

Models: 13A-214F710 (LT2138), 13A-254G710 (LT2180), **13A-254G712 (LT2180)**,
13A-298L710 (GT2186-44), 13A-298M710 (GT2186-48)

Serial Number: Tractors built between December 11, 2003 (Date code L113...) through
January 16, 2004 (Date code A164...)

Date: January 20, 2004 **Revised January 23, 2004**

Subject: TRANSMISSION GEAR REPLACEMENT

PLEASE GIVE THIS YOUR IMMEDIATE ATTENTION

DO NOT SELL UNTIL REPAIRS COMPLETED ON TRACTORS LISTED ABOVE

EXCEPTION: Tractors which have a green "X" label affixed next to the model plate label have already been reworked. No further action is required on your part.

PROBLEM: Premature wear of transmission gear 717-3392.

SOLUTION: To correct the above problem, a service kit has been developed and must be installed on all models noted above and within the serial number range. Do not attempt to order kits, as they will be shipped no charge to you automatically based on the quantity of tractors you received. Additional kits will be provided if needed by contacting the Cub Cadet Service Department. Service kit will consist of a new gear and Ultra Gray sealant.

REPAIR INSTRUCTIONS:

1. Park tractor on a level surface.
2. Refer to transmission removal instructions in the Series 2000 Service Manual.
3. Drain oil from transmission into clean container for reuse.
4. Remove transmission from tractor following procedures in Service Manual.
5. Stand transmission up on right rear wheel and remove left wheel. See Figure 1.



Figure 1



Figure 2

6. Wedge a 2x4 block between the transmission axle housing and the right wheel. See Figure 2.
7. Remove the wheel hub using a 28mm socket and an impact wrench.
8. Remove the hydro neutral bracket.
9. Remove the remaining transmission housing screws and the housing alignment hex bolts.
10. Separate the two housing halves. See Figure 3.
Note: Three pry points, use a dowel rod and hammer to break seal.
11. Carefully remove the left hand transmission housing and axle housing as an assembly.



Figure 3



Figure 4

12. Locate the 42-tooth spur gear on the output shaft and remove bearing and gear. See Figure 4.
13. Replace 42-tooth spur gear with new gear supplied in the kit.
14. Install previously removed bearing on output shaft.
15. Clean left and right transmission sealing surfaces. Note: Be careful not to damage the surfaces when cleaning.
16. Apply Ultra-Gray sealant, supplied in kit, to the right half of the transmission housing mating surface.
17. Carefully install the left hand transmission housing and axle housing. NOTE: Make sure the bearings are properly located in the transmission housing.
18. Install two housing screws opposite of each other finger tight.
19. Install both housing alignment hex bolts through the dowel bushing and secure.
20. Install hydro neutral bracket and remaining screws. Torque to 90 - 120-inch pounds.
21. Install wheel hub and torque hub nut to 200 - 295-foot pounds. Remove 2x4 block.
22. Install the left wheel.
23. Install transmission in tractor frame in reverse order.
24. Refill transmission to proper level with oil previously removed.
25. Start engine and verify proper operation of the forward and reverse controls, the brake and the safety interlock system.

Warranty Allowance: Flat rate 2.5 hours. Indicate Service Advisory CC-442 and 717-3392 as the original failed part number on the claim.

Service Manager	Parts Manager	Sales Manager	Service Tech.	Service Tech.

Circulate and Initial