



## INSTRUCTION BULLETIN

No. 340051

Machine: 355/385/7400/  
8400/8410

Published: 11-97/01  
System: CHASSIS

**NOTE: DO NOT DISCARD the Parts List from the Instruction Bulletin. Place the Parts List in the appropriate place in your machine manual for future reference. Retaining the Parts List will make it easier to reorder individual parts and will save you the cost of ordering an entire kit.**

*NOTE: Numbers in parenthesis ( ) are reference numbers for parts listed in Bill of Materials.*

Installation Instructions for Kit number 374565 and 374566

### **SYNOPSIS / PROBLEM:**

This kit contains the parts needed to install a rear drive replacement kit on the machines listed above. Please follow step-by-step instructions.

### **SPECIAL TOOLS / CONSIDERATIONS:** None

(Estimated time to complete: 6 hours)

### **DISASSEMBLY:**

(Refer to FIG. 1, 2, 3, 4, 5, and 6)

**FOR SAFETY: Before leaving or servicing machine, stop on level surface and set parking brake. Then turn off machine and remove key.**

1. Raise the drive wheel off the floor and install jack stands under the machine frame.
2. Remove the drive tire and wheel assembly.
3. Remove the hardware holding the end of the steering cylinder to the drive support casting.
4. Disconnect and plug the hydraulic hoses leading to the drive motor.
5. Remove the clamp holding the hydraulic hoses to the top of the drive support casting.
6. Remove the hydraulic drive motor from the support casting.
7. Remove the cotter pin from the slotted nut on the top of the support pin. Remove the slotted nut.
8. Loosen both socket head screws holding the drive support pin in the frame.
9. Position a jack under the drive assembly to support it when the pin is removed. Remove the support pin from the drive assembly. Remove the drive assembly from the machine.
10. Remove the two roller bearings and spacer washer from the support casting. Retain the two roller bearings and spacer washer.
11. Use a press or a hammer and punch to remove the two bearing races from the support casting. Retain the two bearing races.

## RE-ASSEMBLY:

(Refer to FIG. 1, 2, 3, 4, 5, and 6)

1. Press one of the bearing races, removed in step 11 on the first page, into the machined bore of the new support casting (1).

*NOTE: Apply grease on both sealing surfaces on the new grease cavity seal (2) before assembling bearings.*

2. Install the new grease cavity seal (2) in the machined hole of the new support casting (1).
3. Press the second bearing race, removed in step 11 on the first page, into the machined bore of the new support casting (1).
4. Install the two new grease fittings (4) into the two smaller tapped holes on the side of the new support casting (1).
5. Position both roller bearings, removed in step 10 on the first page, in the two bearing races.
6. Reinstall the new support casting (1) and bearings in the machine. Make sure the existing spacer washer, removed in step 10 on the first page, and new felt washer (3) are installed on the top side of the upper roller bearing.
7. Slip the existing pivot pin up from the bottom. Install the slotted nut.
8. Tighten the slotted nut to 25 - 30 ft lbs. Check for play. If the pin is not seated, tap with a rubber hammer and re-tighten the slotted nut.
9. Tighten the top socket head screw to 60 - 65 ft lbs. (.38 bolt) or 85 ft lbs (M16 bolt).
10. Tighten the slotted nut to the next slot (75 ft lbs max) and install the cotter pin.
11. Check to see if the casting rocks or binds. If it does, loosen the top screw, rock the casting to seat the bearing, re-tighten the slotted nut and then the top socket head screw to 60 - 65 ft lbs or 85 ft lb (M16).
12. Tighten the lower socket head screw to 60 - 65 ft lbs. (.38 bolt) or 85 ft lbs (M16 bolt).
13. Grease both grease fittings until grease comes out of the upper and lower bearings.
14. Reinstall the hydraulic drive motor on the support casting. Tighten the four screws to 70 - 85 ft lbs. (90 - 117 Nm)
15. Reconnect the steering cylinder to the top of the support casting. Tighten the hardware to 220 ft lbs.
16. Reconnect the hydraulic hoses to the drive motor.
17. Reinstall the tire and wheel assembly. Tighten the wheel nuts to 90 - 115 ft lbs. (130 - 160 Nm) in a star pattern twice.
18. Remove the jack stands and lower the machine. Operate the machine and check for proper operation.

