



Service Repair Manual

Models

D6M TRACK-TYPE TRACTOR

Product: TRACK-TYPE TRACTOR

Model: D6M TRACK-TYPE TRACTOR 4GS

Configuration: D6M XL & D6M LGP TRACTORS / POWERSHIFT / 4GS00001-UP (MACHINE) POWERED BY 3116 ENGINE

Disassembly and Assembly D6M Track-Type Tractor Power Train

Media Number -SEN9482-04

Publication Date -01/01/2011

Date Updated -31/01/2011

i00964522

Bevel and Transfer Gears - Assemble

Assembly Procedure

Table 1

Tools Needed	A	B	C	D	E
8T-2839 Spanner Wrench	1				
FT-1986 Stud		1			1
2P-8257 Plate		1			1
6B-6684 Nut		5			9
2P-8260 Cylinder Liner Installer		1			1
4B-5273 Washer		3			4
1D-4719 Nut		2			2
0S-1590 Bolt 3/8 inch - 16 NC x 2 inch (50.8 mm)		1			1
8S-2328 Dial Indicator Group			1		
1P-520 Driver Group				1	
1P-1833 Adapter					1
1P-1839 Adapter					1



Illustration 1

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1. If bearing race (43) was removed, lower the temperature of the bearing race. Install the bearing race in the case assembly.

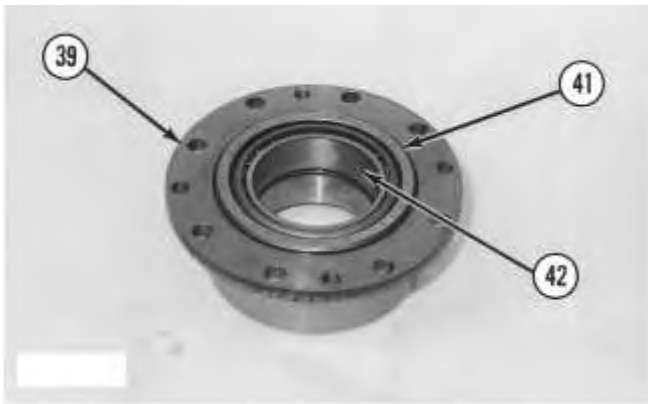


Illustration 2

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2. Install bearing cones (42) and bearing cups (41) in cage (39) .

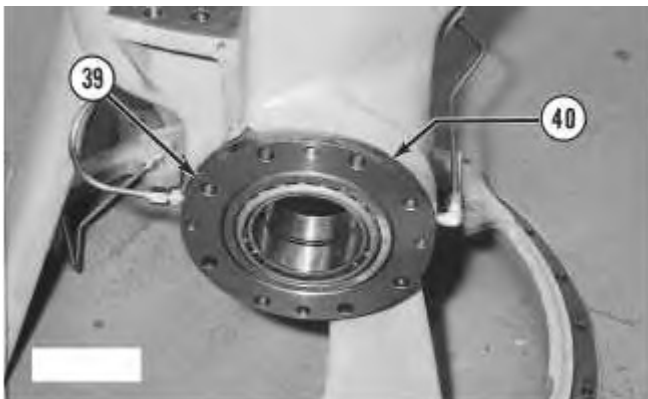


Illustration 3

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3. Install the original amount of shims (40) and cage in the case assembly.

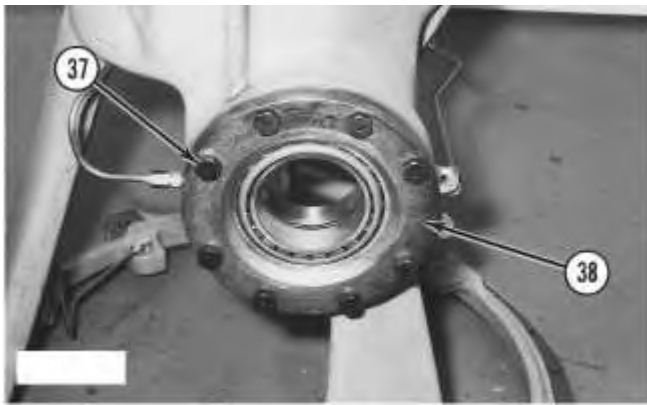


Illustration 4

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4. Put retainer (38) in position. Install bolts (37) .

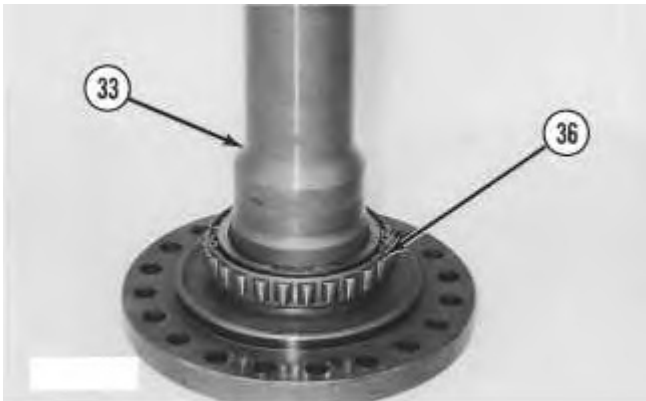


Illustration 5

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5. If bearing (36) was removed, heat the bearing to a maximum temperature of 135°C (275°F). Install the bearing on shaft (33) .
-

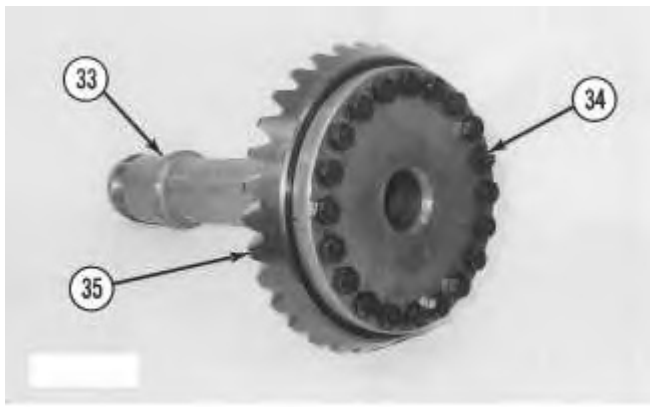


Illustration 6

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- Put gear (35) in position on shaft (33). Install bolts (34) .



