

Fig. 20-15-3—Removing Drive Sprocket

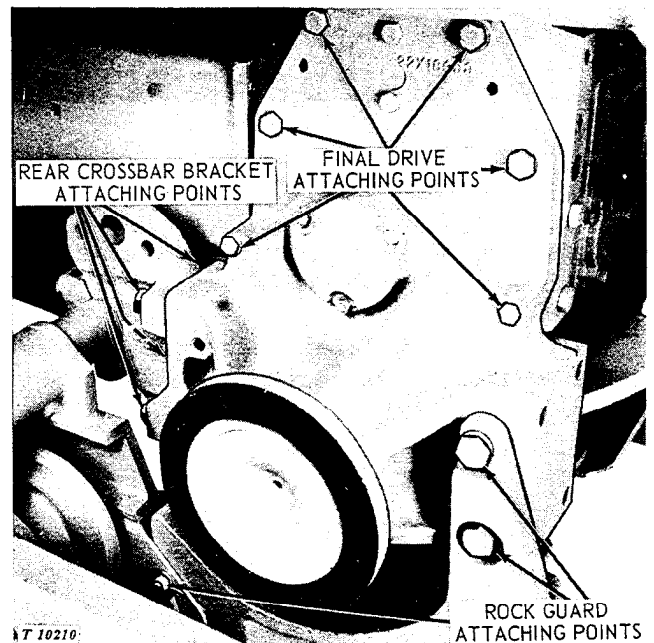


Fig. 20-15-5—Final Drive Attaching Points

9. Block up rear of tractor and remove track drive sprocket by removing cap screws attaching drive sprocket to flanged axle (Fig. 20-15-3). Tap drive sprocket free from flanged axle.

