

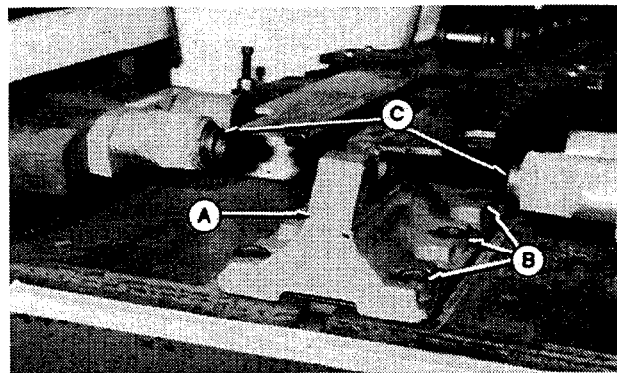
- |                                       |  |
|---------------------------------------|--|
| A—(40989) Saddle                      | M—(10611) Pin (8 used)                         |
| B—(24288) R.H. Assembly Adapter Plate | N—(30350) Forcing Sleeve Bushing Side (2 used) |
| C—(10201) Nut (2 used)                | O—(26545) Plunger, Bushing Side (2 used)       |
| D—(10246) Washer (2 used)             | P—(26330) Spacer (2 used)                      |
| E—(20529) Pilot Plug (2 used)         | Q—(10372) Spring (2 used)                      |
| F—(28577) Track Gauge Plate           | R—(26322) Shim (as required)                   |
| G—(20533) Hand Plug                   | S—(26788) Spacer (2 used)                      |
| H—(30140) Forcing Sleeve Pin (2 used) | T—33016 Shim (as required)                     |
| I—(30512) Plunger, Pin Side (2 used)  | U—(33305) L.H. Assembly Adapter Plate          |
| J—(20457) Shim (2 used)               | V—(12916) Cap Screw (8 used)                   |
| K—(10370) Spring (2 used)             |  |
| L—(26116) Shim (as required)          |  |

**Track Assembly Tooling**

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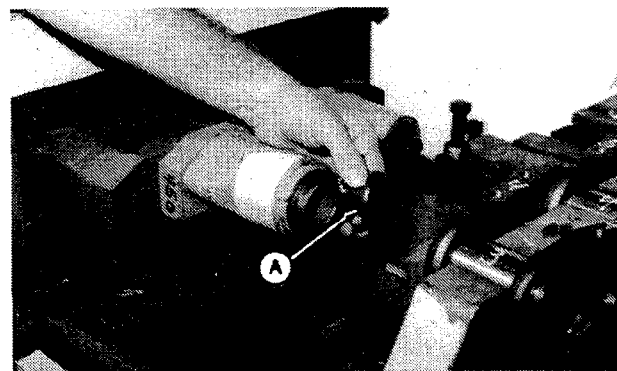
4. Install 40989 saddle (A) in track press frame and secure with cap screws (B). (Same saddle used for disassembly).

5. Install assembly heads (C) from 26815 Tool Set and secure with attaching nuts.



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*NOTE: When assembling right and left hand track link to the master bushing, insert the 26327 Master Bushing Spacer (A) into the right and left bushing plungers. (Spacer shown with Track Disassembly Tooling).*



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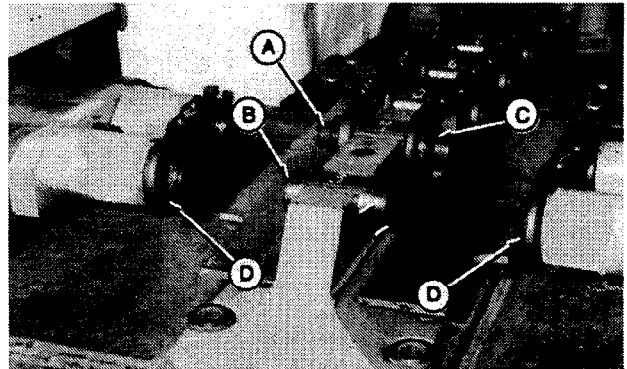
6. Lubricate pin with SAE 80W-90 gear oil.

