Disassembly and Assembly
D6T Track Type Tractor Power Train
Media Number -M0073303-04 **Publication Date -01/09/2018** **Date Updated -06/09/2018**

i07434369

Bevel and Transfer Gears - Assemble

SMCS - 3011-016

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	422-5474	Lifting Eye Assembly	3
C	439-3940	Bracket As	1
F	8T-2839	Wrench	1
K	-	Loctite C5-A Copper Anti-Seize	-
L	1P-0520	Driver Group	1
M	1U-7234	Feeler Gauge	1
N	154-6183	Forcing Bolt	1
P	8T-5096	Tool Gp	1

Illustration 1 g06132214

1. Raise the temperature of roller bearing race (48). Install roller bearing race (48) on bevel gear and shaft (37).

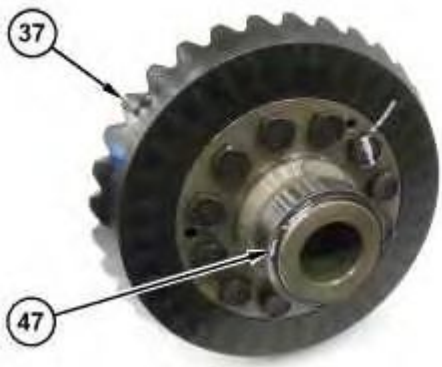

Illustration 2 g06130916

2. Install retaining ring (47) on bevel gear and shaft (37).

Illustration 3 g06130915

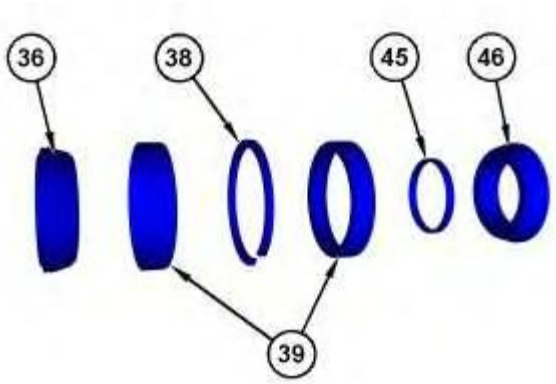

Illustration 4 g06136393

NOTICE

Bearing cone (36), retaining ring (38), bearing cups (39), spacer (45), and bearing cone (46) have to be replaced as a set. Do not mix new parts with old parts.

3. Raise the temperature of bearing cone (46) and spacer (45). Install bearing (46) and spacer (45) on bevel gear and shaft (37).

Illustration 5 g06132266

4. Install tube assemblies (42) in the transmission case.
5. Attach a suitable lifting device to bevel gear and shaft (37). The weight of bevel gear and shaft (37) is approximately 59 kg (130 lb).
6. Position bevel gear and shaft (37) in the transmission case.

Illustration 6 g06130847

7. Align the dowel hole in race and roller assembly (43) with the hole in bearing cage (41).
8. Install race and roller assembly (43) in bearing cage (41).
9. Install dowel (44) in bearing cage (41).

Illustration 7 g06130837

10. Position bearing cage (41) on the transmission case.
11. Install bolts (40). Tighten bolts (40) to a torque of 120 ± 20 N·m (89 ± 15 lb ft).

Illustration 8 g06130815

12. Install retaining ring (38) (not shown) in the center of bearing cage (35).
13. Lower the temperature of two bearing cups (39). Install bearing cups (39) in bearing cage (35).

