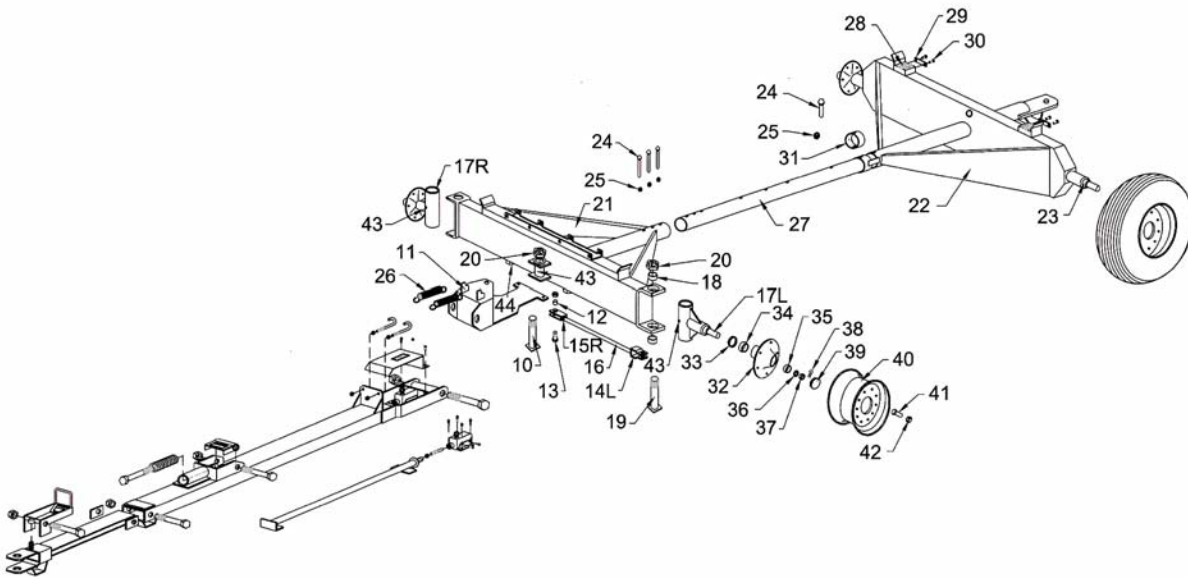


OPERATOR'S MANUAL

Set-Up Instructions and Parts Catalog for

Model 2494ST Running Gear



24 Ton Capacity

Short Turn Design
Four-Wheel Hydraulic Drum Brakes



J. & M. Manufacturing Co., Inc.
P.O. Box 547
Fort Recovery, OH 45846

Phone: (419) 375 2376 Fax: (419) 375-2708
E-mail: sales@jm-inc.com Website: www.jm-inc.com

REV-08-20-09

TO THE DEALER:

Read manual instructions and safety rules. Make sure all items on the Dealer's Pre-Delivery and Delivery Check Lists in the Operator's Manual are completed before releasing equipment to the owner.

The dealer must complete the Warranty Registration Card attached to the front inside cover of this manual and return to J. & M. Mfg. Co., Inc. at the address indicated on the card. **Warranty claims will be denied if the Warranty Registration Card has not been completed and returned.**

EXPRESS WARRANTY:

J. & M. Mfg. Co. Inc. warrants against defects in construction or materials for a period of ONE year. We reserve the right to inspect and decide whether material or construction was faulty or whether abuse or accident voids our guarantee.

Warranty service must be performed by a dealer or service center authorized by J. & M. Mfg. Co. Inc. to sell and/or service the type of product involved, which will use only new or remanufactured parts or components furnished by J. & M. Mfg. Co. Inc. Warranty service will be performed without charge to the purchaser for parts or labor based on the Warranty Labor Times schedule. Under no circumstance will allowable labor times extend beyond the maximum hours indicated in the Warranty Labor Times schedule for each warranty procedure. The purchaser will be responsible, however, for any service call and/or transportation of the product to and from the dealer or service center's place of business, for any premium charged for overtime labor requested by the purchaser, and for any service and/or maintenance not directly related to any defect covered under the warranty. Costs associated with equipment rental, product down time, or product disposal are not warrantable and will not be accepted under any circumstance.

Each warranty term begins on the date of product delivery to the purchaser. Under no circumstance will warranty be approved unless (i) the product warranty registration card (attached to the inside of the Operator's Manual) has been properly completed and submitted to the equipment manufacturer. This Warranty is effective only if the warranty registration card is returned within 30 days of purchase.

This warranty does not cover a component which fails, malfunctions or is damaged as a result of (i) improper modification or repair, (ii) accident, abuse or improper use, (iii) improper or insufficient maintenance, or (iv) normal wear or tear. This warranty does not cover products that are previously owned and extends solely to the original purchaser of the product. Should the original purchaser sell or otherwise transfer this product to a third party, this Warranty does not transfer to the third party purchaser in any way. J. & M. Mfg. Co. Inc. makes no warranty, express or implied, with respect to tires or other parts or accessories not manufactured by J. & M. Mfg. Co. Inc. Warranties for these items, if any, are provided separately by their respective manufacturers.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES OR CONDITIONS, EXPRESS, IMPLIED OR STATUTORY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.

