



**Tilt Steering Kit**  
**RT1200 Traction Unit**  
Model No. 25497  
Model No. 25497E

Form No. 3398-100 Rev A

**Installation Instructions**

# Installation

## ⚠ WARNING

### CALIFORNIA Proposition 65 Warning

This product contains a chemical or chemicals known to the State of California to cause cancer, birth defects, or reproductive harm.

# 1

## Preparing to Install the Tilt-Steering Column

### No Parts Required

### Procedure

1. Move the machine to a level surface.  
**Note:** Ensure that the front wheels of the machine are straight.
2. Set the parking brake, shut off the engine, and remove the key from the key switch.
3. Remove the right panel; refer to the *Operator's Manual*.
4. Rotate the battery-disconnect switch to the OFF position; refer to the *Operator's Manual*.

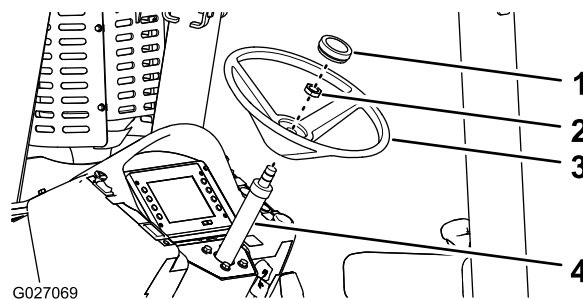
# 2

## Removing the Steering Wheel

### No Parts Required

### Procedure

1. Pry the cover out from the hub of the steering wheel (Figure 1).



**Figure 1**

- |                     |                          |
|---------------------|--------------------------|
| 1. Cover            | 3. Steering wheel        |
| 2. Nut (13/16 inch) | 4. Fixed-steering column |

2. Remove the nut (13/16 inch) that secures the steering wheel to the fixed-steering column (Figure 1).
3. Remove the steering wheel by pulling it away from the column (Figure 1).



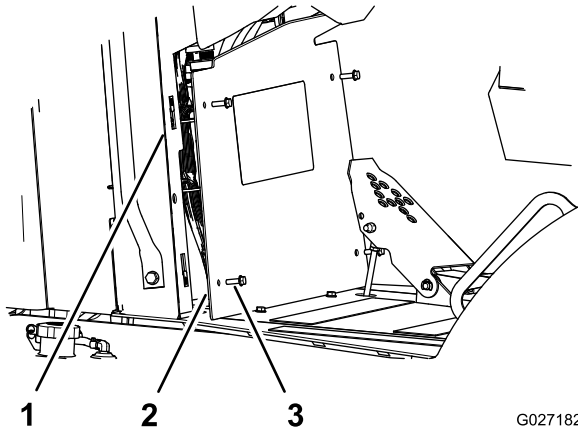
# 3

## Removing the Fixed-Steering Column

### No Parts Required

### Procedure

1. Remove the 4 hex-flanged bolts (5/16 x 1 inch) that secure the kick panel to the console (Figure 2).

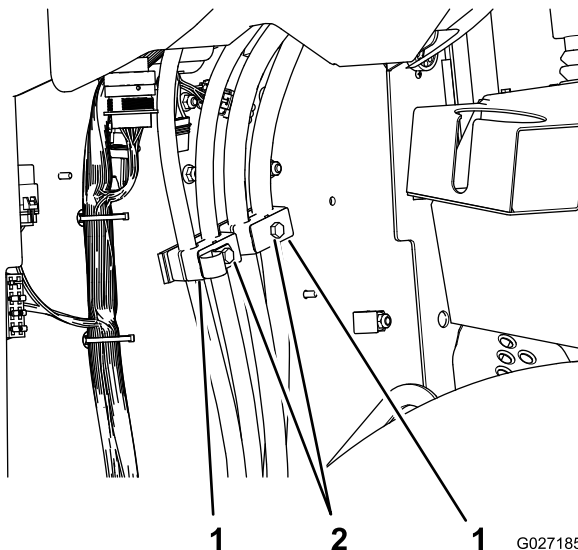


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Figure 2

1. Clip nut (console)
2. Kick panel
3. Hex-flanged bolts (5/16 x 1 inch)

2. Loosen the 2 bolts (5/16 x 1-3/4 inch) and 4 clamp blocks that secure the steering-valve hoses to the console (Figure 3).



