

without dislodging any of the balls. Stick the other group of balls to the race machined into upper side of steering cam, then position upper race (3) over the balls and into bore of gear housing. Install thrust washer (4), then install steering column (2) using the removed shim pack (3) or one of equal thickness. Install and

tighten the retaining cap screws. Steering shaft bearings should be adjusted to zero end play without binding. Bearings are adjusted by adding or removing shims (3) which are available in thicknesses of 0.002, 0.005 and 0.010.

Complete the assembly by installing pitman shaft (10) with actuating pin

in center of cam, then installing pitman arm (17) with drag link attaching pole pointing downward. Fill steering gear housing with $\frac{1}{2}$ -pint of SAE 90 gear oil. Level is correct when lubricant is within one inch of filler plug (13). Adjust the assembled unit as outlined in paragraph 4 and install as in paragraph 5.

ENGINE AND COMPONENTS

All models are equipped with a Perkins 4A, 107 four cylinder diesel engine having a bore of 3 $\frac{1}{4}$ -inches, a stroke of 3 $\frac{1}{2}$ -inches and a piston displacement of 107 cubic inches. Compression ratio is 22.5:1 and fuel is injected into a pre-combustion chamber located in cylinder head.

On Model MF25, the engine is carried in a separate frame and a formed steel engine adapter plate and oil pan are used. Model MF130 uses a heavy cast engine adapter plate and cast iron oil pan which serves as part of the tractor frame.

R&R ENGINE WITH CLUTCH

Model MF25

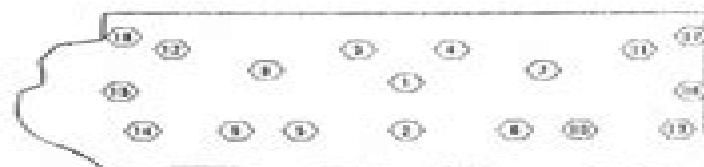
7. To remove engine and clutch as a unit, first drain cooling system and if engine is to be disassembled, drain oil pan.

Remove the hood and battery, shut off fuel and remove fuel tank. Disconnect heat indicator sending unit from cylinder head and oil pressure gage tube from elbow in engine block. Disconnect wiring, tachometer cable and throttle linkage. Remove oil cooler lines and disconnect steering drag link. Place suitable wooden wedges between front axle and support to prevent engine from tilting, support both halves of tractor separately and separate the tractor at clutch housing.

Swing the engine in a hoist, disconnect radiator hoses and air cleaner hose, remove the mounting bolts and lift engine from front frame.

Install by reversing the removal procedure, leaving engine front mounting bolts loose until after engine is reconnected to clutch housing. Bleed fuel system as outlined in paragraph 36 after tractor is reassembled.

Fig. 6—When installing the cylinder head, tighten stud nuts to a torque of 40-42 ft.-lbs. using the sequence shown.



Model MF130

8. To remove engine and clutch as a unit, first drain cooling system and if engine is to be disassembled, drain oil pan.

Remove hood and battery, shut off fuel and remove fuel tank. Disconnect radiator hoses and air cleaner hose. Remove oil cooler lines and disconnect steering drag link. Support tractor underneath clutch housing and unbolt and remove front axle, front support and radiator as a unit.

Disconnect wiring harness, throttle linkage and oil gage line. Swing engine in a hoist and unbolt engine from clutch housing.

Install by reversing the removal procedure. Bleed fuel system after engine is installed, as outlined in paragraph 36.

CYLINDER HEAD

All Models

9. REMOVE AND REINSTALL. To remove the cylinder head, drain cooling system and remove hood. Shut off the fuel and remove fuel tank. Loosen the rocker arm cover breather tube clamp and remove rocker arm cover. Remove the intake and exhaust manifolds and disconnect upper radiator hose. Remove heat indicator sending unit from cylinder head on older models or disconnect gage wire on late models.

Remove rocker arms assembly and push rods. Disconnect high pressure lines and leak off line from injectors. Remove the battery and the four bolts securing steering gear housing to clutch housing. Loosen the two top stud nuts on clutch housing bolt circle. Disconnect the oil pressure gage line and remaining lines to fuel filter, tip steering gear housing rearward at top until battery carrier clears cylinder head and block the gear housing securely. Remove the cylinder head retaining stud nuts and lift off cylinder head.

NOTE: Cylinder sleeves are a relatively loose fit in engine block and may rise with piston if crankshaft is turned. Secure the sleeves with flat washers, pipe spacers and two stud nuts before turning crankshaft with head removed.

Head gasket is marked "FRONT" for proper installation. Stud holes will not align if gasket is turned upside down. Coat both sides of gasket with aviation grade Permatex when head is installed. Tighten cylinder head stud nuts to a torque of 40-42 ft.-lbs. using the sequence shown in Fig. 6. The five long stud nuts should be installed on studs between the injectors in positions marked 2, 5, 6, 9 and 10 in tightening sequence. Reinstall push rods and rocker arms assembly, making sure that rocker shaft oil supply

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