In no event shall J. & M. Mfg. Co. Inc. be liable for special, direct, incidental or consequential damages of any kind. The exclusive remedy under this Warranty shall be repair or replacement of the defective component at J. & M. Mfg. Co. Inc.'s option. This is the entire agreement between J. & M. Mfg. Co. Inc. and the Owner about warranty and no J. & M. Mfg. Co. Inc. employee or dealer is authorized to make any additional warranty on behalf of J. & M. Mfg. Co. Inc.

The manufacturer reserves the right to make product design and material changes at any time without notice. They shall not incur any obligation or liability to incorporate such changes and improvements in products previously sold to any customer, nor shall they be obligated or liable for the replacement of previously sold products with products or parts incorporating such changes.

SERVICE:

The equipment you have purchased has been carefully manufactured to provide dependable and satisfactory use. Like all mechanical products, it will require cleaning and upkeep. Lubricate the unit as specified. Observe all safety information in this manual and safety signs on the equipment.

For service, your authorized J. & M. dealer has trained mechanics, genuine J. & M. service parts, and the necessary tools and equipment to handle all your needs.

Use only genuine J. & M. service parts. Substitute parts may void the warranty and may not meet standards required for safe and satisfactory operation. Record the model number and serial number of your equipment in the spaces provided:

Serial # _____ Purchase Date: _____ Purchased From: _____

Please provide this information to your dealer to obtain the correct parts:

MODEL 2494ST - 24 TON RUNNING GEAR Specifications

Capacity	24 Ton
Weight (with tires)	2,800 lbs.
Width (c/c of tires)	92"
Spindle Size	3 3/8" diameter (sleeved)
Spring Balance Tongue	Dual Spring
Ground Height (to top of axle)	26"
Rocking Bolster	Built-In Rear
Tongue, Adj. Quick Hitch	Standard
Adjustable Center Pole	Standard
Pull Through Rear Hitch	Standard
Hydraulic Brake System	Four Wheel Drum
Wheels – 10 Bolt	22.5 x 13





GENERAL INFORMATION

TO THE OWNER:

The purpose of this manual is to assist you in operating and maintaining your running gear in a safe manner. Read it carefully. It furnishes information and instructions that will help you achieve years of dependable performance and help maintain safe operating conditions. If this machine is used by an employee or is loaned or rented, make certain that the operator(s), prior to operating:

1. Is instructed in safe and proper use.
2. Reviews and understands the manual(s) pertaining to this machine.

Throughout this manual, the term **IMPORTANT** is used to indicate that failure to observe can cause damage to equipment. The terms **CAUTION**, **WARNING** and **DANGER** are used in conjunction with the Safety-Alert Symbol, (a triangle with an exclamation mark), to indicate the degree of hazard for items of personal safety. When you see this symbol, carefully read the message that follows and be alert to the possibility of personal injury or death.

	This Safety-Alert symbol indicates a hazard and means ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!
	Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury.
	Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury, and includes hazards that are exposed when guards are removed.
	Indicates a potentially hazardous situation that, if not avoided, may result in minor or moderate injury.
IMPORTANT	Indicates that failure to observe can cause damage to equipment.
NOTE	Indicates helpful information.

GENERAL INFORMATION (continued)

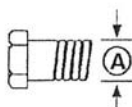
BOLT TORQUE CHART

Always tighten hardware to these values unless a different torque or tightening procedure is listed for a specific application.


Fasteners must always be replaced with the same grade as specified in the manual parts list.

Always use the proper tool for tightening hardware. SAE for SAE hardware and Metric for metric hardware.

Make sure fastener threads are clean and you start the thread engagement properly. All torque values are given to specification used on hardware defined by SAE J1701 & J1701M (Jul 96).




SAE SERIES TORQUE CHART




SAE Bolt Head Identification

SAE Grade 2 (No Dashes)

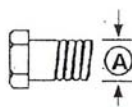


SAE Grade 5 (3 Radial Dashes)




SAE Grade 8 (6 Radial Dashes)

Diameter (Inches) ^(A)	Wrench Size	MARKING ON HEAD					
		SAE 2		SAE 5		SAE 8	
		Lbs.-Ft.	N-m	Lbs.-Ft.	N-m	Lbs.-Ft.	N-m
1/4	7/16"	6	8	10	13	14	18
5/16	1/2"	12	17	19	26	27	37
3/8	9/16"	23	31	35	47	49	67
7/16	5/8"	36	48	55	75	78	106
1/2	3/4"	55	75	85	115	120	163
9/16	13/16"	78	106	121	164	171	232
5/8	15/16"	110	149	170	230	240	325
3/4	1-1/8"	192	261	297	403	420	569
7/8	1-5/16"	306	416	474	642	669	907
1	1-1/2"	467	634	722	979	1020	1383