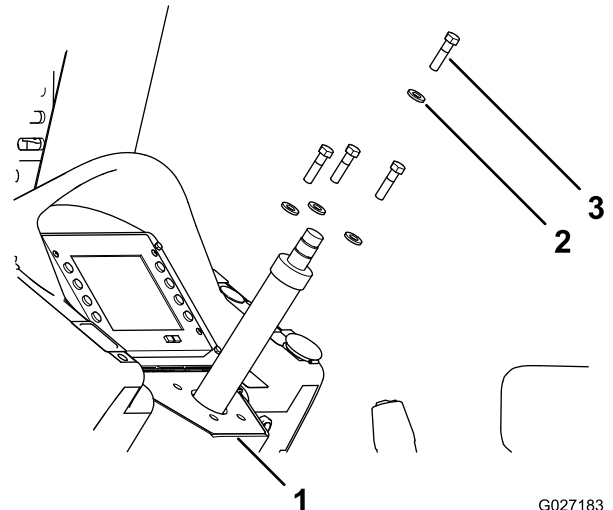
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Figure 3

1. Clamp blocks
2. Bolts (5/16 x 1-3/4 inch)

3. Remove the 4 bolts (3/8 x 1-1/2 inch) and 4 washers (3/8 inch) that secure the fixed-steering column and the steering valve to the steering support (Figure 4).

**Note:** Do not discard the washers.

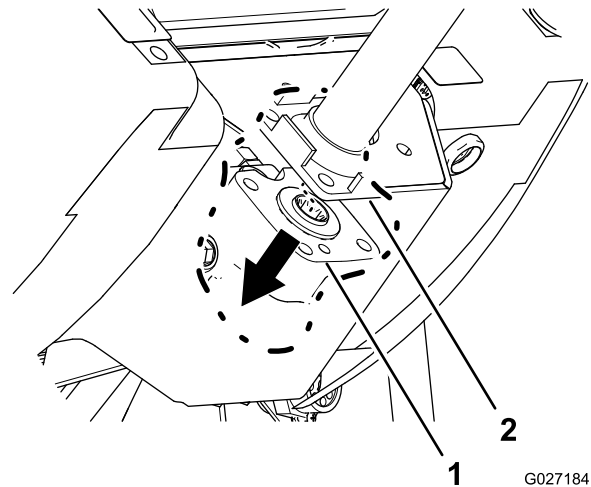


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Figure 4

1. Steering support
2. Washer (3/8 inch)
3. Bolt (3/8 x 1-1/2 inch)

4. Separate the mounting flange of the fixed-steering column from the steering valve (Figure 5).

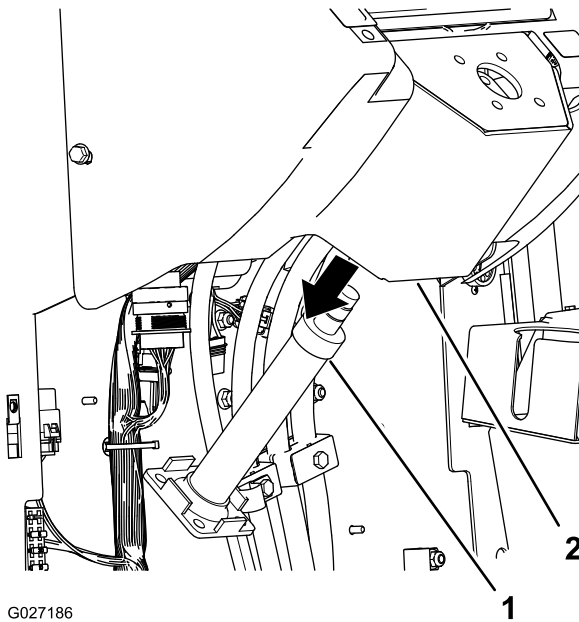


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Figure 5

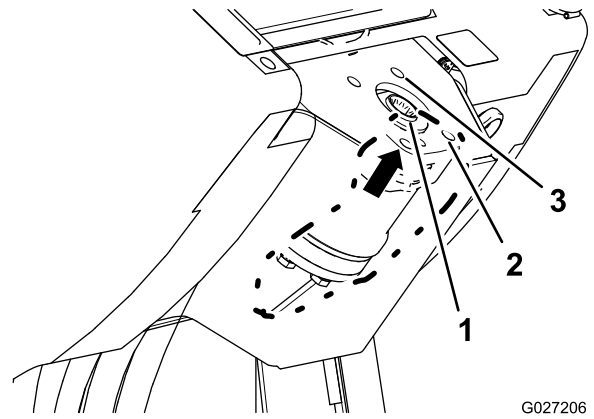
1. Steering valve
2. Mounting flange (fixed steering column)

5. Move the steering valve forward and to the side to provide clearance for removing the fixed-steering column.
6. Move the fixed-steering column down and out from under the steering support and remove the fixed-steering column from the machine (Figure 6).



