



INSTRUCTION MANUAL

STEP STAY KIT (K2581-9554-0) for KUBOTA TRACTOR BX1850 / BX2350

STEP STAY KIT (K2592-9554-0) for KUBOTA TRACTOR BX24

■ Assembly Procedure



CAUTION

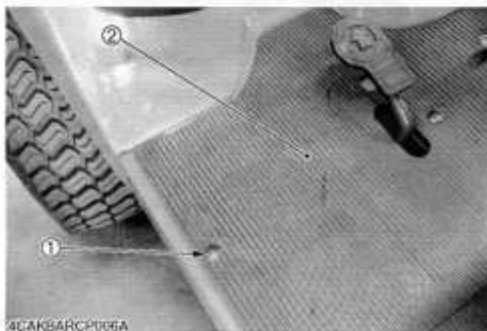
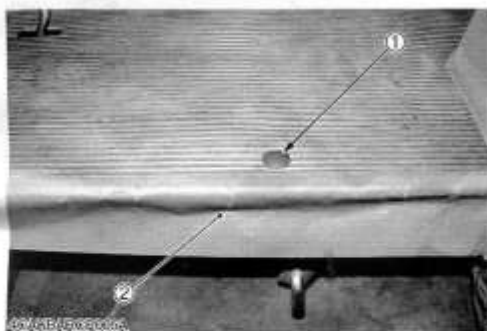
To avoid personal injury:

- Park the machine on firm and level surface.
- Apply the parking brake.
- Stop the engine and remove the key.

NOTE:

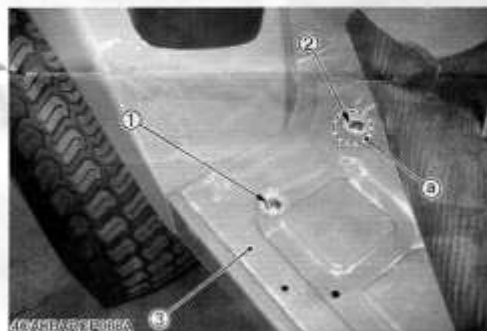
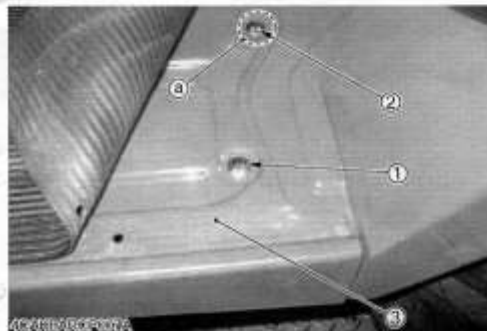
- < > : Ref. No. of Parts List

1. Remove the push rivets from the step on both sides.
(2 places)



- (1) Push rivet
(2) Step

2. Remove the short SQR. neck bolts, flange nuts and plain washers from the step on both sides.
(BX1850 / BX2350 : 2 places, BX24 : 4 places)



- (1) Short SQR. neck bolt (M8 x 1.25), flange nut and plain washer
(2) Short SQR. neck bolt (M8 x 1.25), flange nut and plain washer
(BX24 only)
(3) Step
(4) Step

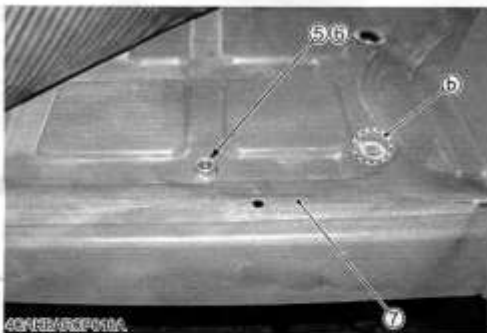
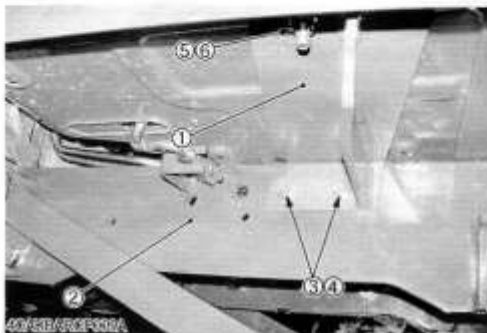
IMPORTANT:

- After attaching the step stay, make sure to apply the short SQR. neck bolts, flange nuts and plain washers to the holes (a).