METRIC SERIES TORQUE CHART



Metric Bolt Head Identification

Metric Grade 8.8



Metric Grade 10.9

Diameter & Thread Pitch (Millimeters) ^(A)	Wrench Size	COARSE THREAD				FINE THREAD				Diameter & Thread Pitch (Millimeters) ^(A)
		MARKING ON HEAD								
		Metric 8.8		Metric 10.9		Metric 8.8		Metric 10.9		
		N-m	Lbs.-Ft.	N-m	Lbs.-Ft.	N-m	Lbs.-Ft.	N-m	Lbs.-Ft.	
6 x 1.0	10 mm	8	6	11	8	8	6	11	8	6 x 1.0
8 x 1.25	13 mm	20	15	27	20	21	16	29	22	8 x 1.0
10 x 1.5	16 mm	39	29	54	40	41	30	57	42	10 x 1.25
12 x 1.75	18 mm	68	50	94	70	75	55	103	76	12 x 1.25
14 x 2.0	21 mm	109	80	151	111	118	87	163	120	14 x 1.5
16 x 2.0	24 mm	169	125	234	173	181	133	250	184	16 x 1.5
18 x 2.5	27 mm	234	172	323	239	263	194	363	268	18 x 1.5
20 x 2.5	30 mm	330	244	457	337	367	270	507	374	20 x 1.5
22 x 2.5	34 mm	451	332	623	460	495	365	684	505	22 x 1.5
24 x 3.0	36 mm	571	421	790	583	623	459	861	635	24 x 2.0
30 x 3.0	46 mm	1175	867	1626	1199	1258	928	1740	1283	30 x 2.0

TABLE OF CONTENTS

INTRODUCTION	2
EXPRESS WARRANTY	2
SPECIFICATIONS	3
GENERAL INFORMATION	3
BOLT TORQUE CHART	4
SAFETY RULES	6
SAFETY SIGNS	7
SET-UP INSTRUCTIONS	7-8
OPERATING INSTRUCTIONS / MAINTENANCE	9-10
PARTS LIST / DIAGRAM	11
OPTIONAL HYDRAULIC DRUM BRAKES	12-13
OPTIONAL FENDER KIT	14
SERVICE RECORDS	15

SAFETY RULES

ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED!

Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be erased by an operator's single careless act. In addition, hazard control and accident prevention are dependent upon the awareness, concern, judgment, and proper training of personnel involved in the operation, transport, maintenance and storage of equipment.

Make certain that the operator(s), prior to operating is instructed in safe and proper use and reviews and understands the manual(s) pertaining to this machine.

Read this manual before you operate this machine. If you do not understand any part of this manual, or need more information, contact the manufacturer or your authorized dealer.

SAFETY

Understand that your safety and the safety of other persons are measured by how you service, and operate this machine. Know the positions and functions of all controls before you try to operate them. Make sure to check all controls in a safe area before starting your work.

The safety information given in this manual does not replace safety codes, federal, state or local laws. Make certain your machine has the proper equipment as designated by local laws and regulations.

A frequent cause of personal injury or death is from persons falling off equipment and being run over. Do not permit persons to ride on this machine.

Travel speeds should be such that complete control and machine stability is maintained at all times. Where possible, avoid operating near ditches, embankments and holes. Reduce speed when turning, crossing slopes and rough, slick or muddy surfaces.

Collision of high speed road traffic and slow moving machines can cause personal injury or death. On roads, use flasher lights according to local laws. Keep slow-moving-vehicle emblem visible. Pull over to let faster traffic pass.

Never adjust, service, clean, or lubricate running gear until all power is shut off.

Keep all safety shields in place.

Keep hands, feet, hair and clothing away from moving parts while unit is in operation.

Make sure that everyone is clear of equipment before applying power or moving the machine.

Make sure that the implement is fastened securely to the tractor by using the proper hitch pin, clip and safety chains.

Never overload the running gear. Overloading the running gear is dangerous and can cause extensive damage.

Do NOT exceed speeds in excess of 20 MPH. Rim, hubs and bearings are designed for heavy loads at slow speeds. Also be sure slow moving vehicle emblem is attached to rear of wagon.

Before unhooking the implement from the towing unit, be sure to properly block the wheels to prevent the implement from moving.

SAFETY SIGNS

IMPORTANT: Install new safety signs if the old signs are destroyed, lost, painted over or cannot be read. When parts are replaced that have safety signs, make sure you install a new sign with each new part. New signs are available from the manufacturer or your authorized dealer.

DECAL PARTS LIST

Item #	Part #	Description
1	DC-111	Caution: Keep Lug Nuts Tight / Do Not Exceed Limit
2	DC-113	Caution: Check Fluid Level
3	DI-114M	J&M Oval - Medium

SET-UP INSTRUCTIONS

IMPORTANT: Set-up work to be performed by qualified servicemen only.

1. Mount tires on the wheels and inflate to 80 psi.
2. Mount the tires to the hubs and tighten the flat hub nuts to 500 ft. lb. torque. Check the hub nuts after the first hour of operation, then every 10 hours of operation for the first 40 hours of use. These nuts must be kept tight at all times. Wheels that are improperly installed on the running gear, resulting in product failure, will nullify the warranty and shift the burden of liability to the owner/operator of the equipment.
3. Slide the coupling pole through the rear A-Frame, inserting the collar to coupling pole and through the front A-Frame. When mounting to a 680SD or 760SD Gravity Wagon, the distance from the center of axle to center of axle is approximately 134".
4. Fasten the tongue to the front of the assembly using the tongue bolt (remove paint from the bolt before attaching) and the hex nut. Attach the tongue springs to the brackets on the tongue and hitch assembly.
5. Mount the brakes lines from the rear of the master cylinder to the Drum Brakes according to the Tongue Assembly and Brake Lines and Fittings drawing located in the Repair Parts Section of this manual. Be careful not to over tighten the fittings and strip the threads. Use care in shaping brake lines to avoid sharp bends or kinks. Be sure to use a "Double-Flaring" type of tool on steel tubing to assure tight leak proof connections. Be sure and use hydraulic rubber hoses at points of flexing. Anchor hose ends to avoid stress on tubing. Always use DOT 5 Silicone Brake Fluid or equivalent.