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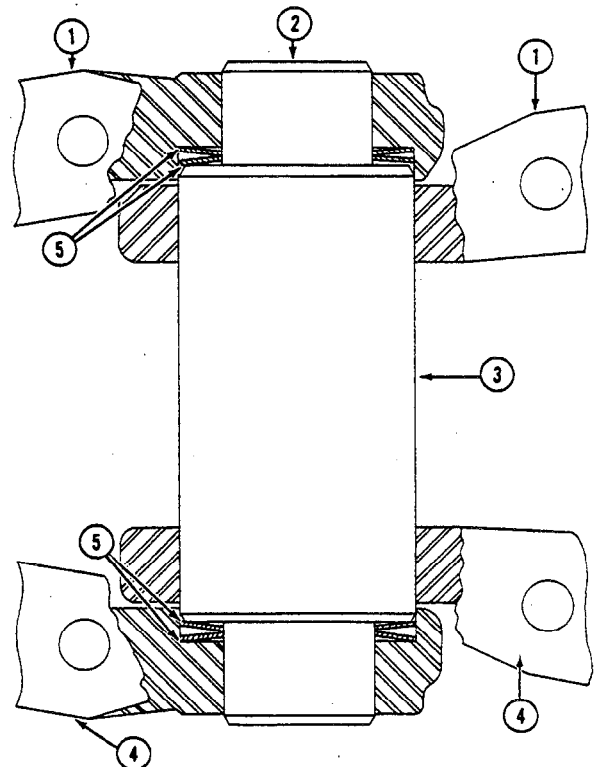
7. Install pin (A) in bushing and bushing (B) in saddle slot. Install two belleville seals (C) on each side of track pin. (See cross sectional drawing on Track Chain Link Connection). Install belleville seals with dished side opposite or outward. Place right and left track links (D) in position on assembly heads.

A—Track Pin  
B—Track Bushing

C—Belleville Seals  
D—Track Links



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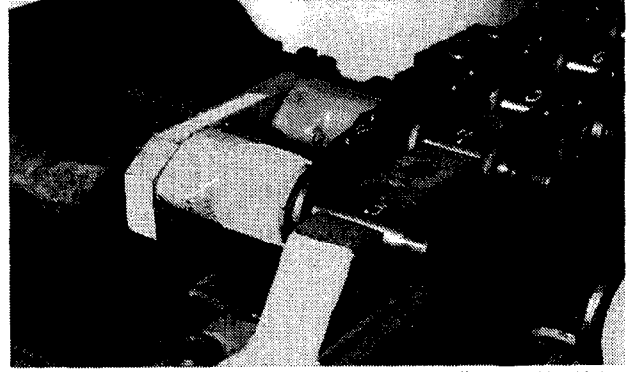


1—Left Track Link  
2—Track Pin  
3—Track Bushing

4—Right Track Link  
5—Belleville Seals (4 used)

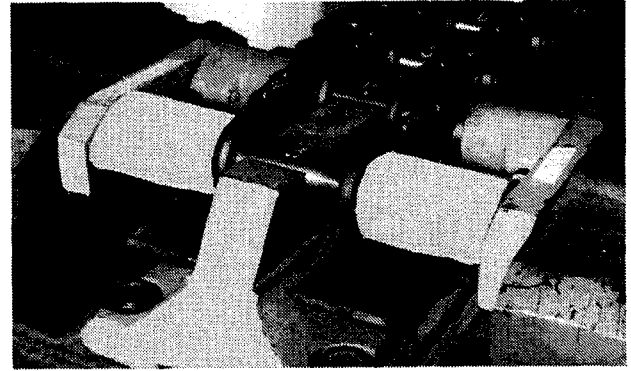
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8. Extend the left assembly head until the link almost contacts the track press saddle.



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9. Extend the right assembly head until the bushing contacts the link seats. Bushing and pin should be centered in saddle during assembly. Continue pressing until the track shoe bolt holes are in alignment with 28577 Gauge.