12. Remove cap screws attaching oil pan rock guard to final drive and roller frame (Fig. 20-15-5).

13. Remove outer cap screws which hold final drive housing to steering clutch housing (Fig. 20-15-5).

14. Remove four special cap screws which attach final drive housing to rear crossbar bracket (Fig. 20-15-5).

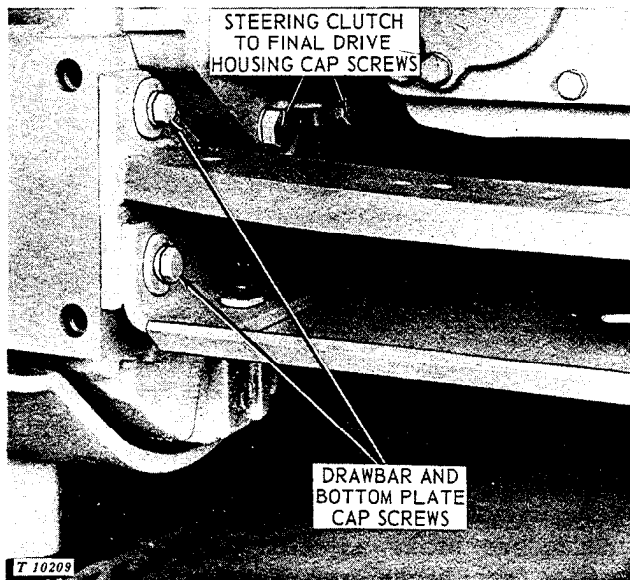


Fig. 20-15-4—Removing Drawbar and Steering Clutch Housing Attaching Cap Screws

10. Remove cap screws which attach drawbar quadrant and bottom plate to final drive housing (Fig. 20-15-4).

11. Under tractor, remove two inner cap screws attaching steering clutch housing to final drive (Fig. 20-15-4).

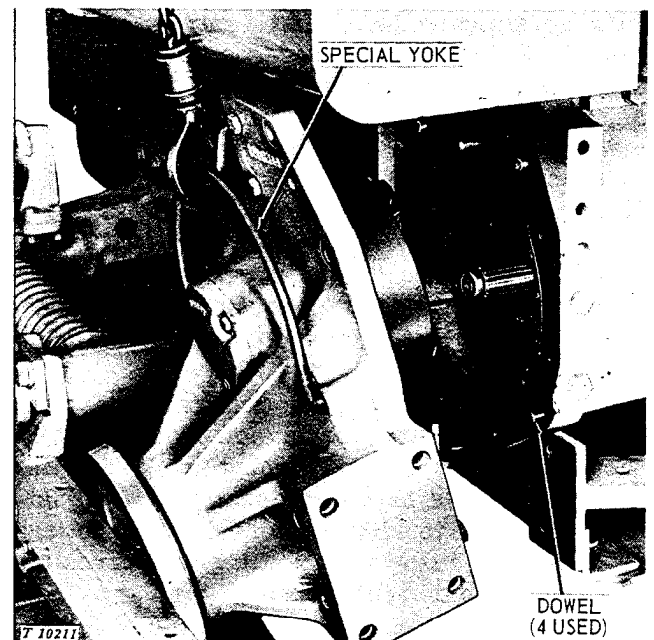


Fig. 20-15-6—Removing Final Drive

15. Using a chain hoist, lift final drive assembly away from steering clutch housing (Fig. 20-15-6). The special yoke shown can be constructed from 1/2-inch round stock and will facilitate removal of the final drive assembly.

If brake band binds on drum, work it back into position as assembly is lifted away.

### INSTALLATION

Fill steering lever shaft bearing hole in upper part of final drive housing about one-eighth full with grease and apply a small amount of grease to steering clutch drive shaft.

Coat machine mounting surface of final drive housing with joint sealing compound and install final drive assembly on mounting dowels using a hoist and special yoke (Fig. 20-15-6)

*NOTE: If side tanks are still attached to tractor, use floor jack to lift final drive into position.*

**CAUTION:** Do not allow steering clutch drive shaft to rest on throw-out bearing carrier sleeve.

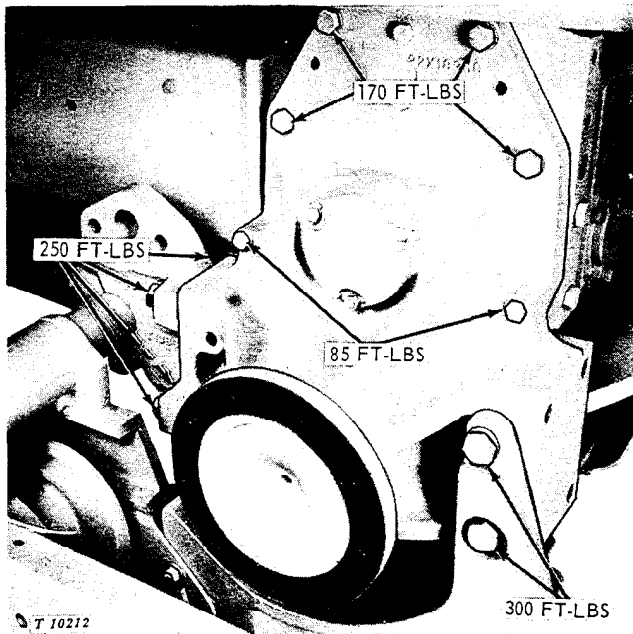


Fig. 20-15-7-Torquing Attaching Cap Screws

Attach final drive housing to rear crossbar brackets with special cap screws (Fig. 20-15-7). Coat cap screws with lubriplate and tighten to 250 ft-lbs.

Install final drive to steering clutch housing cap screws (Fig. 20-15-7). Tighten upper cap screws to 170 ft-lbs and lower cap screws to 85 ft-lbs.

