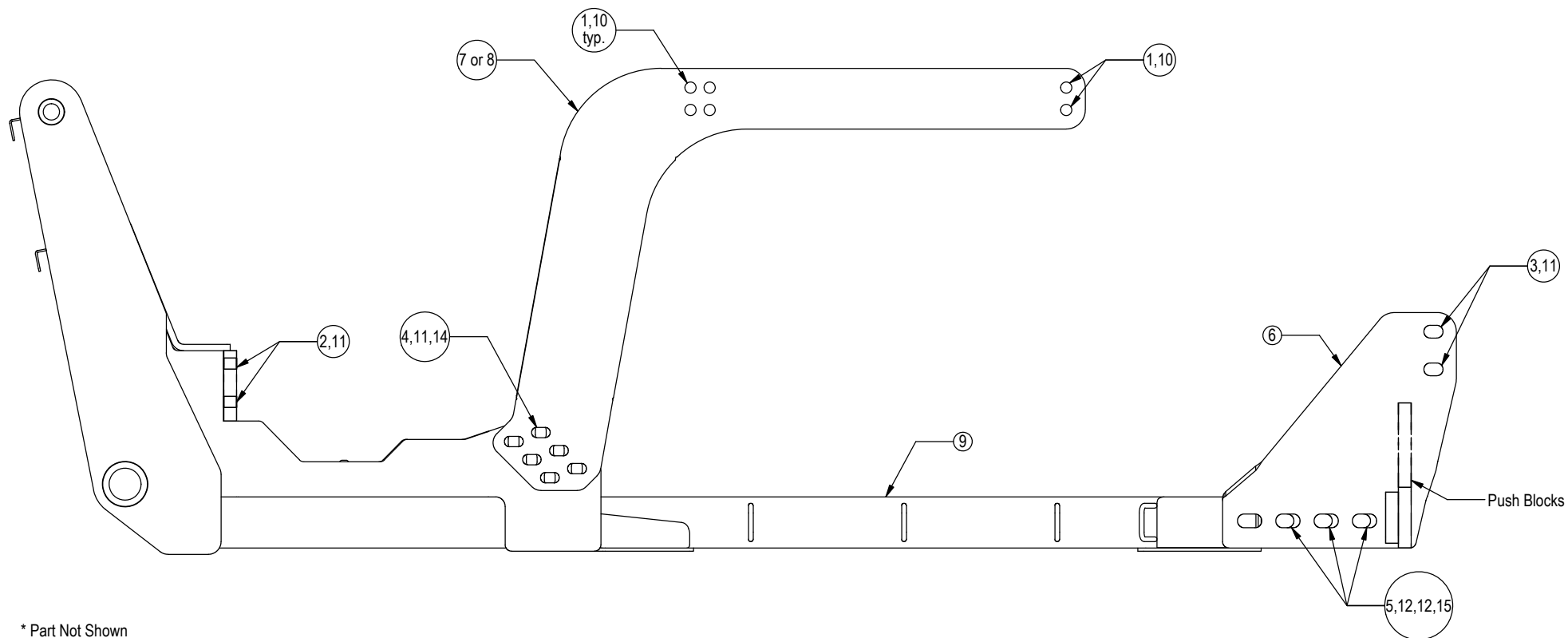
# FH-400 John Deere 8R (Tier 3) with IVT Undercarriage Installation Instructions