SET-UP INSTRUCTIONS (continued)

IMPORTANT: Set-up work to be performed by qualified servicemen only.

6. Adding Brake Fluid to the Master Cylinder. **IMPORTANT:** Do NOT shake the brake fluid container. AVOID agitating the system when bleeding. Do NOT “pump” the brake plunger. Instead, depress and release slowly.

Fill the master cylinder carefully, pouring the fluid down the side of the reservoir to minimize air entrainment.

METHOD ONE (requires two people)

Close all bleed screws.

Start with the wheel furthest from the master cylinder. Slip a transparent bleed hose on the bleeder stem and place the other end of the hose in a clean container which is partially filled with fluid at all times.

The first person depresses the brake plunger SLOWLY (take 3-5 seconds). THEN the second person opens the bleed screw. He then closes the bleed screw BEFORE the first person SLOWLY releases the plunger (3-5 seconds). Continue until there is no evidence of air in the bleed hose. Continue with remaining wheels working from the longest to the shortest distance from the master cylinder. Top off master cylinder as needed to prevent reintroducing air into the lines.

REMEMBER:

- 1) Depress plunger slowly
- 2) Open bleed screw
- 3) Close bleed screw
- 4) Release plunger slowly

METHOD TWO (one person)

Attach bleed hose to rear wheel as in method one. Open bleed screw. SLOWLY depress plunger (3-5 seconds). Repeat until line is air free. Close bleed screw. Top off master cylinder as needed to prevent reintroducing air into the lines.

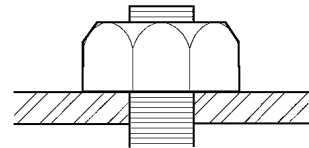
Repeat with remaining wheel.

Contamination with dirt, water, petroleum products or other materials may result in brake failure or costly repairs.

8) **IMPORTANT:** Make sure to properly attach the gravity box (or other equipment) to the running gear. Bolt all four corners of the gravity box to the running gear. If the box is used in rough terrain and it is not equipped with a rocking bolster, bolt a minimum of two corners and chain (or cable) the remaining two corners to allow more box flexibility.

MOUNTING WHEELS

The adjacent diagram shows the proper way to mount wheels with straight holes (22.5x13 wheels). Use flange wheel nut (valve stem is on the outward side of the tire). Wheels that are improperly installed on running gears, resulting in product failure, will nullify warranty and shift the burden of liability to the owner/operator of the equipment.



OPERATION INSTRUCTIONS // MAINTENANCE

WARNING - BE CERTAIN THAT ALL POWER IS SHUT OFF BEFORE SERVICING EQUIPMENT.

Before equipment is put into service:

Has this manual and the operator's manual of the gravity box been read and clearly understood by the operator(s) of this machine?

Have all braces, bolts, nuts, lug bolts and lug nuts been checked to ensure that they are properly fastened?

Is the running gear properly fastened to the tractor? Use a good quality hitch pin with clip and safety chains.

SAFETY CHAIN USER INSTRUCTIONS

- a) Secure the safety chain by looping it around the tongue support located on the underside of the outer tongue. Extend the chain through the support located on the underside of the inner tongue and connect to the towing machine's attaching bar.
- b) Be sure to run the safety chain through the support on the underside of the inner tongue. This will provide an intermediate support for the safety chain.
- c) Do NOT allow more slack than necessary for articulation (max. 9 inches).
- d) Do NOT use any intermediate support as the attaching point.
- e) Store the safety chain by securing it around the tongue supports.
- f) Replace the safety chain if one or more links or end fittings are broken, stretched or otherwise damaged or deformed.

Have all danger, warning, caution and important signs on the equipment been read and clearly understood? If employees or other use or are near this equipment, make sure they also have read and understood all danger, warning, caution and important signs on the equipment and have also read the operator's manual.

Have the wheel bearings been inspected? Repack with grease if needed. Grease both the tongue bolt and the hitch bolt.

BRAKING SYSTEM REQUIREMENTS:

WARNING - Tow Loads Safely

Stopping distance increases with speed and weight of towed loads, and on slopes. Towed loads with or without brakes that are too heavy for the tractor or are too fast can cause loss of control. Consider the total weight of the equipment and its load.

Observe these recommended maximum road speed, or local speed limits which may be slower:

- If towed equipment DOES NOT have brakes, do not travel more than 32 km/hr (20 mph) and do not tow loads more than 1.5 times the tractor weight.
- If towed equipment DOES have brakes, do not travel more than 40 km/hr (25 mph) and do not tow loads more than 4.5 times the tractor weight.

Ensure the load does not exceed the recommended weight ratio. Use additional caution when towing loads under adverse conditions, when turning and on inclines.