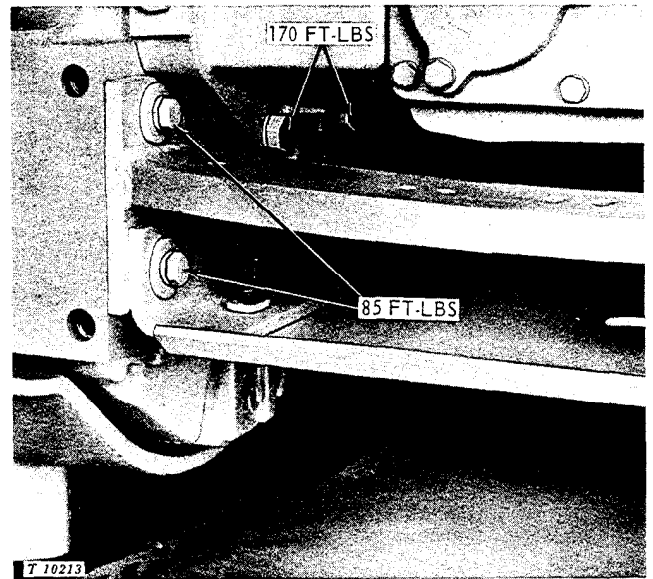


Fig. 20-15-8-Torquing Attaching Cap Screws

Under tractor, install two inner cap screws attaching steering clutch housing to final drive (Fig. 20-15-8). Torque to 170 ft-lbs.

Attach drawbar quadrant (Fig. 20-15-8), making sure that hollow dowels are in place between quadrant and final drive housing. Torque to 85 ft-lbs.

Attach oil pan rock guard to final drive and roller frame (Fig. 20-15-7). Torque large rear cap screws to 300 ft-lbs.

Install sprocket and tighten the sprocket to axle attaching cap screws to 130 ft-lbs (Fig. 20-15-3).

Using a chain hoist, pull track from front of tractor up over idler wheel and sprocket. Place a block of wood between upper portion of track and carrier assembly to take out sag (Fig. 20-15-1).

Line up master pin hole and drive master pin in place, making certain T-head on master pin fits into locking slot on master link (Fig. 20-15-1). Install snap ring.

Align track and adjust tension according to instructions in Section 180, Group 5.

Adjust steering clutch and brake according to instructions in Section 140, Group 5.

Install steering clutch housing cover and seat cushion.

Fill final drive housing with lubricant to proper level. See Section 30 of this manual for proper quantity and viscosity of lubricant.

## Group 20

# STEERING CLUTCH REMOVAL AND INSTALLATION

### REMOVAL

To gain access to steering clutches, first remove rear tank unit from tractor as follows:

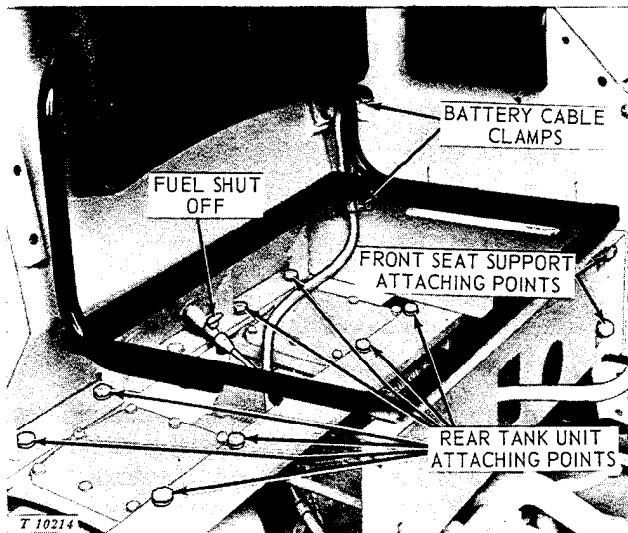


Fig. 20-20-1—Rear Tank Unit Attaching Points

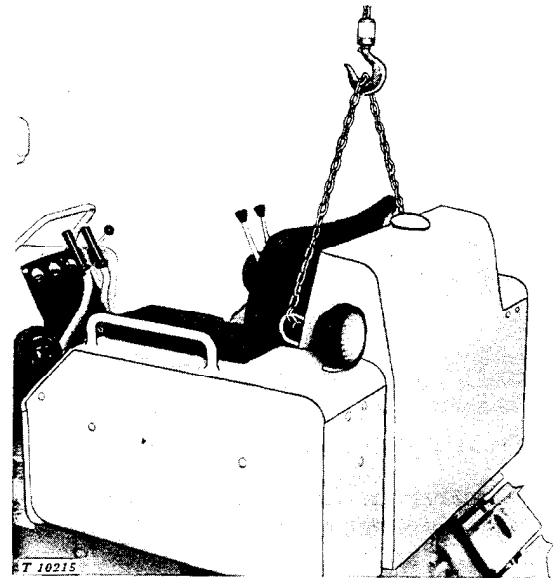


Fig. 20-20-2—Removing Rear Tank Unit

1. Raise battery box lid and disconnect battery cables from batteries. Also disconnect cable clamps from battery box and free cable from rear tank unit.