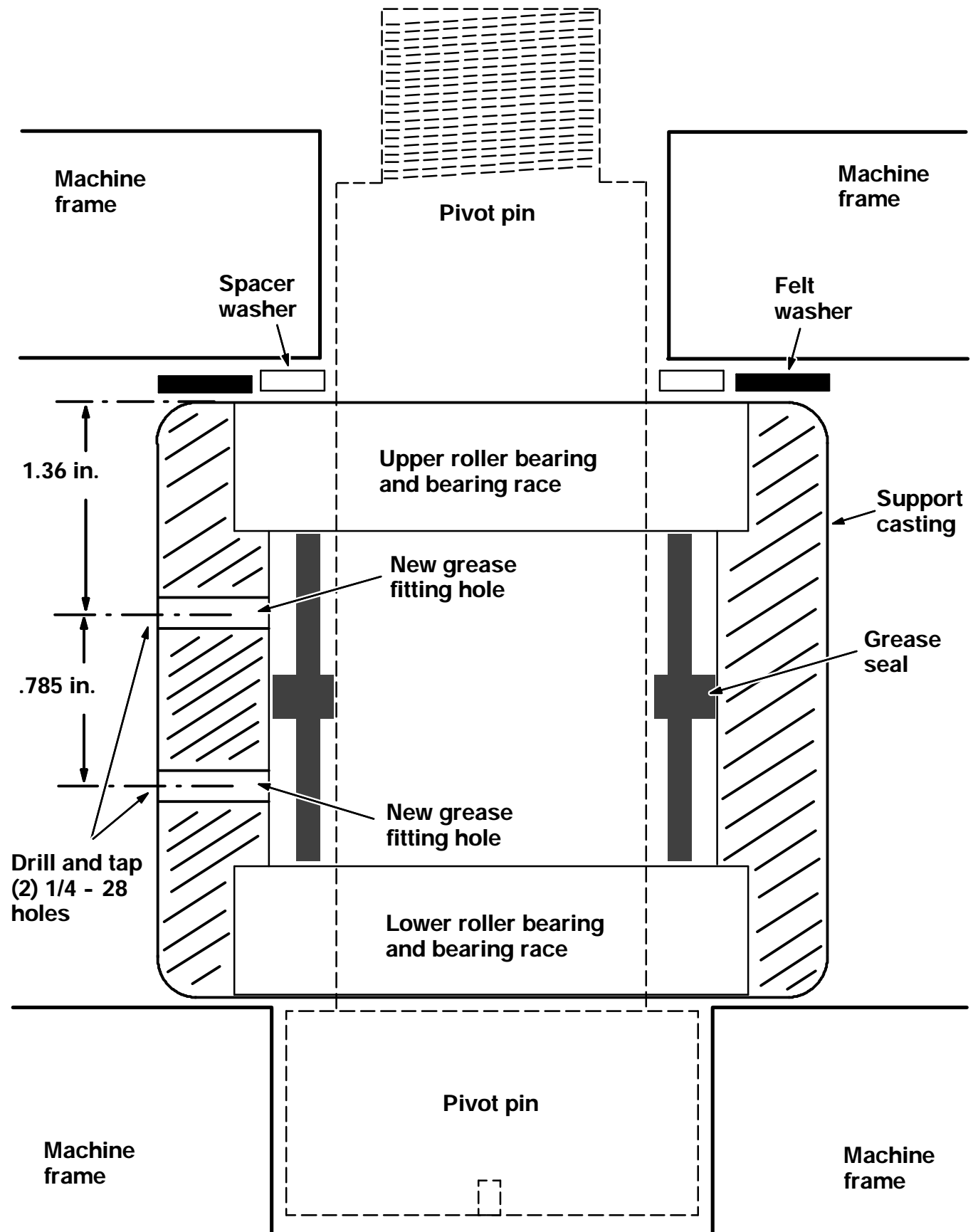