OPERATION INSTRUCTIONS / MAINTENANCE (continued)

IMPORTANT:

Keep the tires properly inflated (approx. 80 psi). Both under and over inflation can greatly reduce tire life.

Inspect bracing and welds and repair if needed. Failure to repair could cause extensive damage and greatly reduce the life of the unit.

Inspect tie rods and replace the bronze bushings in the steering assembly when needed.

Repack the bearings in the hub assemblies once a year or as needed. Use a good quality bearing lubricant such as Bearing Gard MK1 or equivalent. NOTE: Grease zerks on hubs caps are for between scheduled service lubrication.

If equipped with brakes, inspect the drums periodically for wear and for brake line damage. Check fluid in the master cylinder and inspect for dirt or corrosion on the inside wall of the master cylinder. Clean and replace with new Silicone Brake Fluid (DOT 5) if needed. Wagons with brakes should be stored in a clean, dry place when not in use.

ADJUSTING THE DRUM BRAKES

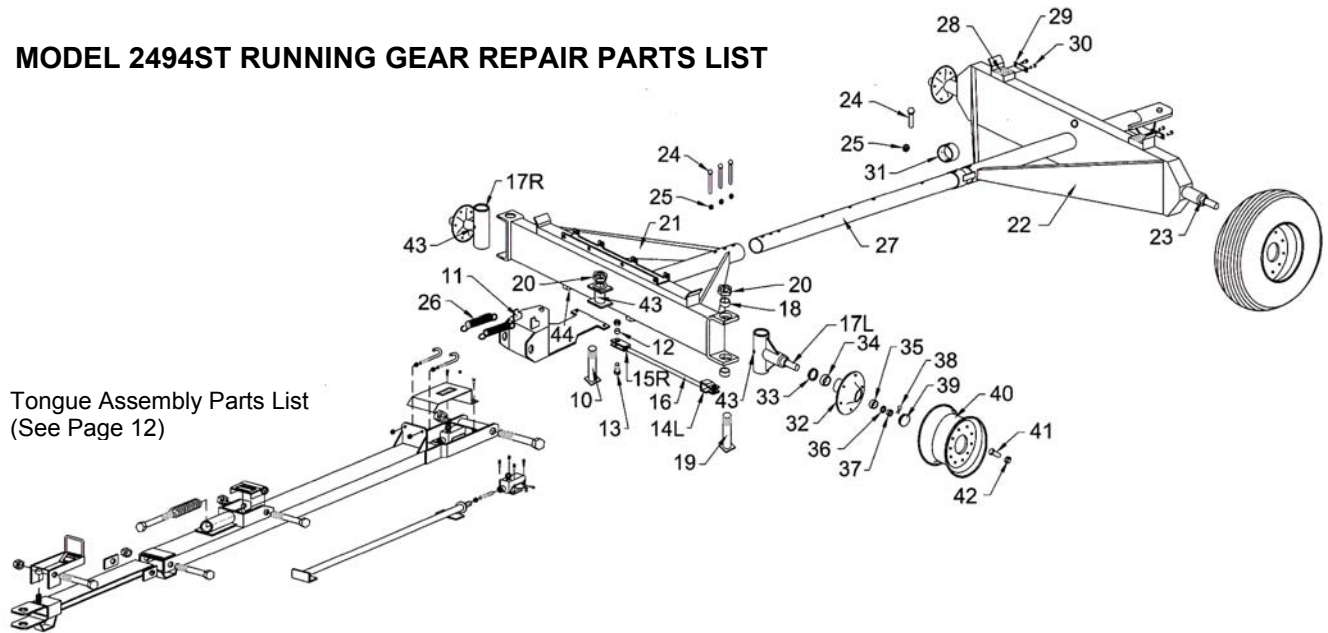
It is necessary to rotate the wheels in the direction of forward rotation only when making adjustments.

The brake adjustment nut is located behind a slot at the bottom of the backing plate. Tighten the nut until you cannot rotate the wheel by hand, then back off the adjustment 18 to 20 notches.

ROTATE THE DRUM IN THE DIRECTION OF FORWARD ROTATION ONLY

MODEL 2494ST RUNNING GEAR REPAIR PARTS LIST

Tongue Assembly Parts List
(See Page 12)