**Figure 6**

1. Steering support
2. Fixed-steering column



**Figure 7**

1. Hole (steering support)
2. Threaded hole (steering valve)
3. Spline socket (steering valve)

2. Align the tilt-steering column to the steering valve with the short-spline shaft down and the word PUSH that is embossed in the boot of the column rearward ([Figure 8](#)).

# 4

## Installing the Tilt-Steering Column

**Parts needed for this procedure:**

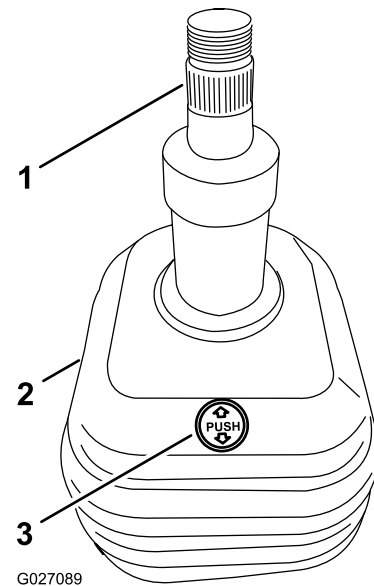
4	Bolts (3/8-16 x 1-1/4 inch)
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## Installing the Column

**Note:** Have another person help you install the tilt steering column.

1. Push the steering valve up and align the threaded holes in the steering valve with the holes in the steering support ([Figure 7](#)).

**Note:** Ensure that the top of the steering valve is flush with the bottom of the steering support.



**Figure 8**

1. Steering-wheel shaft
2. Boot
3. PUSH (embossed in the boot)

3. Align the short-spline shaft (at the flange end of the tilt-steering column) to the spline socket of the steering valve by turning the steering-wheel shaft of the column and insert the short-spline shaft ([Figure 9](#)).

**Note:** Ensure that the mounting flange of the tilt-steering column is flush to the top of the steering support.

# 5

## Installing the Steering Wheel

No Parts Required

### Procedure

1. Apply medium-grade, thread-locking compound to the threads of the steering-wheel shaft.
2. Align the spokes of the steering wheel (Figure 10).

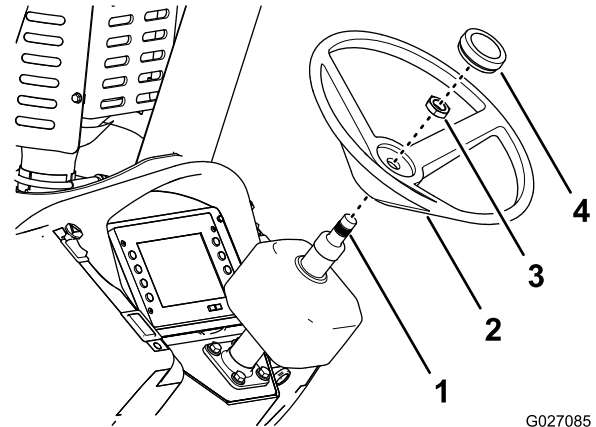


Figure 10

- |                         |                     |
|-------------------------|---------------------|
| 1. Steering-wheel shaft | 3. Nut (13/16 inch) |
| 2. Steering wheel       | 4. Cover            |

3. Align the splines of the steering wheel to the splines of the steering-wheel shaft of the tilt steering column (Figure 10).
4. Seat the steering wheel onto the tilt steering column (Figure 10).
5. Secure the wheel to the column (Figure 10) with the nut (13/16 inch) and torque the nut to 41 to 49 N-m (30 to 36 ft-lb).
6. Rotate the battery-disconnect switch to the ON position; refer to the *Operator's Manual*.
7. Install the right panel; refer to the *Operator's Manual*.