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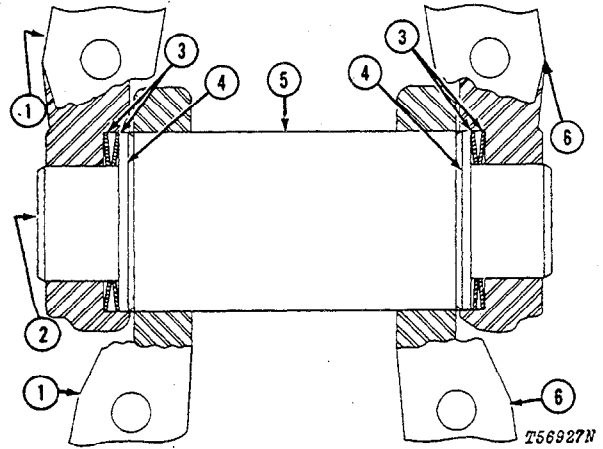
10. Raise conveyor and slide chain away from operator. Position newly installed bushing in rear saddle slot.

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11. Assemble remainder of chain using the previous steps.

**NOTE:** Master pin (2) is installed when assembling track to crawler unit. Two special spacers (4) make up the dimensional differences in the master bushing (5) when installing master pin (2). (See beginning of this group for breaking track chain procedure.)

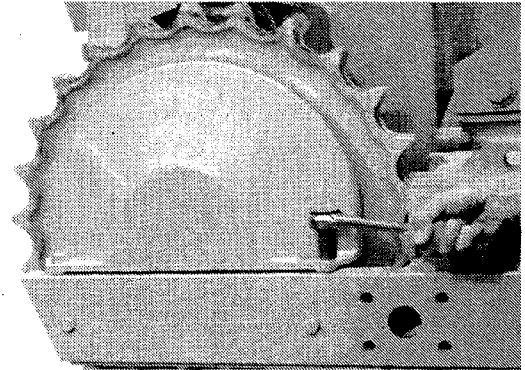
- |                                |                                     |
|--------------------------------|-------------------------------------|
| 1—Right Track Link             | 4—Master Bushing Spacer<br>(2 used) |
| 2—Master Pin                   | 5—Master Bushing                    |
| 3—Belleville Seals<br>(4 used) | 6—Left Track Link                   |



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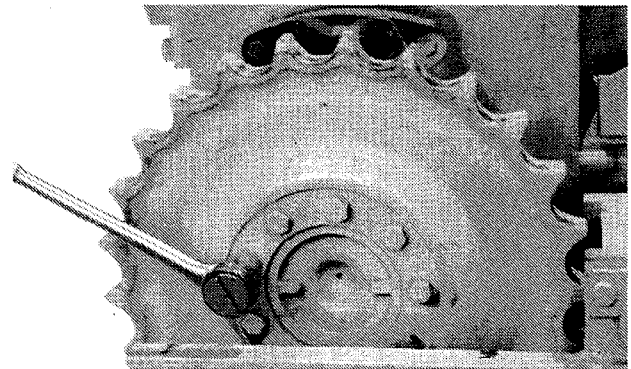
## REMOVE DRIVE SPROCKET

1. Remove four cap screws and lock washers to remove sprocket shield (Dozer only).



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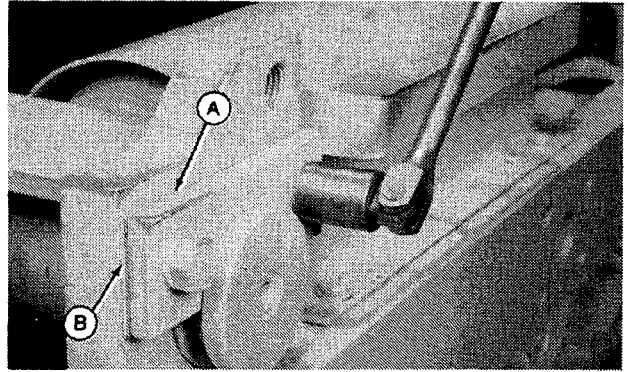
2. Remove nine cap screws and washers and lift sprocket from axle shaft.