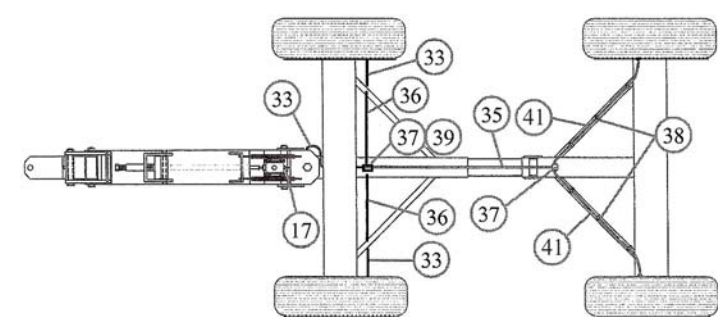
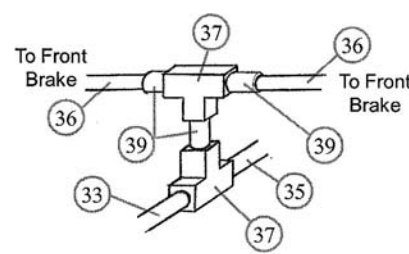
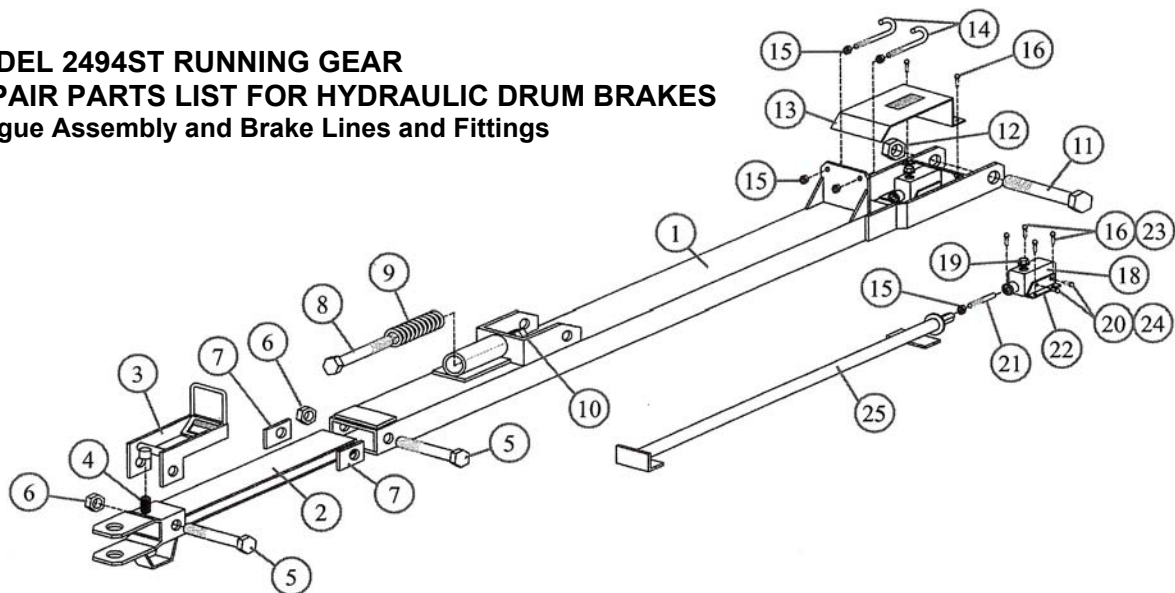


PARTS LIST

#	Part #	Description
10	HB-24	King Pin Hitch Bolt 1 3/4" x 10 1/2"
11	HW-24	Hitch Weldment
12	BB-78	7/8" ID Bronze Bushing
13	SB-78	7/8" Step Bolt with Nut
14L	TRE-114L	Tie Rod End, Left
14R	TRE-14R	Tie Rod End, Right
15L	HN-114L	1 1/4" Hex Nut, Left
15R	HN-114R	1 1/4" Hex Nut, Right
16	TR-24A	Tie Rod, 1 1/4" x 24" Long
17L	SA-24L	3 3/8" Spindle & Spool Assembly, Left
17R	SA-24R	3 3/8" Spindle & Spool Assembly, Right
18	EB-134	1 3/4" ID End Spindle Bushing
19	SPB-134	1 3/4" Rd CR x 13 1/2" Bolt
20	HN-134	1 3/4" Hex Nut
21	FA-24	Front Axle Weldment (A-Frame Only)
21	FA-24C	Running Gear, Front Only, Less Brakes, Tongue, Hose, Piping, Pole
21	FA-24CDR	Running Gear, Front Only, WITH DRUM BRAKES, Less Tongue, Hose, Piping, Pole
22	RA-24DR	Running Gear, Rear Only WITH DRUM BRAKES, Less Rims, Hose, Rocking Bolster

#	Part #	Description
23	SS-33816	3 3/8" x 16" Straight Spindle
24	MB-1634	1" x 6 3/4" Bolt
25	1LN	1" Lock Nut
26	TS-615H	Large Tongue Spring
27	CP-24ST	Coupling Pole with Rear Hitch
28	212314-RP	2 1/2" x 3 1/4" Rubber Plate
29	14114312-P	1/4" x 1 1/4" x 3 1/2" Plate
30	381-FB	3/8" x 1" Flange Bolt
31	HCL-412	4 1/2" OD Collar
32	W-871B	873 Hub (faced) w/studs & nuts
33	CR-33772	Seal (4 5/8" OD)
34	4T-33275	Large Bearing
35	4T-460	Small Bearing
36	913632	Spindle Washer
37	912969	Slotted Spindle Nut
38	905944	Cotter Pin
39	909983	Dust Cap
40	WR22.5-13	Wheel, 22.5x13, 10 Bolt
41	913564	Wheel Stud, 3/4"-16
42	913571	Wheel Nuts, 3/4"-16
43	1633	Grease Fitting
44	583G8B	5/8" x 3" Grade 8 Bolt
45	58-RN	5/8" Regular Nut (not shown)
51	910397	Inner Cup (large) (not shown)
52	910332	Outer Cup (small) (not shown)