Illustration 7

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- Fasten a hoist to shaft (33). Put the shaft in position in the case assembly. Remove the hoist from the shaft. Install the shaft all the way.

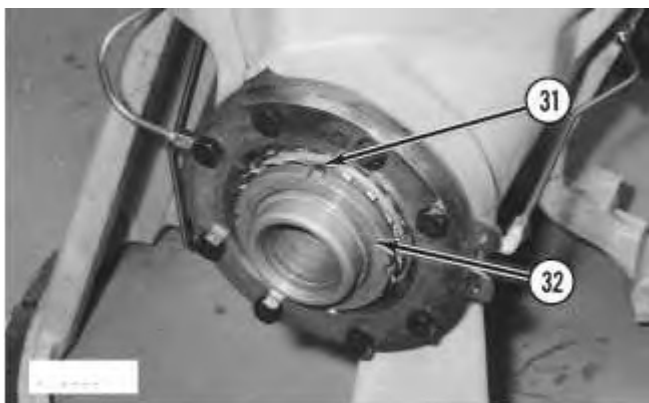


Illustration 8

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8. Put the washer and washer (31) in position on the shaft.
9. Put **5P-3931** Anti-Seize Compound on the threads and face of nut (32). Install the nut on the shaft. Use Tool (B) in order to tighten the nut to a torque of $612 \text{ N}\cdot\text{m} \pm 68 \text{ N}\cdot\text{m}$ ($450 \text{ lb ft} \pm 50 \text{ lb ft}$).

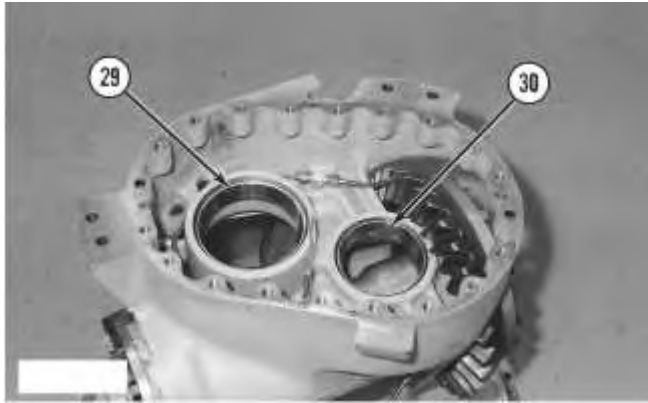


Illustration 9

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10. If bearing cups (29) and (30) were removed, lower the temperature of bearing cups. Install the bearing cups in the case assembly. The bearing cups must be seated in the case assembly.



Illustration 10

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Note: If the bearing cones were removed from gear (22), new bearing cones must be installed.

11. Heat bearing cones (27) and (28) to a maximum temperature of 135°C (275°F). Install the bearing cones on gear (22). The bearing cones must be seated on the gear.
-

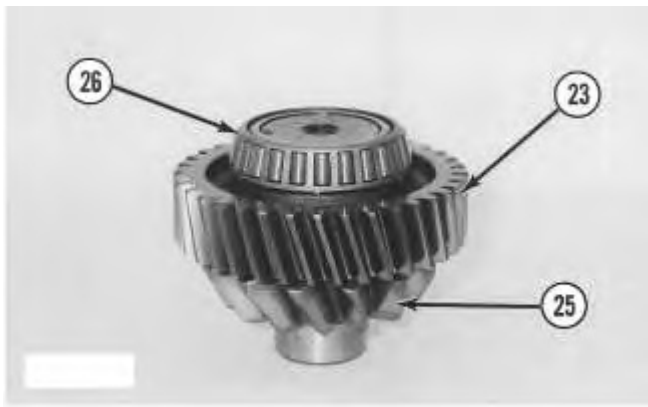


Illustration 11

g00709320

12. Put pinion (25) in position in gear (23) .
13. Heat bearing cones (26) to a maximum temperature of 135°C (275°F). Install the bearing cone on pinion (25). The bearing cone must be seated on the pinion.

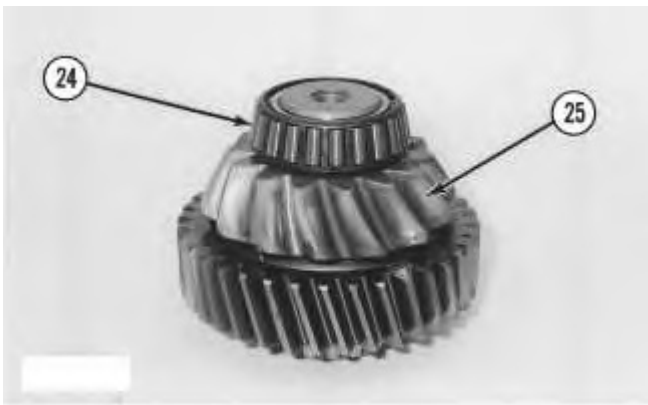


Illustration 12

g00709323

14. Heat bearing cones (24) to a maximum temperature of 135°C (275°F). Install the bearing cone on pinion (25). The bearing cone must be seated on the pinion.



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