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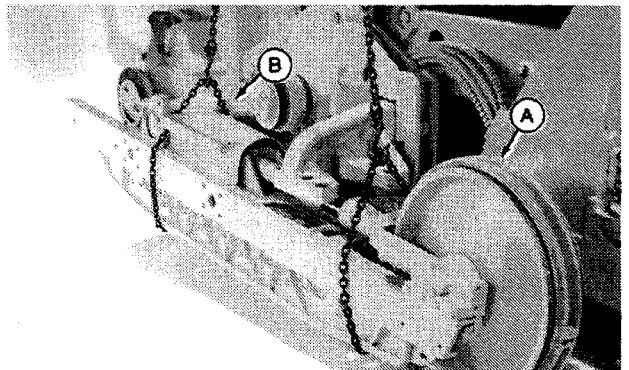
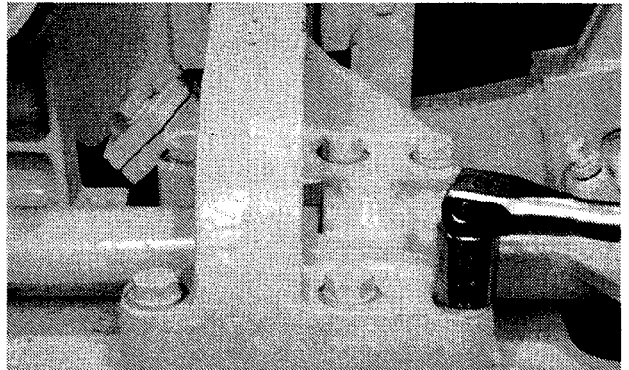
### REMOVE TRACK FRAME

1. Remove two cap screws and washers to remove retainer (A) and shims (B).



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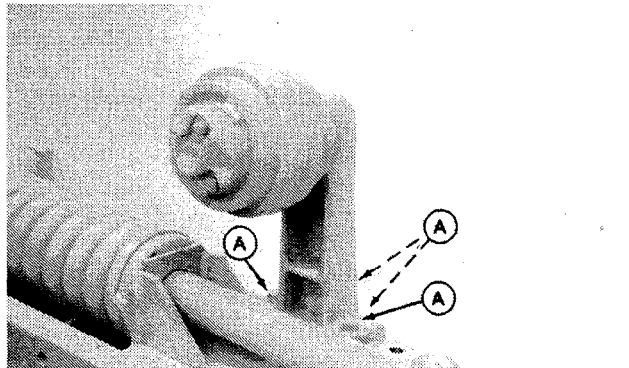
2. Attach hoist.
3. Remove six cap screws and flat washers from front crossbar.
4. Move front idler (A) forward.
5. Pull track frame assembly free from rear crossbar (B) and slide clear of crawbar.



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### REMOVE UPPER CARRIER ROLLER ASSEMBLY

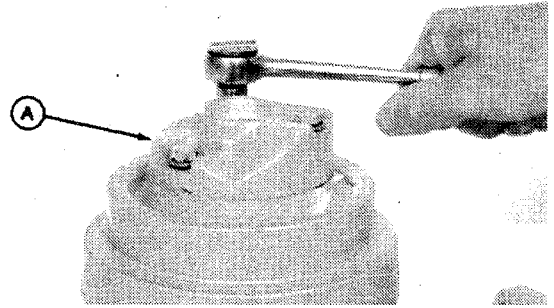
1. Remove four cap screws and lock washers (A) to remove track carrier roller support assembly.



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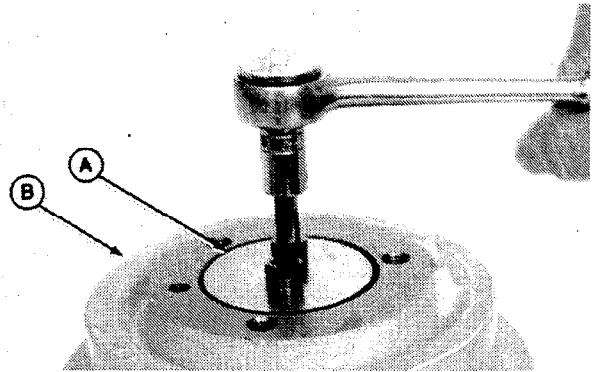
## DISASSEMBLE AND INSPECT UPPER CARRIER ROLLER ASSEMBLY

1. Remove three cap screws and lock washers to remove cover (A) and gasket.



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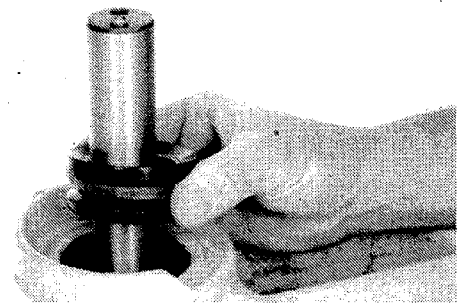
2. Remove two socket head cap screws to remove plate (A) and roller assembly (B).