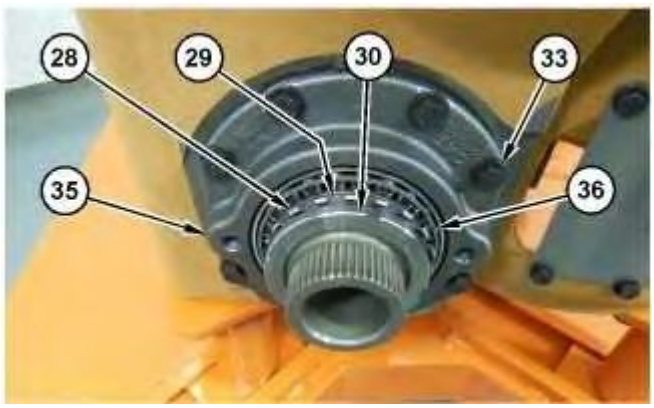

Illustration 9 g06133273

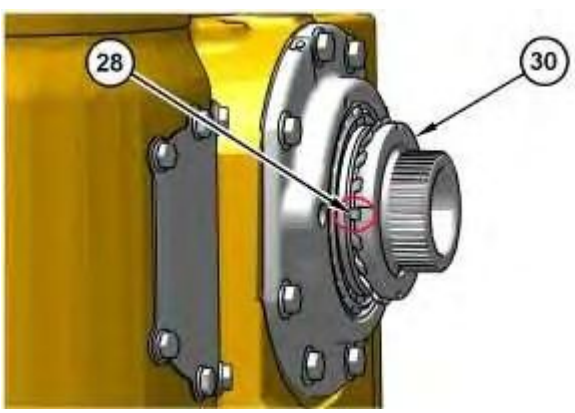

Illustration 10 g06326102

14. Install bearing cage (35) without the shims.
15. Install bolts (33) that hold bearing cage (35) to the transmission case. Do not tighten bolts (33).
16. Raise the temperature of bearing cone (36). Install bearing cone (36) on the bevel gear and shaft.
17. Install washer (29) (not shown) and bearing lock washer (28).
18. Apply Tooling (K) to the threads and the face of bearing locknut (30). Install bearing locknut (30) on the bevel gear shaft.
19. Use Tooling (F) to tighten bearing locknut (30) to a torque of 900 ± 100 N·m (664 ± 74 lb ft).
20. Increment bearing locknut (30) to the closest tab/groove location and then bend the locking tab on bearing lock washer (28).

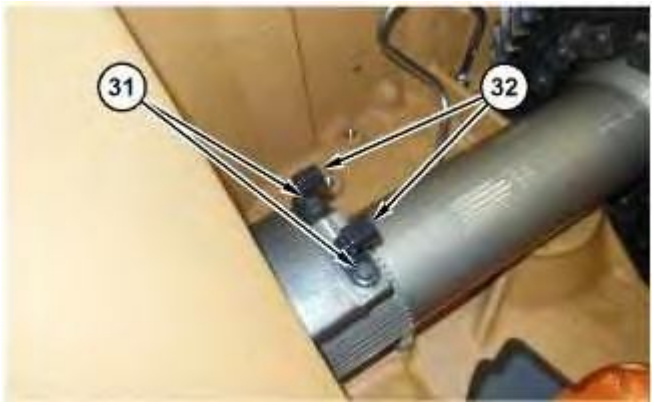

Illustration 11 g06130749

21. Install speed sensors (32) and bolts (31).

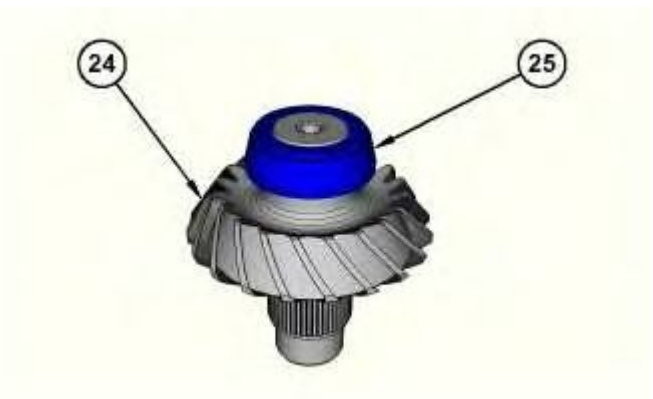

Illustration 12 g06134656

22. Raise the temperature of bearing cone (25) to 135°C (275°F) and install bearing cone (25) on bevel pinion gear (24). Use a 0.03 mm (0.001 inch) feeler gauge to ensure that bearing cone (25) is seated against bevel pinion gear (24).