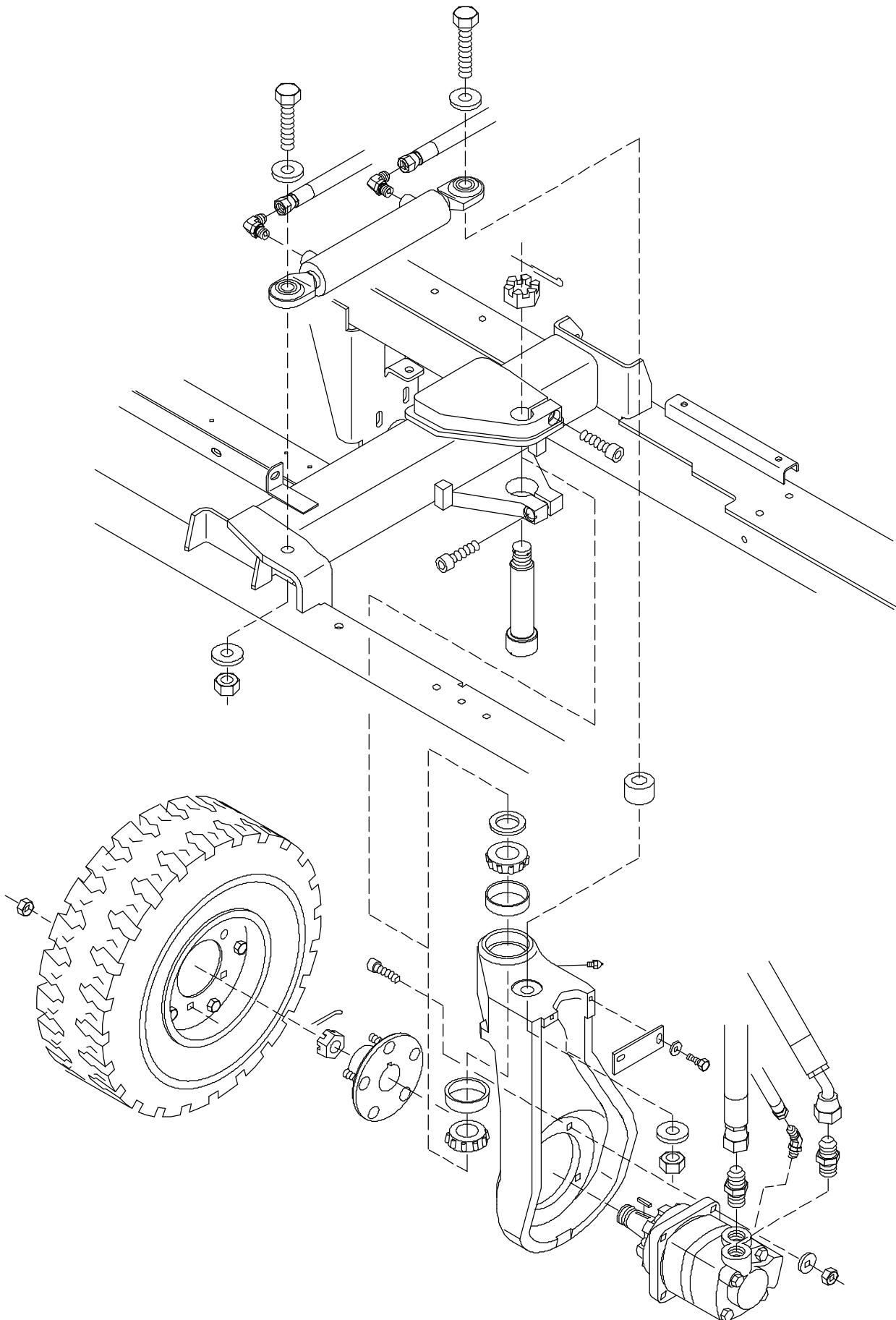