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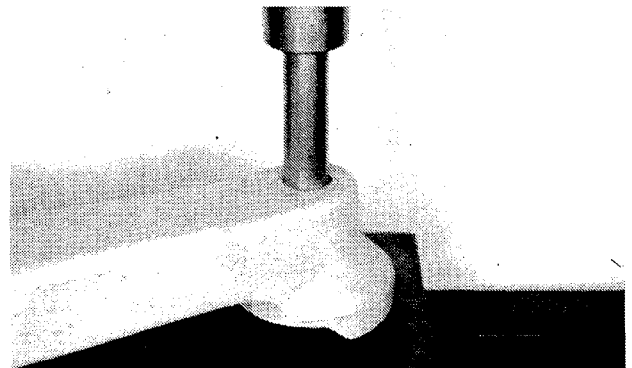
3. Remove oil seal in carrier support.

*NOTE: Keep metal face of seals lubricated and together at all times while disassembled.*



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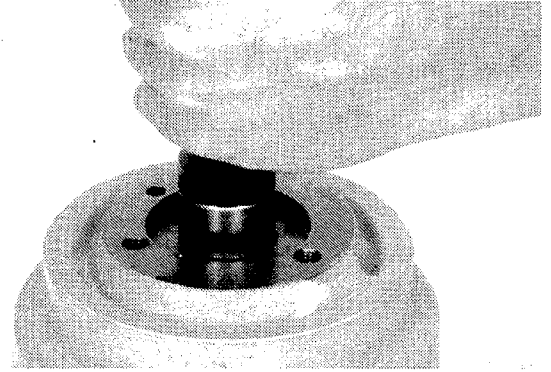
4. Inspect shaft for wear or damage, replace only if necessary. Remove shaft using a press and a piece of pipe with 101.6 mm (4 in.) O.D. and a minimum length of 50.8 mm (2 in.).



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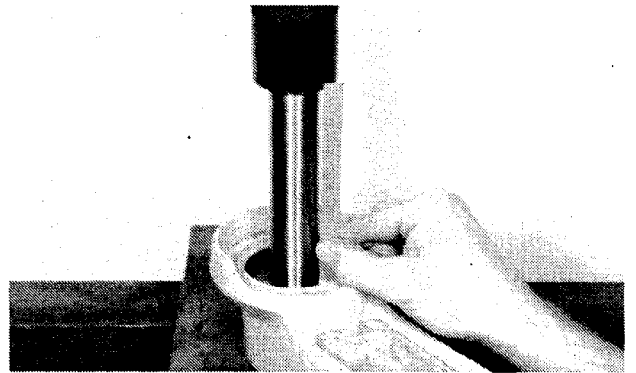
## ASSEMBLE UPPER CARRIER ROLLER

1. If replacement of the two bushings in roller is necessary, use 27508 and 27505 disks from D-01045AA Bushing, Bearing and Seal Driver Set.



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2. Install new shaft using a press. Press in shaft to 145.03 to 145.54 mm (5.710 to 5.730 in.) above the face of seal bore.

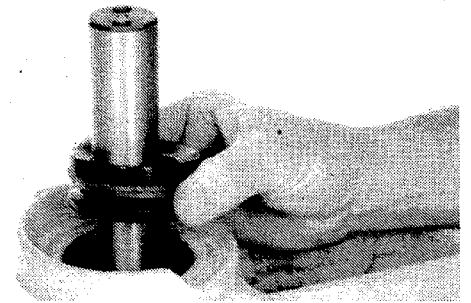


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**IMPORTANT:** The metal face seal bore in support and roller must be degreased with clean solvent and dried before installing seal.

3. Install oil seal into support. Side with the retainer ring goes into support. It is recommended that a new oil seal kit be installed.

