

# B4681 SUPPORT FRAME KIT

## Support Frame Mounting Instructions

Tractor Applications: B1700E/DT/HSD\*/HSDB\*, B2100DT/HSD\*/HSDB\*, B2400HSE\*/HSD\*/HSDB\*, B2410HSE/HSD/HSDB, B7300HSD\*, B7400HSD, B7500DT/HSD (\* Requires additional parts)

**IMPORTANT:** All applicable tractors **MUST** have the correct KUBOTA Front Loader installed **BEFORE** attempting to install this support frame kit. Also, this support frame kit **MUST** be installed **BEFORE** attempting to mount the B4672A Backhoe or B5550A Trencher on the tractor.

Remove the rear wheels and drain the transmission oil according to instructions found in the tractor operator's manual.

Remove the appropriate six bolts securing the rear axle housings to the differential case.

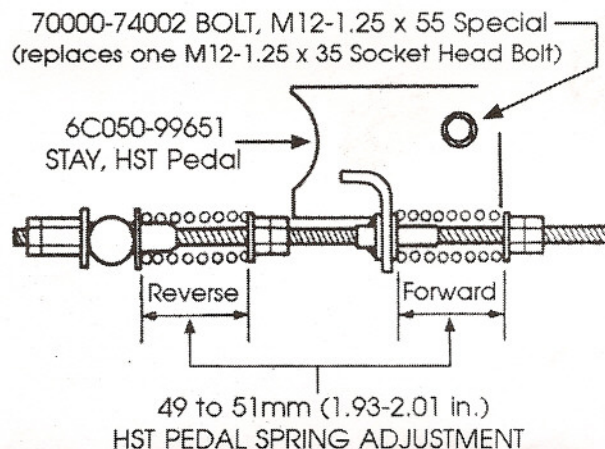
Insert the coarse thread end (M10-1.5) of the four studs, with thread lock, into the upper two holes in each axle housing. Double nut the fine thread end (M10-1.25) of each stud and tighten snugly with a socket wrench. **DO NOT** use an impact wrench as the threads may strip in the aluminum differential case.

Remove the double nuts from the studs and install the support frame pieces to the tractor as shown below. If the tractor is a B1700, B2100, B2400, or B7300 HST model, follow instructions in column two before proceeding.

Leave all fasteners loose until both support frames and belly brace have been installed. Torque fasteners according to information provided below, starting with the socket head bolts.

**B7100, B2100, B2400, & B7300 HST TRACTOR APPLICATIONS** (Require Additional Parts: P/N 700000-74002 Bolt, M12-1.25 x 55 Special, Qty. 1, P/N 6C050-99651 Stay, HST Pedal, Qty. 1.

Remove and discard the HST pedal spring stay and the metric bolt containing a lockwasher. Install the new stay and special (thin head) M12-1.25 x 55 bolt as shown. Also readjust the pedal centering springs to the dimensions shown.



Refill the tractor transmission with KUBOTA "SUPER UDT" fluid and reinstall the rear wheels.

4 - 01555-51065 Stud, M10 x 85  
4 - 04512-50100 Lockwasher, M10  
4 - 02118-50100 Nut, M10-1.25  
Nut Torque = 32 ft. lbs. (43 N·m)

4 - 01370-11235 Socket Head Bolt, M12-1.25 x 35  
Torque = 61 ft. lbs. (83 N·m)  
(install LAST, w/thread lock, & torque FIRST)

4 - 01153-51250 Bolt, M12-1.75 x 50  
4 - 04512-50120 Lockwasher, M12  
Torque = 65 ft. lbs. (88 N·m)

2 - 01173-51000 Bolt, M10-1.25 x 100  
2 - 04512-50100 Lockwasher, M10  
Torque = 40 ft. lbs. (55 N·m)

1 - 70050-00535 Support Frame, RH  
1 - 70050-00536 Support Frame, LH

1 - 70050-94990 Belly Brace

4 - 75599-01530 Bolt, 1/2-13 x 1-1/2  
4 - 75599-33015 Lockwasher, 1/2  
4 - 75599-31015 Nut, 1/2-13  
Torque = 85 ft. lbs. (116 N·m)