Disassembly and Assembly
D6T Track-Type Tractor Power Train
Media Number -KENR5126-07 **Publication Date -01/01/2013** **Date Updated -25/07/2018**

i06701251

Final Drive - Assemble

SMCS - 4050-016

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	138-7573	Link Bracket	3
	1A-2029	Bolt	3
B	1P-0520	Driver Gp	1
D	138-7574	Link Bracket	2
	2A-1538	Bolt	2
E	8M-9395	Installer	1

1. Apply clean oil to all the parts during assembly.

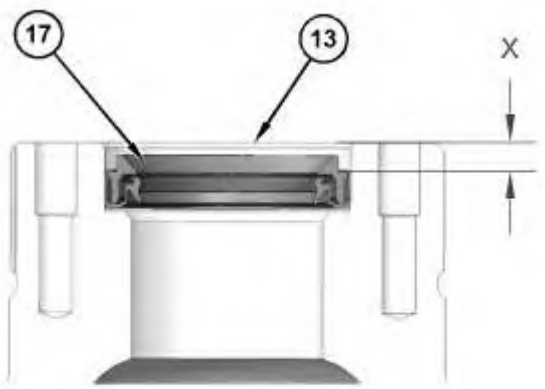

Illustration 1 g06081205

2. Use Tooling (B) to install lip seal (17) in spindle (13) to a depth of (X) 9 ± 0.25 mm (0.3543 ± 0.0098 inch). Put clean oil on the lip of the seal.

   Note: Dimension (X) is measured from the face of the spindle to the top of the metal can of the lip seal in the orientation shown.

   Note: Do not apply excessive force to lip seal (17) during installation to avoid damaging the seal.

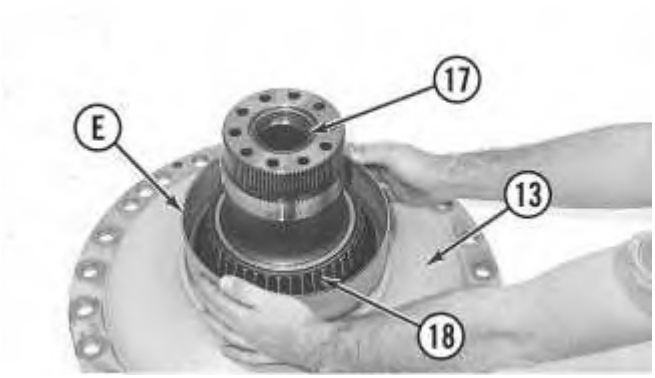

Illustration 2 g00841209

3. Raise the temperature of bearing cone (18) to a maximum temperature of 135 °C (275 °F). Install bearing cone (18) on spindle (13).

   Note: Before the installation of the Duo-Cone seal, refer to Disassembly and Assembly, "Duo-Cone Floating Seals - Install" for the correct procedure.

4. Use Tooling (E) to install the Duo-Cone seal on spindle (13).

Illustration 3 g00841210

5. Lower the temperature of bearing cups (14) and (16). Install bearing cups (14) and (16) in hub (12).
6. Use Tooling (E) to install the Duo-Cone seal in hub (12).

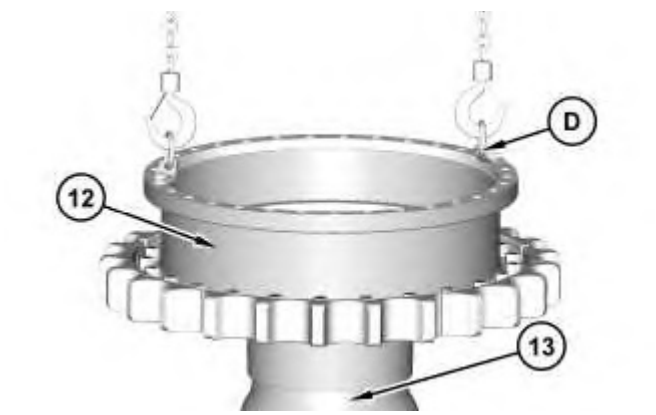

Illustration 4 g01195917

7. Install Tooling (D) on hub (12). Attach a suitable lifting device to Tooling (D). Carefully position hub (12) on spindle (13).

