



Supplement Sheet

Date: 6/16/2008

Subject: Service Replacement for the 17198A Segment Gear Stabilizer Plate

Models Affected: N/A

PURPOSE: This supplement sheet is applicable **ONLY** when replacing a 17198A Segment Gear Stabilizer Plate. This sheet is **NOT REQUIRED** when replacing a 783-04644 Segment Gear Stabilizer Plate with the 783-04644 supplied.

This supplement sheet provides the instructions for modifying and installing the 783-04644 Segment Gear Stabilizer Plate supplied when replacing a 17198A Segment Gear Stabilizer Plate which is no longer available.

MODIFYING INSTRUCTIONS:

1. When replacing the 17198A with the current production 783-04644, it is required to open up the middle .325/.320" diameter hole of the 783-04644 to .385/.380" diameter. See Figure 1.

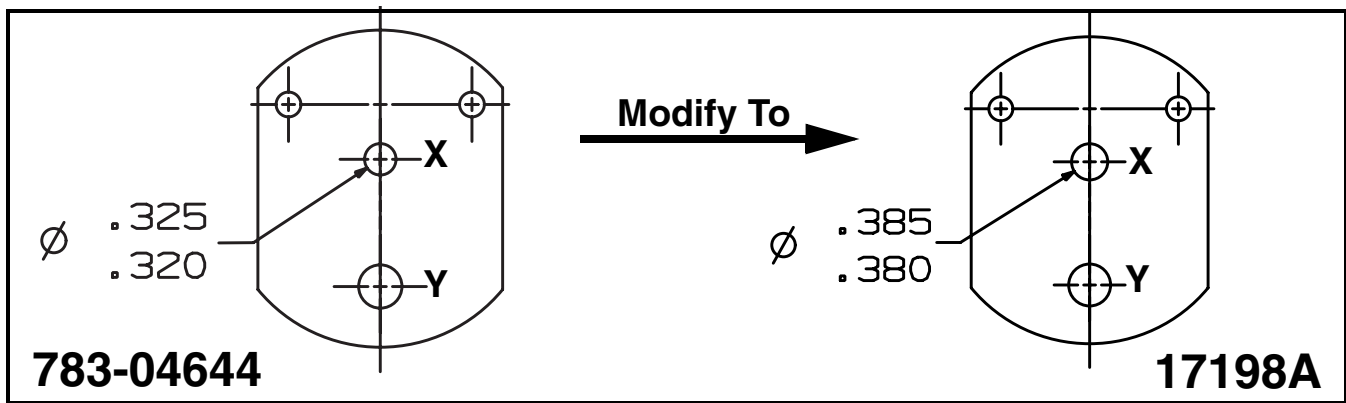


FIGURE 1

2. To maintain dimensional accuracy between the two mounting holes "X" and "Y", it is strongly recommended that the 783-04644 be securely clamped in a drill press when opening the "X" hole to 3/8" diameter.
3. Center the "X" hole with respect to the drill press chuck center line. With the drill press OFF and a 5/16" (.3125") drill bit in the chuck, align the "X" hole by ensuring the 5/16" drill passes freely through the .325/.320" diameter "X" hole.
4. While keeping the 5/16" drill bit in the .325/.320" diameter hole, clamp the 783-04644 securely to the drill press table.
5. Remove the 5/16" drill bit and replace with a sharp 3/8" (.375") diameter drill bit (Optional = .386" (W) drill bit).
6. Open up the .325/.320" diameter hole to 3/8" diameter. Remove sharp edges around 3/8" hole. Use a rat tail file to open the 3/8" hole just enough to allow the 3/8" bolt to fit freely.

INSTALLATION:

When assembling the Gear Segment Stabilizer Plate and Steering Gear Segment to the lower frame, tighten the 738-04141 shoulder bolt (130-170 In-Lbs) before tightening the 710-1039 bolt (400-480 In-Lbs).

Apply Loctite 242 (Blue) or 246 (Red) or equivalent to the **cleaned threads** of 738-04141 and 710-1039 bolts prior to assembly

(Parts in gray are existing)