NOTE:

- The flange nuts and short SQR. neck bolt (BX1850 / BX2350 only) will be used again when fitting the step stay LH and RH.
- Be sure to handle them with care and not lose them.

3. Temporarily attach the step stay LH <1> to the left side of the frame comp. and step with the M10 sems bolts <8>, flange nuts <9>, M8 bolt <7> and flange nut [Original].



- (1) Step stay LH <1>
(2) Frame comp.
(3) Sems bolt (M10 x 35) <8>
(4) Flange nut (M10) <9>
(5) Bolt (M8 x 25) <7>
(6) Flange nut (M8) [Original]
(7) Step

IMPORTANT :

- Do not use the hole (b).
- Make sure the step stay LH is attached between the step and fender.

4. Apply the short SQR. neck bolt, flange nut and plain washer that are removed from the hole (a) in step 2 above. (BX24 only)

◆ Tightening torque

M8 : 23.5 to 27.4 N-m
(2.4 to 2.8 kgf-m, 17.4 to 20.3 ft-lbs.)

5. Tighten the sems bolts, bolt and flange nuts.

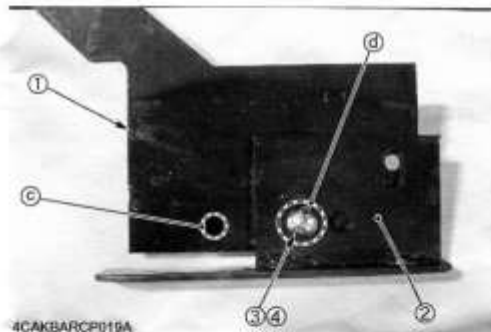
◆ Tightening torque

M8 : 23.5 to 27.4 N-m
(2.4 to 2.8 kgf-m, 17.4 to 20.3 ft-lbs.)
M10 : 48.0 to 55.9 N-m
(4.8 to 5.6 kgf-m, 35.4 to 41.2 ft-lbs.)

6. Attach the step stay RH.

[BX1850 / BX2350]

- (1) Temporarily attach the stay plate RH <3> to the step stay RH <2> with the short SQR. neck bolt [Original] and flange nut <14>.



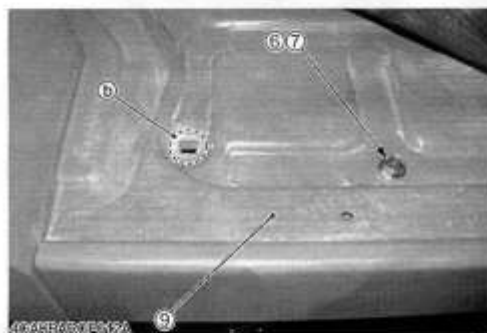
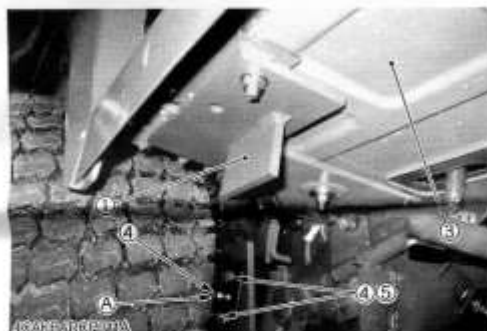
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- (1) Step stay RH <2>
(2) Stay plate RH <3>
(3) Short SQR. neck bolt [Original]
(4) Flange nut <14>

IMPORTANT :

- Make sure not to confuse the hole of the short SQR. neck bolt.
BX1850 : Use the hole (c).
BX2350 : Use the hole (d)

- (2) Temporarily attach the step stay RH <2> to the right side of the frame comp. and step with the M10 sems bolts <6>, flange nuts <9>, M8 bolt <7> and flange nut [Original].



- (1) Step stay RH <2>
 (2) Stay plate RH <3>
 (3) Frame comp.
 (4) Sems bolt (M10 x 35) <8>
 (5) Flange nut (M10) <9>
 (6) Bolt (M8 x 25) <7>
 (7) Flange nut (M8) [Original] <14>
 (8) Short SQR. neck bolt [Original]
 (9) Step

IMPORTANT :

- Do not use the hole (b).
- Make sure the step stay RH is attached between the step and fender.

NOTE :

- Scrape the hole of the frame comp. if it is difficult to insert the M10 sems bolt (A).