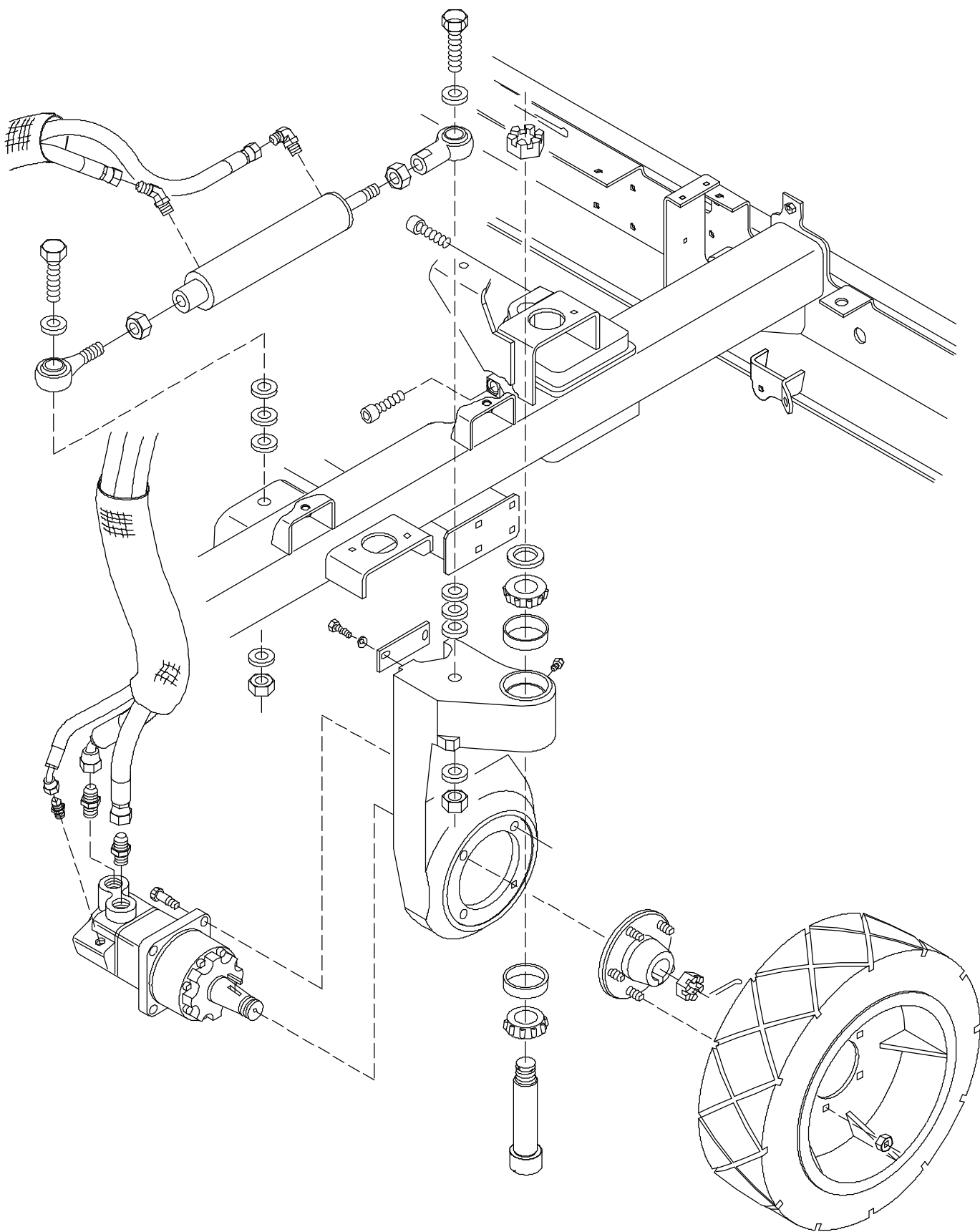