**MODEL 2494ST RUNNING GEAR
REPAIR PARTS LIST FOR HYDRAULIC DRUM BRAKES
Tongue Assembly and Brake Lines and Fittings**



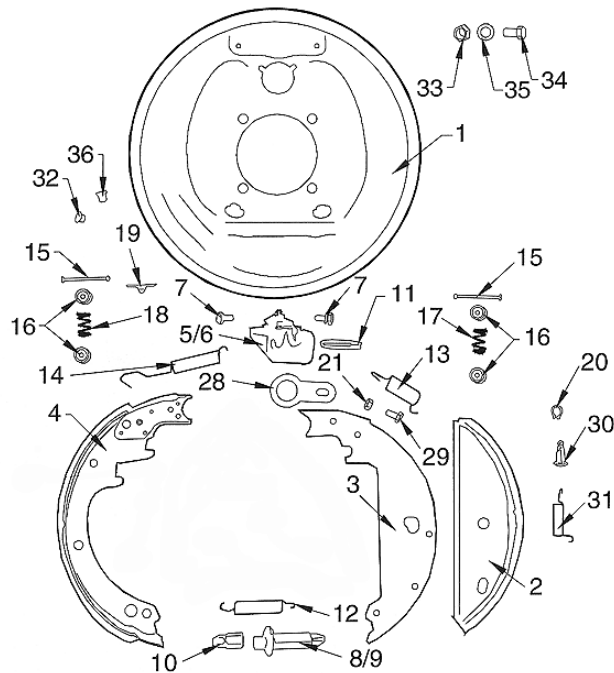
Front Brake Line Assembly

PARTS LIST

#	Part #	Description
1	OTW-24ST	Outer Tongue Weldment
2	ITW-1324	Inner Tongue Weldment
3	TL-1324	Tongue Latch
4	SS-615NS	Small Spring In Latch
5	17G2B	1" x 7" Grade 2 Bolt
6	1LN	1" Lock Nut
7	BL-58	Brake Limiter
8	19G8B	1" x 9" Grade 8 Bolt
9	CS-178714	Compression Spring
10	1RN	1" Regular Nut
11	TB-1215	Tongue Bolt
12	HN-114	1 1/4" Hex Nut
13	SMC-1	Shield for Master Cylinder
14	124-JB	1/2" x 4" J-Bolt
15	12-N	1/2" Regular Nut
16	381-FB	3/8" x 1" Flange Bolt
17	FMC-1324	Fitting for Master Cylinder
18	MCA-DR1	Master Cylinder Assembly
19	RMCM-1324	Replacement Cap (M/Cylinder)
20	383G8B	3/8" x 3" Grade 8 Bolt

#	Part #	Description
21	PRE-1	Plunger Rod End
22	MBMC-DR2	Mounting Bracket (2 pcs) (M/C)
23	38-FN	3/8" Flange Nut
24	38-LN	3/8" Lock Nut
25	PP-1DST	Plunger Pole
26	RB-1415	Rubber Boot on M/Cylinder
27	GR-1415	Rubber Grommet
28	SKMC-1324	Seal Kit for Master Cylinder
29	DOT5-BF	Container COT 5 Brake Fluid
31	W-871B	Hub, Faced for Brakes
32	BS-24	Bleeder Stem
33	HH-1424	1/4" x 24" Hydraulic Hose
35	ST-120	3/16" Brake Line x 120"
36	ST-30	3/16" Brake Line x 30"
37	10606	Tee
38	CT-1	Cable Tie
39	10606-X	Tee Extension
40	RB-1415	Rubber Boot on Master Cylinder
41	ST-53	3/16" Brake Line x 53"