*NOTE: Do not remove plastic retaining ring from new seal.*



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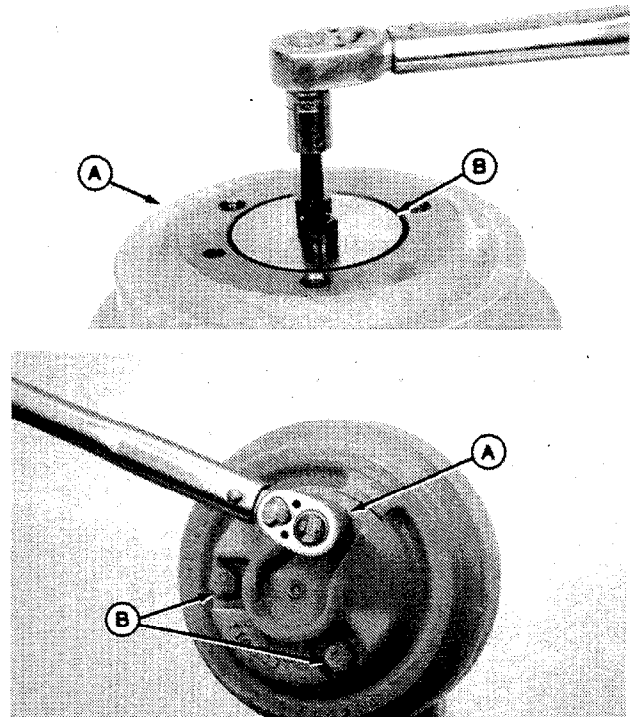
**Thank you so much for reading**



4. Install roller assembly (A), plate (B) and two socket head screws. Tighten screws to  $54 \pm 3$  N·m ( $40 \pm 3$  lb-ft).

5. Install cover with three cap screws. Tighten cap screw (A) to  $41 \pm 4$  N·m ( $30 \pm 3$  lb-ft) and cap screws (B) to  $47$  N·m ( $35$  lb-ft).

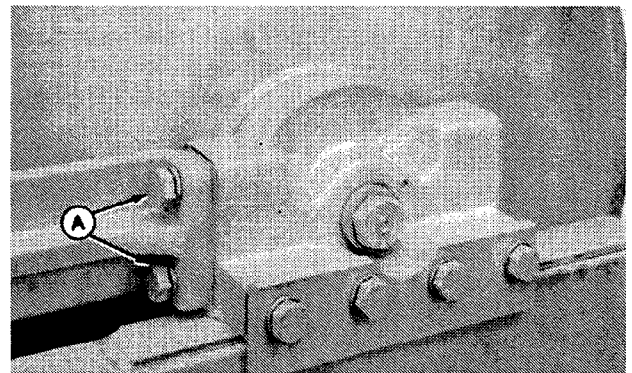
6. Fill roller assembly with approximately 710 ML (1-1/2 pt) of the recommended oil. (See Lubrication in Section I.)



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### REMOVE FRONT IDLER ASSEMBLY

1. Remove two cap screws and lock washers (A) from both sides.
2. Attach hoist and slide front idler forward off track frame.



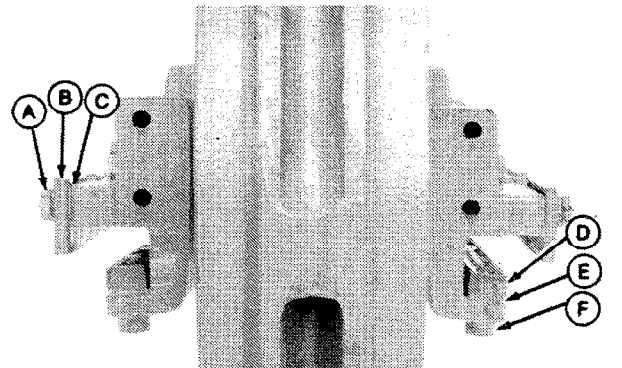
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### DISASSEMBLE AND INSPECT FRONT IDLER ASSEMBLY

1. Remove two cap screws and lock washers (F) on bottom of both sides to remove shims (E) and wear strap (D). Remove four cap screws and lock washers (A) on both sides to remove guide (B) and shims (C).

A—Cap Screw (8 used)  
B—Guide (2 used)  
C—Shims

D—Wear Strap (2 used)  
E—Shims  
F—Cap Screw (4 used)



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