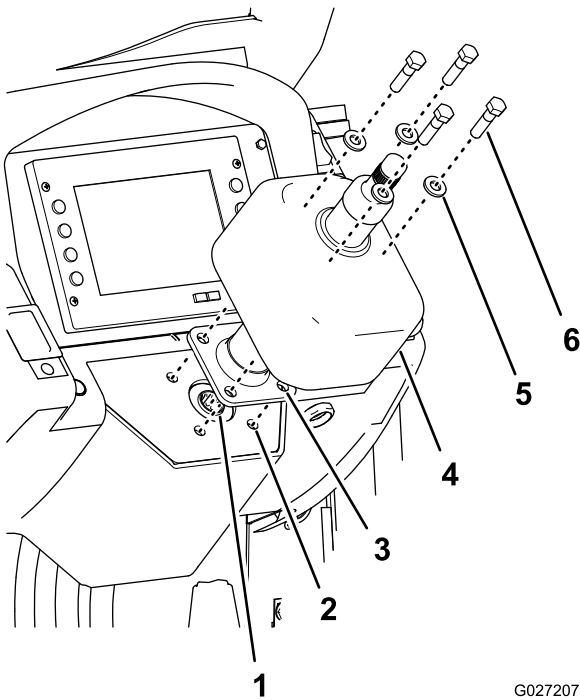


Figure 9

- |  |                               |
|--|-------------------------------|
| 1. Spline socket (steering valve)              | 4. Tilt-steering column       |
| 2. Hole (steering support)                     | 5. Washer (3/8 inch)          |
| 3. Hole (mounting flange—tilt-steering column) | 6. Bolt (3/8-16 x 1-1/4 inch) |

4. Align the holes in the mounting flange of the tilt-steering column, the holes in the steering support, and the threaded holes in the steering valve (Figure 9).
5. Apply medium-grade, thread-locking compound to the 4 bolts (3/8-16 x 1-1/4 inch).
6. Assemble the column, plate, and valve with the 4 bolts (3/8-16 x 1-1/4 inch) included in this kit and the 4 washers (3/8 inch), that were removed in step 3 of 3 Removing the Fixed-Steering Column (page 1), as shown in Figure 9.
7. Torque the bolts to 37 to 45 N-m (27 to 33 ft-lb).
8. Torque the clamp block bolts, that you loosened in step 2 of (page ), to 1978 to 2542 N-cm (175 to 225 in-lb).

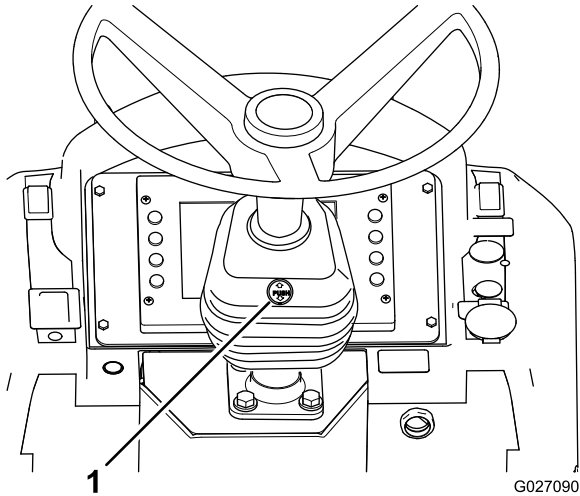
## Installing the Console Panel

1. Apply medium-grade, thread-locking compound to the 4 hex-flanged bolts (5/16 x 1 inch) that you removed in step 1 of (page ).
2. Align the holes in the kick panel with the clip nuts at the console (Figure 2).
3. Assemble the panel to the console with the 4 hex-flanged bolts (Figure 2).
4. Torque the flanged-head bolts to 1978 to 2542 N-cm (175 to 225 in-lb).

# Operation

## Adjusting the Tilt Steering Column

1. Stop the machine and set the parking brake.
2. Hold the steering wheel with 1 hand.
3. Press the latch mechanism (located under the word PUSH that is embossed in the boot of the steering column) until the column unlocks ([Figure 11](#)).



**Figure 11**

1. Latch mechanism—PUSH(embossed in the boot)

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4. Move the steering wheel to the desired position.
  5. Release the latch mechanism and ensure that the steering column is locked in position ([Figure 11](#)).

**Notes:**

**Notes:**



**Count on it.**