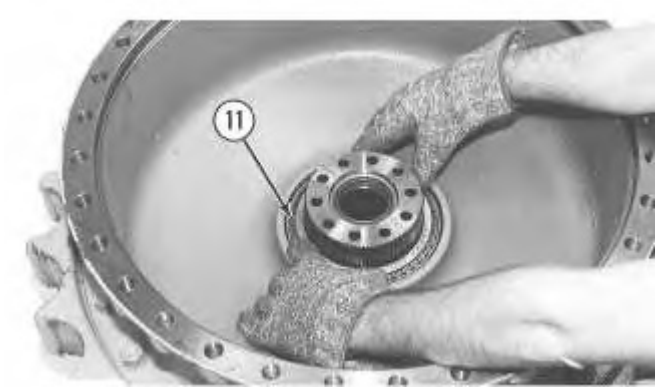

Illustration 5 g00841212

8. Raise the temperature of bearing cone (11). Install bearing cone (11) on spindle (13).

Illustration 6 g01195915

9. Attach a suitable lifting device to hub (9) and position hub (9) in ring gear (8). Install retaining ring (10).

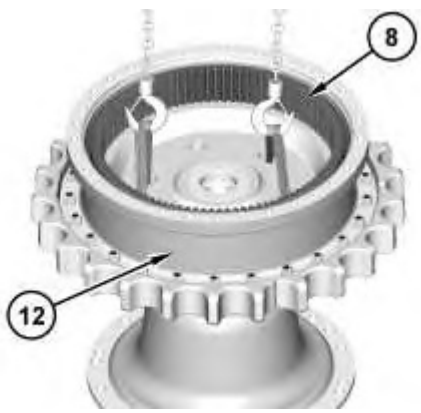

Illustration 7 g01195913

10. Turn over the hub (9) and ring gear (8). Attach a suitable lifting device to hub (9) and the ring gear (8) into position in hub (12).

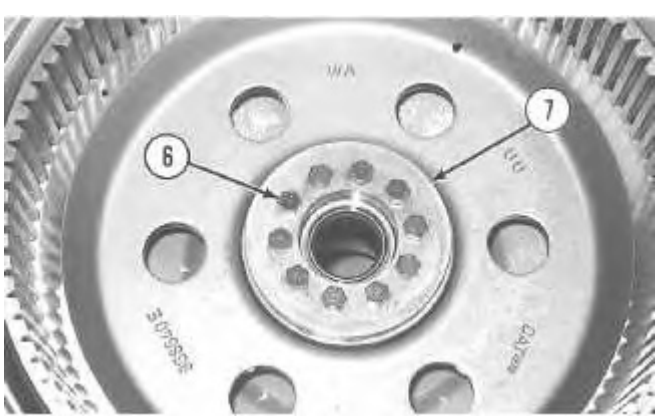

Illustration 8 g00841092

11. Put retainer (7) into position. Install bolts (6) while the hub is slowly rotated. Tighten bolts (6) evenly to a torque of 135 ± 15 N·m (100 ± 11 lb ft). The retainer must contact the end of spindle (13) after bolts (6) have been tightened.