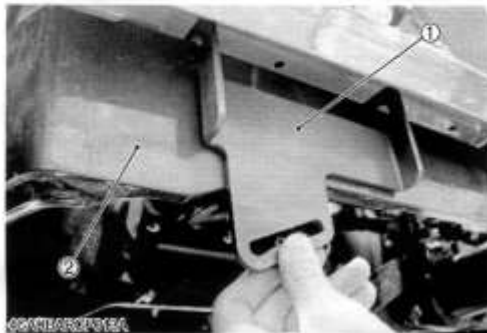
- (3) Tighten the sems bolts, bolt and flange nuts.

◆ Tightening torque

- M8 : 23.5 to 27.4 N-m
 (2.4 to 2.8 kgf-m, 17.4 to 20.3 ft-lbs.)
 M10 : 48.0 to 55.9 N-m
 (4.8 to 5.6 kgf-m, 35.4 to 41.2 ft-lbs.)

[BX24]

- (1) Hang the step hook RH <4> on the sub frame RH.



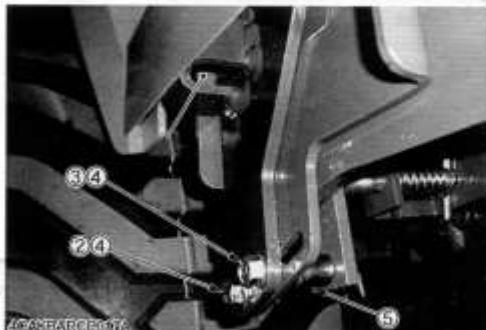
- (1) Step hook RH <4>
(2) Sub frame RH

- (2) Attach the step stay RH <5> over the step hook RH <4> as shown below.



- (1) Step hook RH <4>
(2) Step stay RH <5>

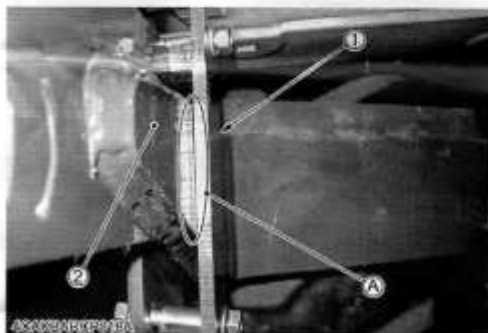
- (3) Temporarily secure the flange bolts (<11> and <12>), bolt <7>, flange nuts ([Original] and <14>), collar <13> and stay plate RH <6>.



- (1) Bolt (M8 x 25) <7>
(2) Flange bolt (M8 x 20) <11>
(3) Flange bolt (M8 x 45) <12>
(4) Flange nut (M8) [Original] <14>
(5) Collar <13>
(6) Stay plate RH <6>

IMPORTANT :

- Do not use the hole (b).
- Make sure the stay plate RH is in contact with the sub frame RH as shown below.



- (1) Stay plate RH <6>
(2) Sub frame RH

(A) "CONTACT"

- (4) Apply the short SQR, neck bolt, flange nut and plain washer that are removed from the hole (a) in step 2 above.

◆ Tightening torque

M8 : 23.5 to 27.4 N-m
(2.4 to 2.8 kgf-m, 17.4 to 20.3 ft-lbs.)

- (5) Tighten the flange bolts, bolt and flange nuts.

◆ Tightening torque

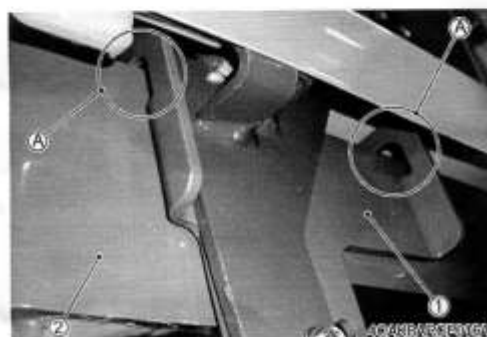
M8 (A) : 23.5 to 27.4 N-m
(2.4 to 2.8 kgf-m, 17.4 to 20.3 ft-lbs.)

M8 (B) : 17.6 to 20.6 N-m
(1.8 to 2.1 kgf-m, 13.0 to 15.2 ft-lbs.)



