

Product: TRACK-TYPE TRACTOR

Model: D6T XW TRACK-TYPE TRACTOR WLM

Configuration: D6T TRACK-TYPE TRACTOR XL, XW, LGP WLM00001-UP (MACHINE) POWERED BY C9 Engine

## Disassembly and Assembly D6T Track-Type Tractor Power Train

Media Number -KENR8911-03

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i04905929

# Steering Planetary and Brake - Assemble

SMCS - 4132-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Description	Qty
A	138-7575	Link Bracket	3
D	6V-6640	Sealant	1

**Reference** Refer to Specifications, "Brake and Planetary" in the Service Manual for your machine.



Illustration 1

g00819345

**Note:** Orient the disc spring with the outer edge downward.

1. Install ring (30) and spring (29) in housing (5) .



Illustration 2

g00622157

2. Apply clean oil to seal ring (28) .

**Note:** Orient the seal ring with the lip downward. Refer to Illustration 2.

3. Install seal ring (28) in piston (24) .



Illustration 3

g00622156

4. Install piston (24) and O-ring seal (27) in the housing.
-



Illustration 4

g00622155

5. Lower the temperature of bearing cups (25). Install bearing cups (25) in retainer (23) .

**Note:** Orient the seal ring with the lip downward. Refer to Illustration 4.

6. Apply clean oil to seal ring (26). Install seal ring (26) in retainer (23) .



Illustration 5

g00622132

## **WARNING**

**Improper assembly of parts that are spring loaded can cause bodily injury.**

**To prevent possible injury, follow the established assembly procedure and wear protective equipment.**

7. Install retainer (23) on piston (24). Align the oil passage in retainer (23) with the oil passage and the O-ring seal in the housing. Install bolts (22) .

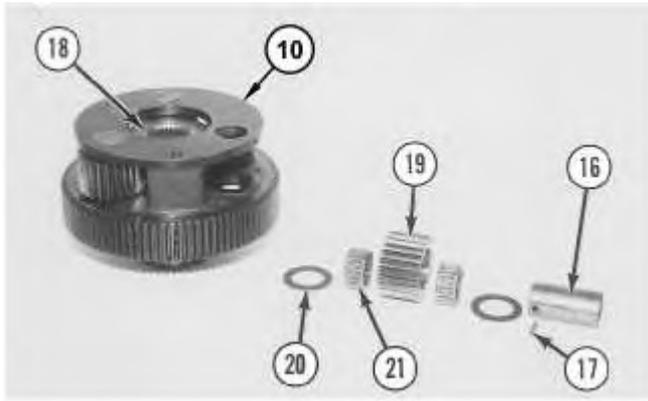


Illustration 6

g01205304

8. Install sun gear (18) in planetary carrier (10) .
9. Install bearings (21) in planetary gear (19) .
10. Install discs (20) and planetary gear (19) in planetary carrier (10). Install shaft (16) .



Illustration 7

g00622128

**Note:** If the rubber in pin (17) is damaged, replace pin (17) .

11. Align the hole in shaft (16) with the hole in planetary carrier (10) and install pin (17). Install pin (17) until the pin is even with the surface of planetary carrier (10) .
  12. Repeat Steps 9 through 11 for the remaining planetary gears.
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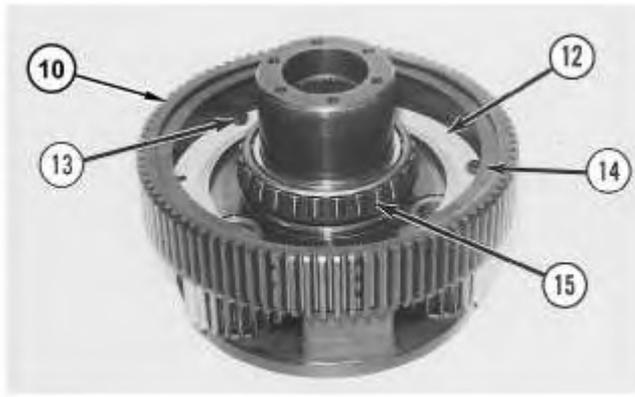


Illustration 8

g01205303

**Note:** If bearing cone (15) was removed from planetary carrier (10), a new bearing must be installed.

13. Raise the temperature of bearing cone (15). Install the bearing cone on planetary carrier (10) .
14. Apply Tooling (D) to the flange of slinger (12) .
15. Install slinger (12) on planetary carrier (10). Install bolts (13). Tighten the bolts to a torque of  $50 \pm 10 \text{ N}\cdot\text{m}$  ( $37 \pm 7 \text{ lb ft}$ ).
16. Install ring (14) in planetary carrier (10) .