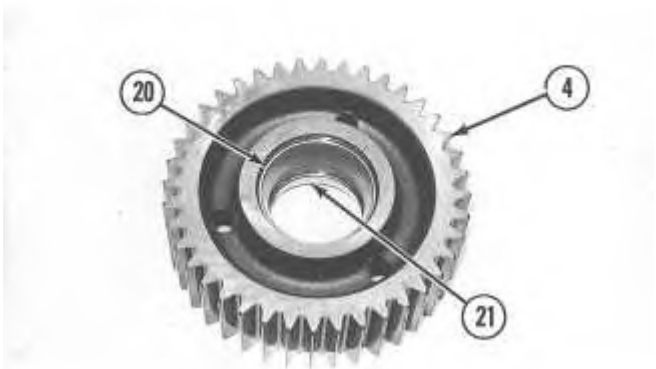

Illustration 9 g00841213

12. Lower the temperature of bearing cups (20) and (21). Install the bearing cups in three planetary gears (4).

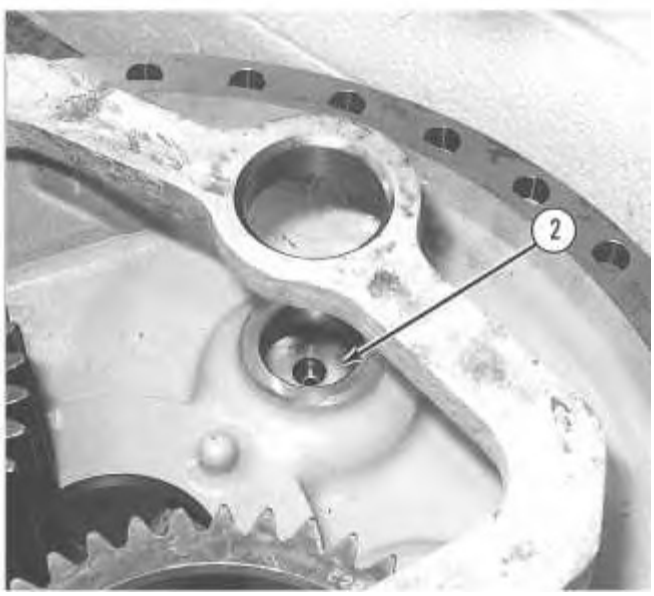

Illustration 10 g00841215

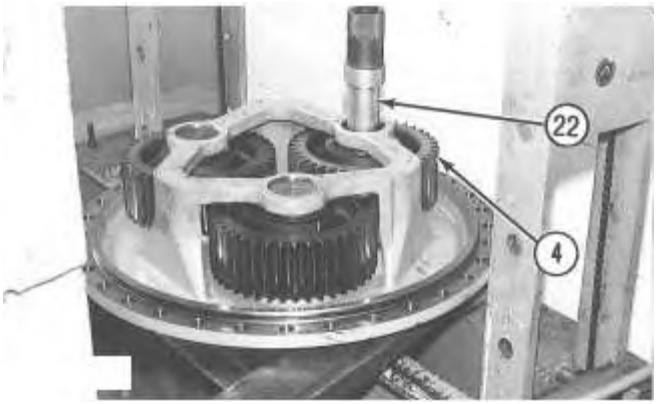

Illustration 11 g00841216

13. Position the planetary carrier in a press. The shaft (22) must be in position with proper support to be a positive stop for the shaft.

NOTICE

The shaft must be correctly installed. If the shaft is incorrectly installed, the bearing preload will be incorrect. This will result in component damage.

14. Position planetary gear (4) in the planetary carrier.

15. Lower the temperature of shaft (22). Use a suitable press to install the shaft in the planetary carrier. After the installation, the end of shaft (22) must be flush with the retainer of the planetary carrier. This will provide the correct bearing preload. The gear must rotate by hand after installation. If the gear does not rotate, the problem must be corrected. Repeat this procedure for all three shafts.

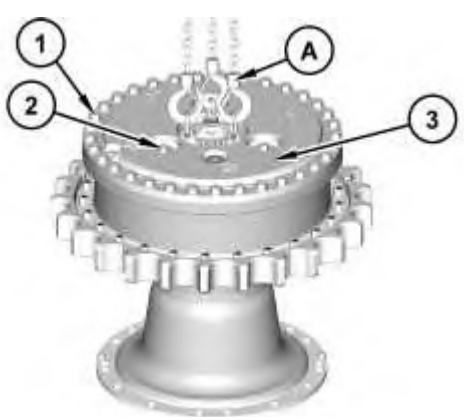

Illustration 12 g01195912

16. Install three retainers (2) on shafts (22).

17. Install Tooling (A). Attach a suitable lifting device to Tooling (A). Install the two O-ring seals on the planetary carrier. Align the drain hole in the planetary carrier with the drain hole in the hub.

18. Position the planetary carrier in the hub.

19. Install bolts (1) that hold planetary carrier (3) to the hub. Remove Tooling (A).

End By:

a. Install the final drives. Refer to Disassembly and Assembly, "Final Drive - Install" for the correct procedure.

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