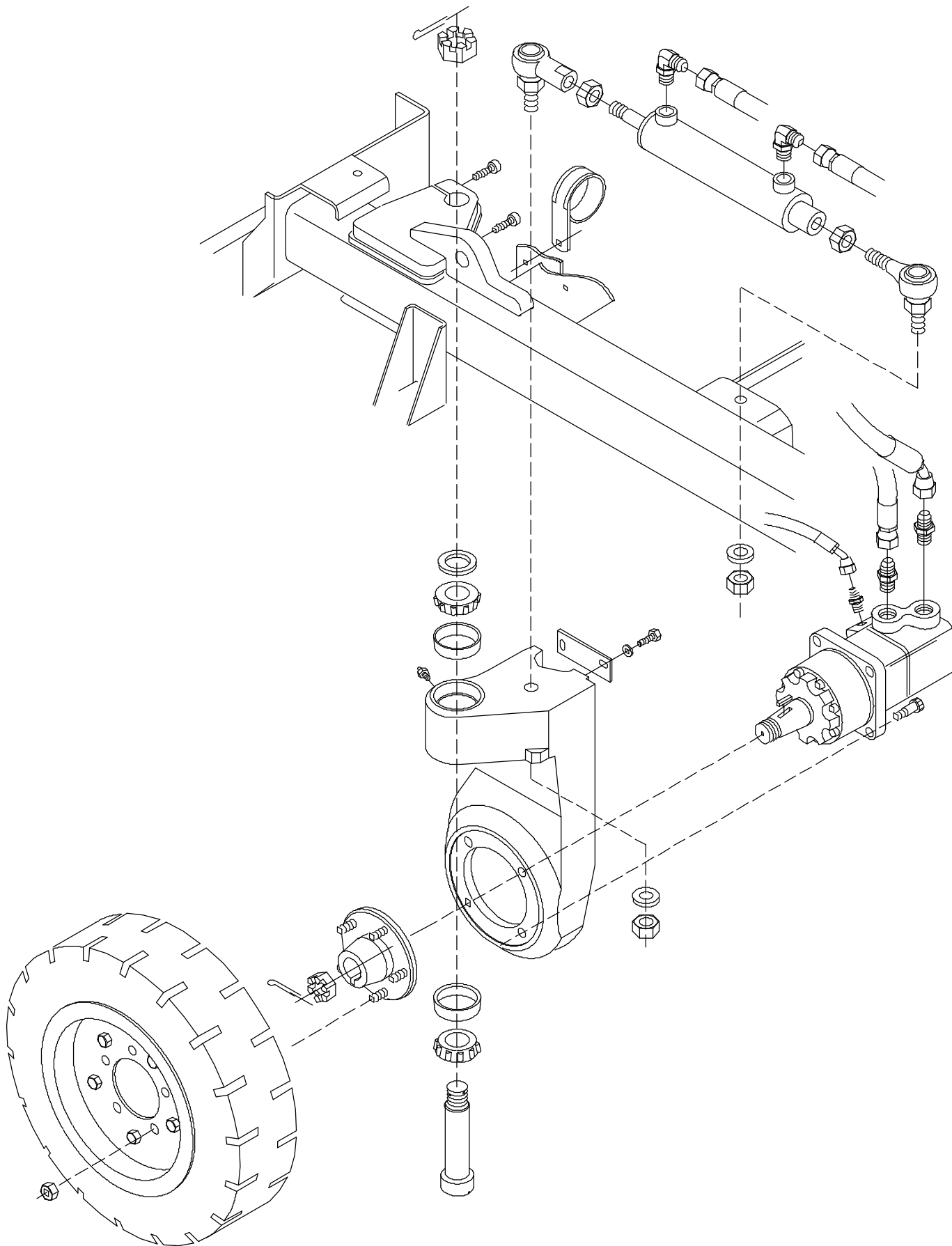
FIG. 1 - Drive Casting Rework And Assembly