2. Remove seat cushion. Close fuel shut-off and disconnect fuel line (Fig. 20-20-1). Also disconnect fuel return line (diesel).

3. On crawler-loader units, disconnect hydraulic tank lines. Refer to Group 30 of this Section.

4. Remove cap screws attaching front seat support to side tank (Fig. 20-20-1). Free support from shift lever. Remove cap screws securing fuel tank support and bottom seat support to steering clutch housing as shown.

5. Attach a chain hoist to lift bars and lift rear tank unit from tractor (Fig. 20-20-2).

6. Remove final drive from steering clutch housing as instructed in Group 15 of this Section.

7. With final drive removed, detach brake anchor pin from brake anchor by removing cotter pin and washer (Fig. 20-20-3). Remove brake adjusting screw from brake band.

8. Detach steering clutch spring from upper carrier screw. Remove the two carrier special cap screws attaching bearing carrier to clutch

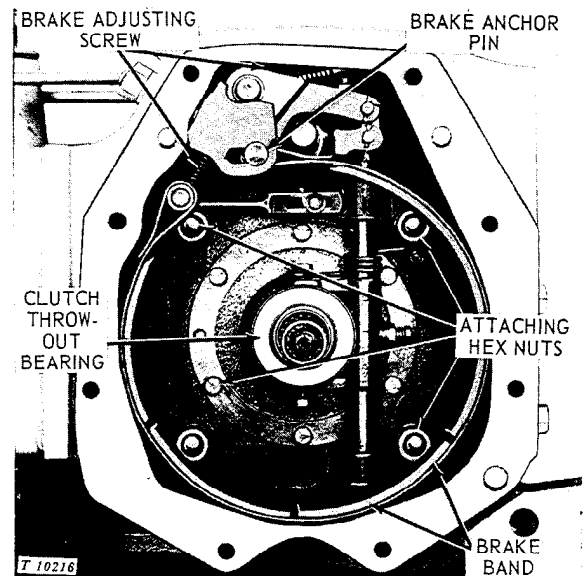


Fig. 20-20-3—Removing Brake Band

fork (Fig. 20-20-3). Slide clutch throw-out bearing and carrier off sleeve.

9. Remove cotter pin and pin attaching steering control lever rod to yoke on steering shaft.

10. Remove cap screws attaching floor plate to transmission top cover. Remove the cotter pin, washer and pin attaching brake rod yoke to brake lever shaft (Fig. 20-20-4).