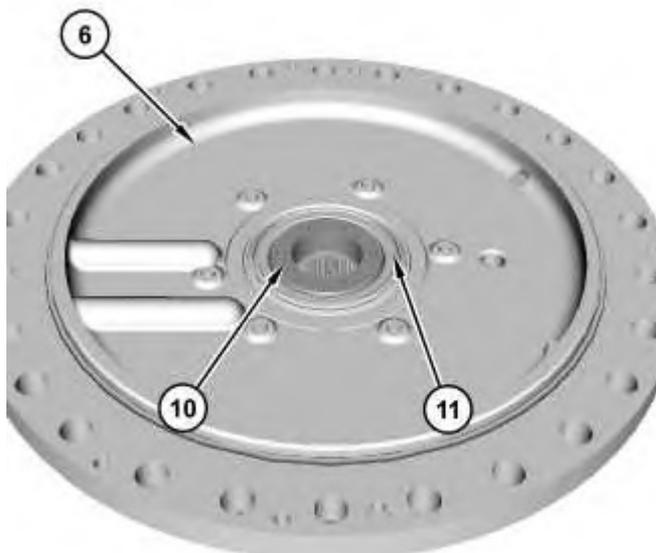


Illustration 9

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17. Position housing (6) on planetary carrier (10) .
18. Raise the temperature of bearing cone (11). Install bearing cone (11) on planetary carrier (10) .

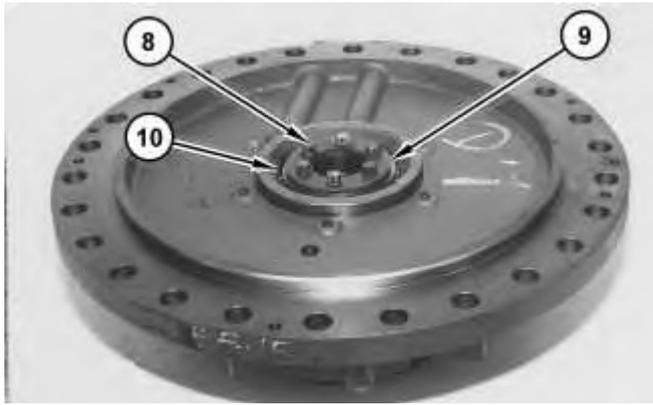


Illustration 10

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19. Position plate (9) onto the planetary carrier (10) .

**Note:** Install shim pack between plate (9) and planetary carrier (10), only if there was a shim pack originally installed in the differential group and if the same planetary carrier is being reused. Shim pack thickness should be 0.31 mm (0.0122inch).

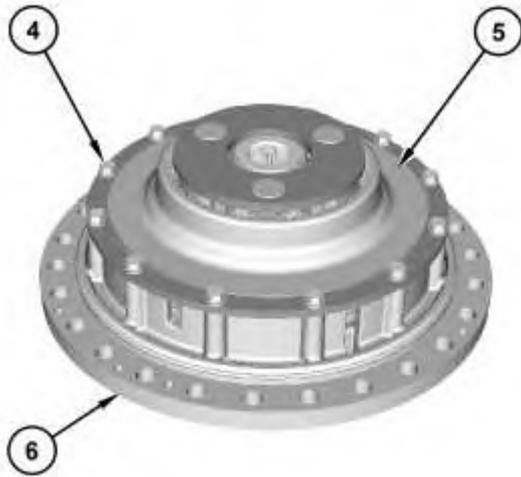
20. Install bolts (8) .



Illustration 11

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21. Install friction discs (7) and brake plates. Alternate the friction discs and the brake plates.
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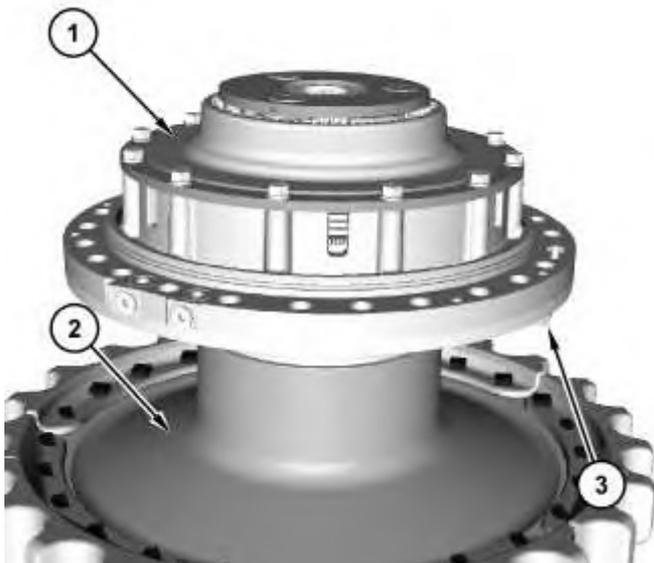


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Illustration 12

g02355596

22. Position ring gear (5) on housing (6) .
23. Install bolts (4). Tighten bolts (4) to a torque of  $135 \pm 20 \text{ N}\cdot\text{m}$  ( $100 \pm 15 \text{ lb ft}$ ).



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Illustration 13

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24. Use a suitable lifting device and Tooling (A) in order to position the planetary group and brake (1) on final drive (2). The weight of the planetary group and brake is approximately 135 kg (300 lb).
25. Install the bolts (3) .

**End By:** Install the final drive, the planetary group, and the brake.

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