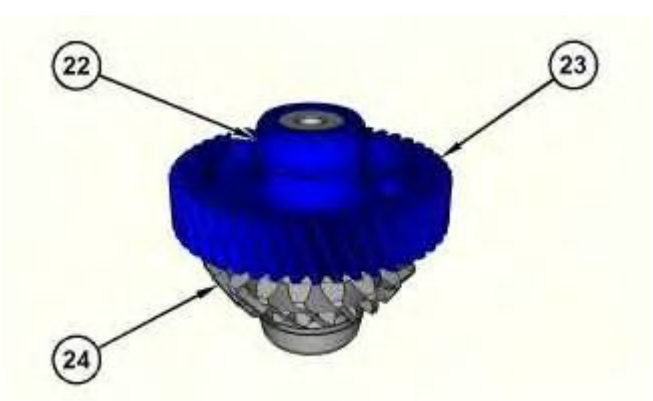

Illustration 13 g06134609

23. Align the splines and install transfer gear (23) on bevel pinion gear (24).

24. Raise the temperature of bearing cone (22) to a maximum of 135°C (275°F) and install bearing cone (22) on transfer gear (23). Use a 0.03 mm (0.001 inch) feeler gauge to ensure that bearing cone (22) is seated against transfer gear (23).

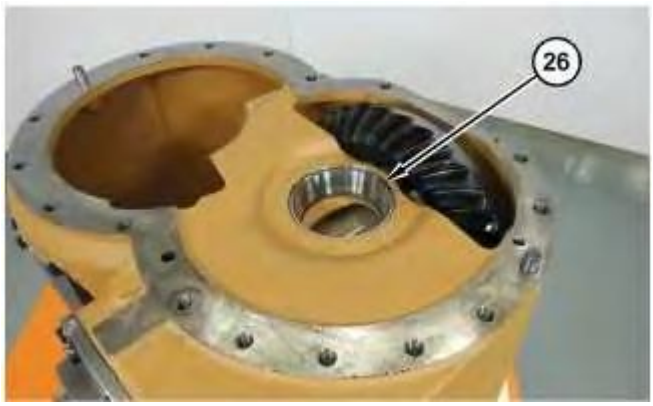

Illustration 14 g06130695

25. Lower the temperature of bearing cup (26). Install bearing cup (26) into the transmission case.

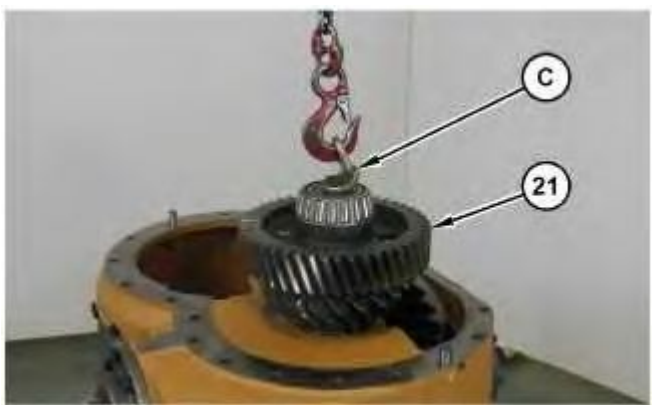

Illustration 15 g06130663

26. Attach Tooling (C) and a suitable lifting device to pinion gear assembly (21). The weight of pinion gear assembly (21) is approximately 33 kg (73 lb).

27. Lower pinion gear assembly (21) into position in the transmission case.

28. Remove Tooling (C) from pinion gear assembly (21).

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