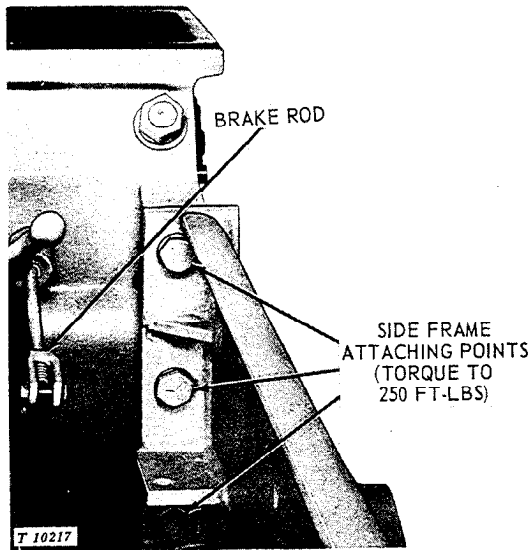


Fig. 20-20-4—Removing Side Frame Cap Screws

11. Remove the three cap screws attaching side frame to clutch housing (Fig. 20-20-4).

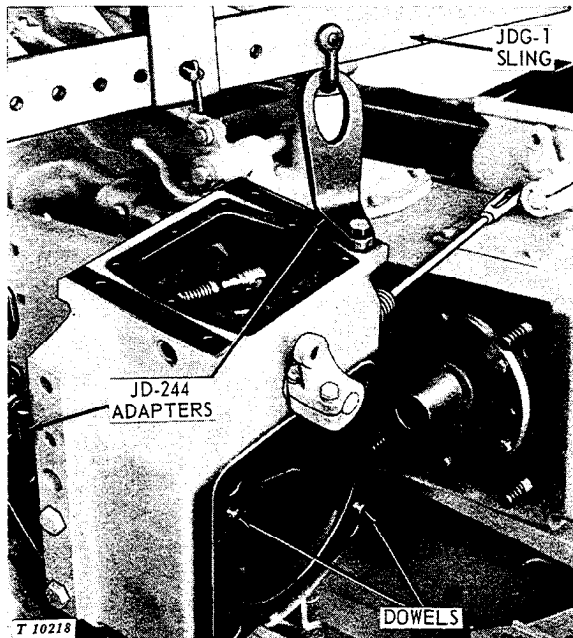


Fig. 20-20-5—Removing Steering Clutch Housing

12. Secure JD-244 adapter tools to steering clutch housing as shown in Fig. 20-20-5.

13. Place JDG-1 sling on a hoist and attach sling to adapter tools as shown in Fig. 20-20-5.

14. Remove the four hex. nuts attaching steering clutch housing to transmission case (Fig. 20-20-3). Using hoist as shown in Fig. 20-20-5, remove housing from transmission case.

## INSTALLATION

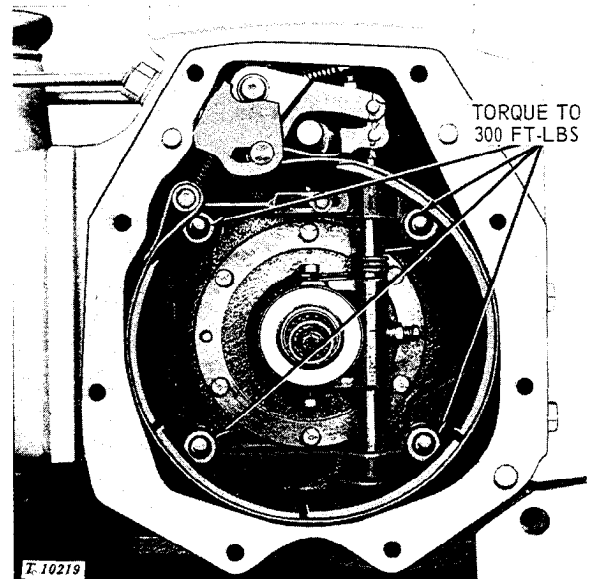


Fig. 20-20-6—Torquing Steering Clutch Hex. Nuts

Before installing steering clutch housing, coat mounting surfaces with joint sealing compound. With the aid of hoist, sling, and adapters, position steering clutch housing on transmission case studs (Fig. 20-20-5). Be sure mounting dowels are in place on steering clutch housing. Install hex. nuts with washers on inner studs and tighten to 300 ft-lbs torque (Fig. 20-20-6).

Attach side frame to steering clutch housing and tighten to 250 ft-lbs torque (Fig. 20-20-4).

Secure steering lever rod to yoke on steering shaft with pin and cotter pin (Fig. 20-20-6).

Install steering clutch throw-out bearing and carrier on sleeve (Fig. 20-20-6). Secure bearing carrier to clutch fork with two special cap screws. Hook clutch spring to upper carrier screw.

Install brake band and attach it to brake anchor with anchor pin, cotter pin and washer.

Secure brake rod yoke to brake lever shaft with pin, cotter pin and washer (Fig. 20-20-4). Install floor plate on tractor.

With the aid of a chainhoist, install rear tank unit on tractor (Fig. 20-20-2). Secure rear tank unit to steering clutch housing as shown in Fig. 20-20-1. Connect battery cables to **POSITIVE** battery terminals. **NEGATIVE TERMINALS ARE GROUNDED. NEVER ATTEMPT TO POLARIZE AN ALTERNATOR-EQUIPPED UNIT.**

Install final drive on steering clutch housing as instructed in Group 15 of this Section.



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