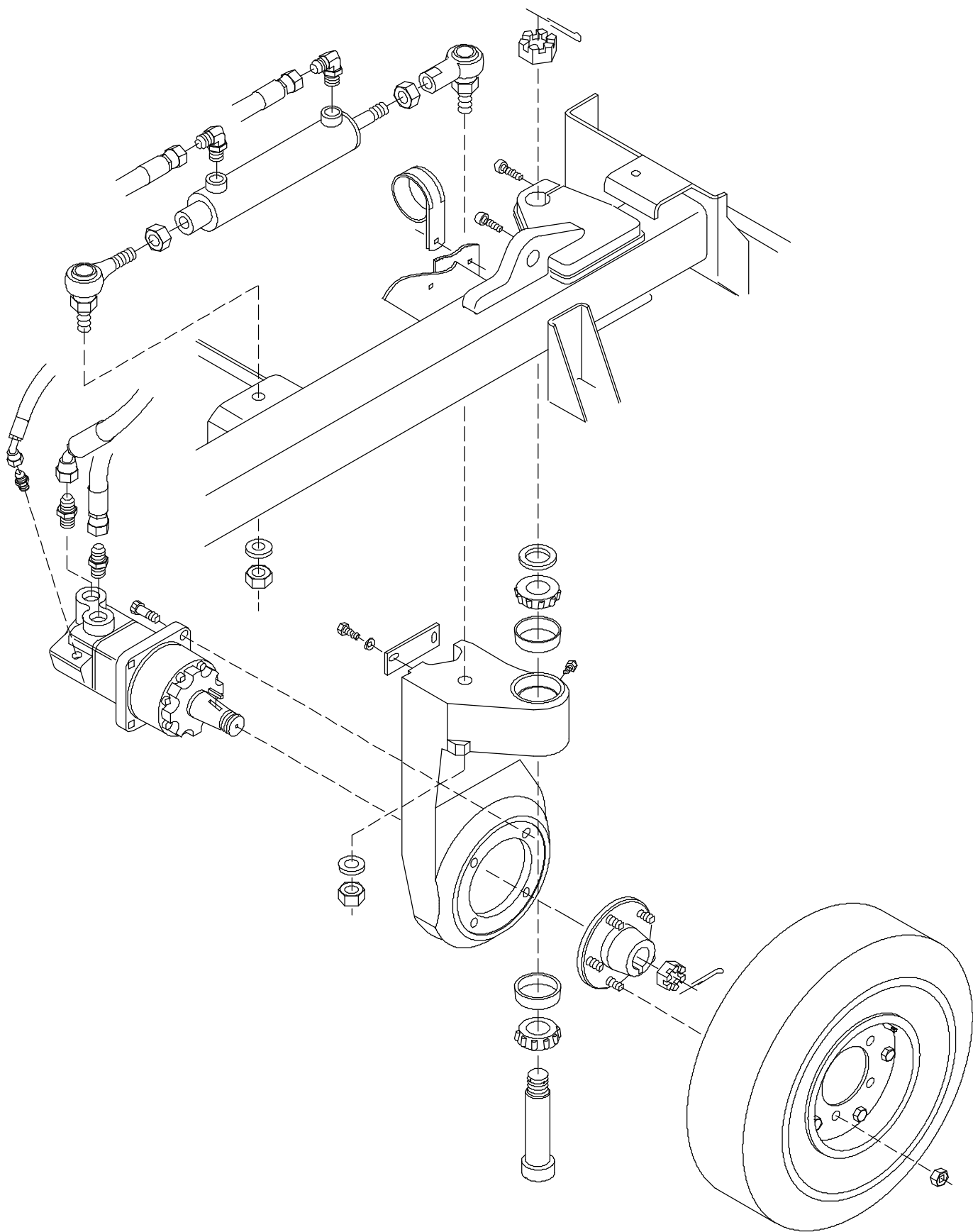
**FIG. 2 - Model 7400 Drive Assembly**



**FIG. 3 - Model 8400/8410 Drive Assembly**



**FIG. 4 - Model 385 LH Drive Assembly**



**FIG. 5 - Model 385 Drive Assembly**





**BILL OF MATERIALS FOR REAR DRIVE HOUSING REPLACEMENT KIT 374565 (RH)**

| <b>Ref.</b> | <b>TENNANT<br/>Part No.</b> | <b>Description</b>             | <b>Qty.</b> |
|-------------|-----------------------------|--------------------------------|-------------|
| 1           | 374561                      | Rear drive housing support, RH | 1           |
| 2           | 374560                      | Rear drive grease cavity seal  | 1           |
| 3           | 374563                      | Flat washer 2.1 in. x 3.5 in.  | 1           |
| 4           | 47801                       | Grease fitting                 | 2           |

**BILL OF MATERIALS FOR REAR DRIVE HOUSING REPLACEMENT KIT 374566 (LH)**

| <b>Ref.</b> | <b>TENNANT<br/>Part No.</b> | <b>Description</b>             | <b>Qty.</b> |
|-------------|-----------------------------|--------------------------------|-------------|
| 1           | 374562                      | Rear drive housing support, LH | 1           |
| 2           | 374560                      | Rear drive grease cavity seal  | 1           |
| 3           | 374563                      | Flat washer 2.1 in. x 3.5 in.  | 1           |
| 4           | 47801                       | Grease fitting                 | 2           |

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