MODEL 2494ST RUNNING GEAR REPAIR PARTS LIST FOR HYDRAULIC DRUM BRAKES
Drum Brake Assembly



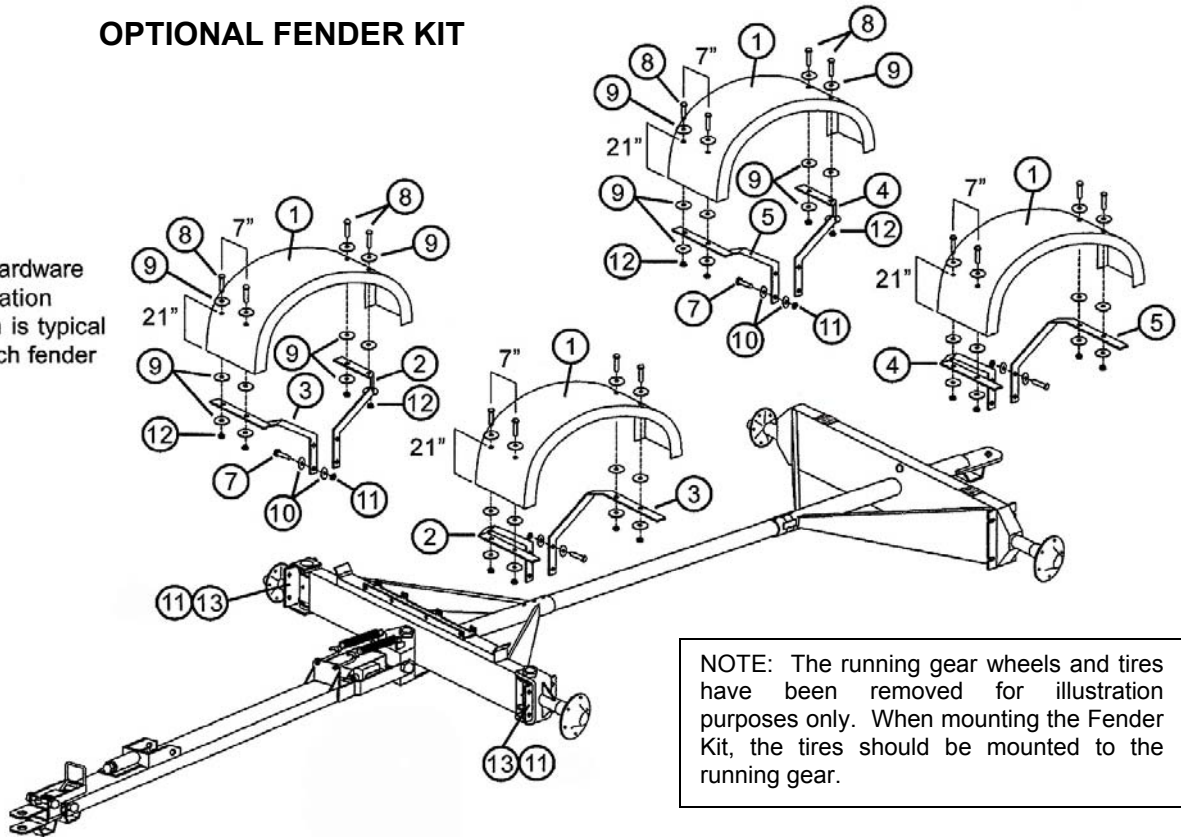
PARTS LIST

#	Part #	Description
1	24737	Back Plate Assembly
2	9739	Front Brake Shoe Assembly
3	9745	Front Shoe Lever
4	9775	Rear Shoe Lever
5	9776	Wheel Cylinder Assembly – Right
6	9777	Wheel Cylinder Assembly – Left
7	23457	Screw & Lockwasher
8	23324	Adjusting Screw
9	23324PN	Pivot Nut
10	9782	Socket – Adjusting Screw
11	9783	Push Rod – Wheel Cylinder
12	9784	Spring Adjusting Screw (Yellow)
13	9785	Spring – Front Lever (Red)
14	9786	Spring – Rear Shoe (Orange)
15	9788	Pin – Shoe Hold Down
16	9789	Cup – Shoe Hold Down
17	9790	Spring – Front Hold Down (Yellow)
18	9791	Spring – Rear Hold Down (Black)
19	9254	Cover Plate – Adjusting Hole
20	7778	Retaining Ring

#	Part #	Description
21	17406	Hex – Locknut 5/16" NC
28	9743	Travel Link
29	7949	Travel Link Bolt – Hex Cap Screw 5/16" NC x 5/8"
30	12560	Front Shoe Pin w/o Park Link
31	6814	Spring – Front Shoe
32	9797	Plug – Plastic
33	7972	Hex Nut 1/2" NF
34	7955	Cap Screw 1/2" NF x 1"
35	7937	Lockwasher 1/2"
36	9404	Plug – Plastic
39	15845	Wheel Cylinder Repair Kit 1 1/8"
40	DRBA-L	Drum Brake Cluster Assy (left)
40	DRBA-R	Drum Brake Cluster Assy (right)
41	24DB	13" Brake Drum (6" pilot)

OPTIONAL FENDER KIT

The hardware installation shown is typical for each fender



Installation Instructions

Step One – Loosely fasten each set of front and rear Fender Brackets to the mounting plate located on the front and rear spindle assemblies using four 1/2" x 2 1/2" grade 5 bolts, eight 1/2" regular washers and four 1/2" flange nuts. Do Not Tighten the brackets.

Step Two – Mark and drill two 9/16" diameter holes on the front and rear ends of the fender. To properly seat the fender over the tire, the holes should be evenly spaced along the width of the fender, located 7" apart and 21" from the bottom edge.

Step Three – Secure each fender to the mounting brackets using four 1/2" x 1 1/2" grade 5 bolts, twelve 1/2" oversized washers and four 1/2" regular nuts. The head of the bolt should be placed on the top side of the fender with one oversized washer on each side of the fender and another oversized washer on the bottom side of the mounting bracket. Do Not Tighten.

Step Four – Adjust the fender to ensure it is properly located around the tire. Tighten the mounting brackets to the spindle assemblies and the fenders to the mounting brackets.

PARTS LIST

#	Part #	Description	Qty
1	PF-4	Plastic Fender	4
2	FMB-24A	Fender Mounting Bracket	2
3	FMB-24B	Fender Mounting Bracket	2
4	FMB-24C	Fender Mounting Bracket	2
5	FMB-24D	Fender Mounting Bracket	2
6	-----	-----	----
7	12212G5B	1/2" x 2 1/2" Grade 5 Bolt	16
8	12112G5B	1/2" x 1 1/2" Grade 5 Bolt	16
9	12OSW	1/2" Oversized Washer	48

#	Part #	Description	Qty
10	12RW	1/2" Regular Washer	54
11	12FN	1/2" Flange Nut	16
12	12RN	1/2" Regular Nut	16