IMPORTANT :

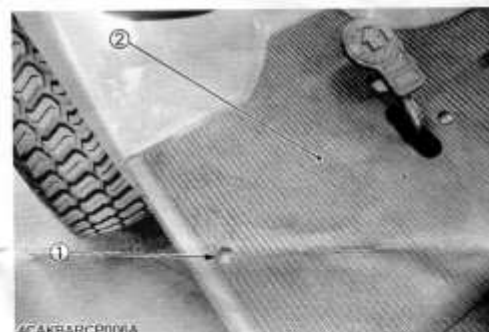
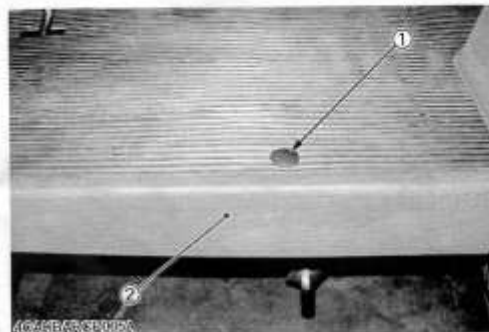
- Make sure the step hook RH is in contact with the sub frame RH as shown below.



(1) Step hook RH <4>
(2) Sub frame RH

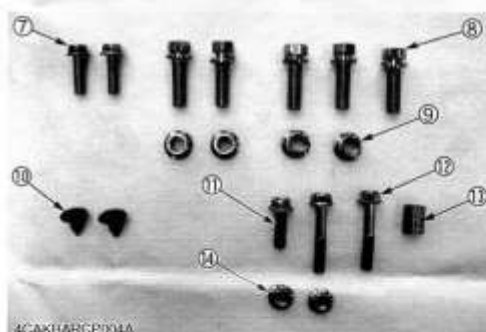
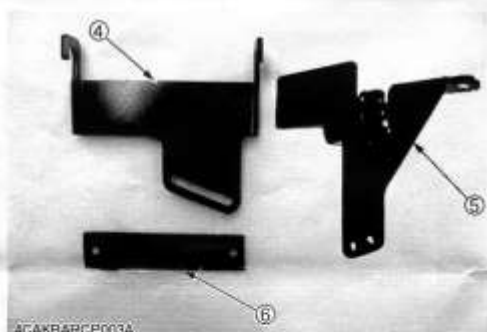
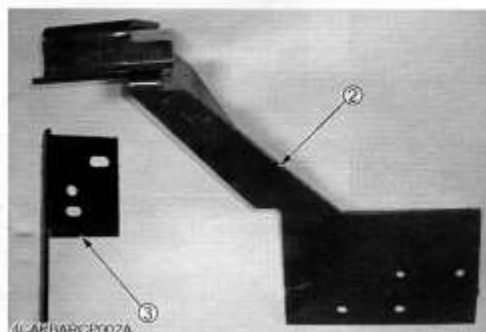
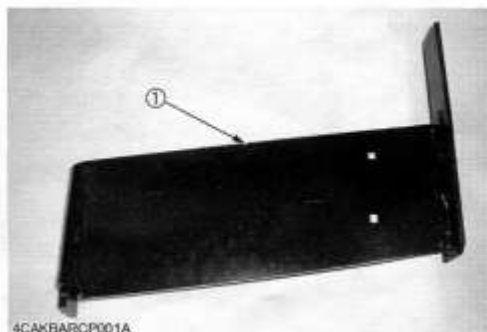
(A) "CONTACT"

7. Apply the push rivets <10> to the step on both sides.
(2 places)



(1) Push rivet <10>
(2) Step

Parts List



REF. No.	PART No.	PART NAME	Q'TY		REMARKS
			BX1850/BX2350	BX24	
1	K2581-5517-0	STAY, STEP LH	1	1	
2	K2581-5518-0	STAY, STEP RH	1	-	
3	K2581-5519-0	PLATE, STAY RH	1	-	
4	K2592-5518-0	HOOK, STEP RH	-	1	
5	K2592-5519-0	STAY, STEP RH	-	1	
6	K2592-5517-0	PLATE, STAY RH	-	1	
7	01153-50825	BOLT	2	2	M8
8	01133-51035	BOLT, SEMS	5	2	M10
9	02771-50100	NUT, FLANGE	4	2	M10
10	K1211-8456-0	RIVET, PUSH	2	2	
11	01754-50820	BOLT, FLANGE	-	1	M8
12	01754-50845	BOLT, FLANGE	-	2	M8
13	K2592-5516-0	COLLAR	-	1	
14	02751-50080	NUT, FLANGE	1	2	M8
15	K2581-9555-0	MANUAL, INSTRUCTION	1	1	This paper