## 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 weights and weight bracket from front of tractor if necessary.
  3. Remove toolbox from left side of tractor and the implement quick coupler from the right side if necessary.
  4. Attach the rear bracket (PN: 18-14855) to the undercarriage (U/C) with 6 - 1" x 2-1/2" bolts (PN: 16-20560), 12 - 1" flat washers (PN: 57-20819), and 6 - 1" nuts (PN: 70-20599). Tighten finger tight. See attached diagram for clarification.
  5. Position the U/C under the tractor and center with the frame of the tractor.
  6. Lift the U/C until the holes on the tractor line up with the U/C holes.
  7. At the front of the tractor, use 4 - 20mm x 70mm bolts (PN: 16-1876) with a 3/4" washer (PN: 57-20747) on each bolt to attach the U/C to the front of the tractor. See attached diagram for clarification.
  8. Raise rear of undercarriage until holes on the tractor line up with the U/C holes.  
**Be sure that the push blocks are tight against bolt heads at rear of U/C.**
  9. Attach the toolbox, the implement quick coupler (if applicable), and the rear of U/C to the tractor with 4 - 20mm x 50mm bolts (PN: 16-1878) with a 3/4" washer (PN: 57-20747) on each bolt.  
**NOTE: If applicable, remove ILS cylinder top grease fitting on each side and install a new 90° grease fitting.**
  10. Attach the right rail (PN: 46-14038-R) to the right side of the undercarriage with 6 - 3/4" x 2-1/2" carriage bolts (PN: 16-21220), 6 - 3/4" washers (PN: 57-20747) and 6 - 3/4" center lock nuts (PN: 70-20607). See attached diagram for clarification.  
**NOTE: Install carriage bolts from outside for proper clearance. Nut has to be on the inside of U/C.**
  11. Attach the left rail (PN: 46-14038-L) to the left side of the undercarriage with 6 - 3/4" x 2-1/2" carriage bolts (PN: 16-21220), 6 - 3/4" washers (PN: 57-20747) and 6 - 3/4" center lock nuts (PN: 70-20607). See attached diagram for clarification.  
**NOTE: Install carriage bolts from outside for proper clearance. Nut has to be on the inside of U/C.**
  12. Start 6 - 16mm x 90mm bolts (PN: 16-1620090) with a 5/8" flat washer (PN: 57-20746) on each bolt through the top holes of the left and right rail and the tractor frame. See attached diagram for clarification.
  13. Once all bolts are installed, torque all 20mm bolts to 432 ft-lbs., all 16mm bolts to 269 ft-lbs., all 1" bolts to 903 ft-lbs., and all 3/4" bolts to 257 ft-lbs.
  14. After first 8 hours of use, re-torque all bolts.
  15. Check all fasteners regularly to ensure proper operation of equipment.

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF GROUSER PRODUCTS INC ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF GROUSER PRODUCTS INC IS PROHIBITED.


REVISIONS:



\* Part Not Shown

Item No.	Qty.	Part No.	Description
1	12	16-1620090	16mm x 2.00mm x 90mm Metric Hex Bolt Gr 10.9 Coarse
2	4	16-1876	20mm x 2.5mm x 70mm Metric Hex Bolt Gr 10.9
3	4	16-1878	20mm x 2.5mm x 50mm Metric Hex Bolt Gr 10.9
4	12	16-21220	3/4" x 2 1/2" Carriage Bolt GR 5 NC
5	6	16-20560	1" x 2-1/2" Hex Bolt Gr 8 NC
6	1	18-14855	FH-400 JD 8030, 8R - IVT/E23 - Tail Section (25")
7	1	46-14038-L	FH-400 JD 8030, 8R (Tier 3) Side Plate Rail Left Weld
8	1	46-14038-R	FH-400 JD 8030, 8R (Tier 3) Side Plate Rail Right Weld
9	1	54-14850	FH-400 UC JD 8030, 8R - IT4 & Ft4
10	12	57-20746	5/8" Flat Washer
11	20	57-20747	3/4" Flat Washer
12	12	57-20819	1" Flat Washer Heavy Duty Gr 8 (USS)
13*	2	58-9372	Grease Zerk 1/8" NPT 90°
14	12	70-20607	3/4" Hex Center Lock Nut Gr 5 NC
15	6	70-20599	1" Hex Nut Gr 8 NC

Parts only shown on left side. Right side is identical.

 <b>GROUSER PRODUCTS INC.</b> 755 2nd Ave NW West Fargo, ND 58078 Phone 701.282.7710 Fax 701.282.8131 WWW.GROUSER.COM		TITLE FH-400 UC JD 8R (Tier 3) - IVT		DWG. NO. <b>15540-A</b>	
		Date: 8-15-2011		Scale: 1:12	