



Service Repair Manual

Models

D7R TRACK-TYPE TRACTOR

Product: TRACK-TYPE TRACTOR

Model: D7R TRACK-TYPE TRACTOR 3DN

Configuration: D7R LGP Track-Type Tractor Differential Steering 3DN00001-UP (MACHINE) POWERED BY 3306 Engine

Disassembly and Assembly

D7R Track-Type Tractor

Power Train

Media Number -SEN1706-02

Publication Date -01/01/2004

Date Updated -15/01/2004

i01008136

Final Drive - Assemble

SMCS - 4050-016

Assembly Procedure

Table 1

| Required Tools | | | |
|----------------|-------------|----------------|-----|
| Tool | Part Number | Description | Qty |
| A | 1P-0520 | Driver | 1 |
| B | 1U-6436 | Seal Installer | 1 |
| | 1U-6437 | Seal Installer | 1 |
| C | 138-7574 | Link Bracket | 1 |
| D | 8T-2827 | Spacer | 1 |
| E | 138-7573 | Link Bracket | 3 |
| F | 138-7573 | Link Bracket | 2 |
| G | 138-7575 | Link Bracket | 3 |

Note: Check the O-ring seals for wear and for damage. Replace the O-ring seals, if necessary.

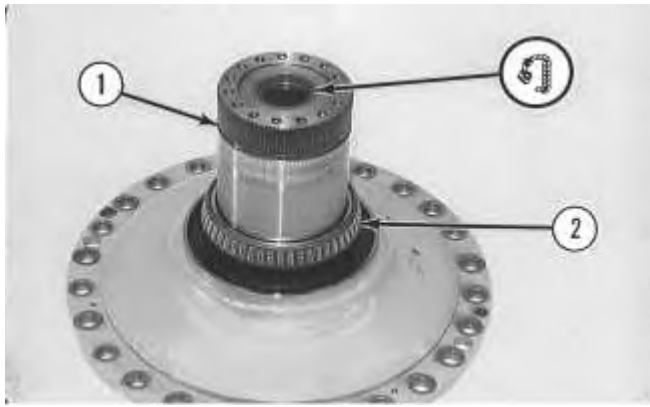


Illustration 1

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1. Use Tooling (A) in order to install the lip seal in hub (1). Apply clean oil to the lip of the seal.
2. Heat bearing cone (2) to a maximum temperature of 135 °C (275 °F). Install bearing cone (2) on hub (1) .



Illustration 2

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3. Use Tooling (B) in order to install the Duo-Cone seal on hub (1) .

Reference See the procedure in Disassembly and Assembly, "Duo-Cone Conventional Seals - Install" in this module.



Illustration 3

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4. Lower the temperature of bearing cups (3). Install the bearing cups in hub (4) .
5. Use Tooling (B) in order to install the Duo-Cone seal on hub (4) .

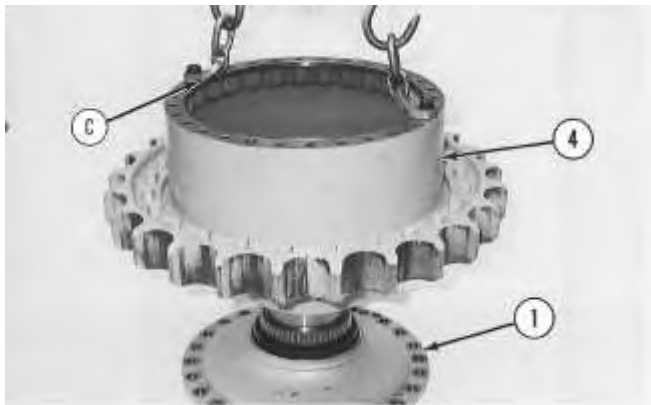
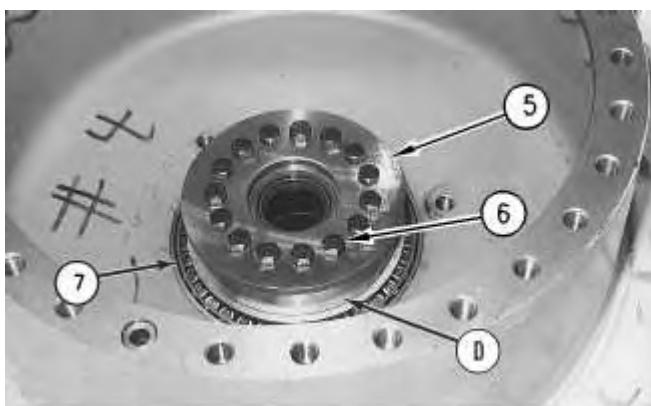


Illustration 4

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6. Attach Tooling (C) and use a hoist in order to install hub (4) on hub (1). The hub weighs approximately 260 kg (580 lb).



- Heat bearing cone (7) to a maximum temperature of 135 °C (275 °F). Install bearing cone (7) on the hub.
- Place Tooling (D) on the bearing cone. Install retainer (5) and bolts (6). Turn the hub as you tighten bolts (6) to a torque of 135 ± 15 N·m (100 ± 11 lb ft). Allow the bearing cone to return to room temperature. Then, remove the retainer and Tooling (D) .

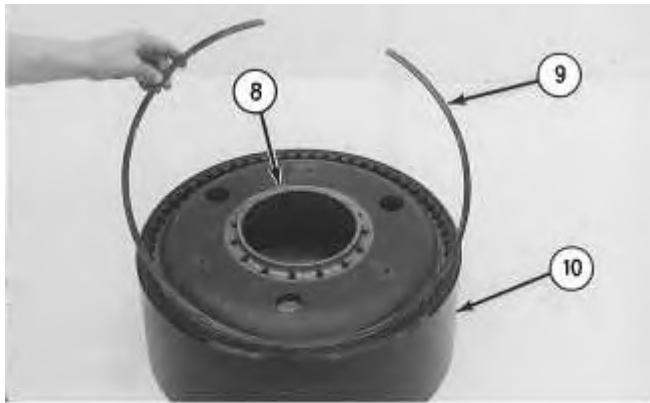


Illustration 6

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- Install hub (8) in ring gear (10). Install retainer (8). The hub weighs approximately 22 kg (48 lb).

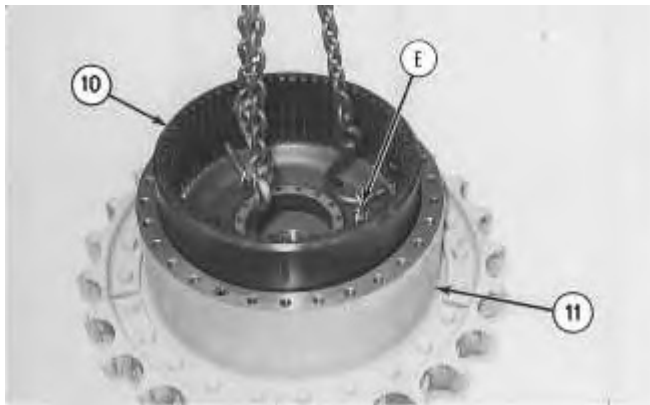


Illustration 7

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- Turn over the unit of hub (8) and of ring gear (9). Attach Tooling (E) and use a hoist in order to install the unit in hub (4). The hub and the ring gear as a unit weigh approximately 73 kg (160 lb).
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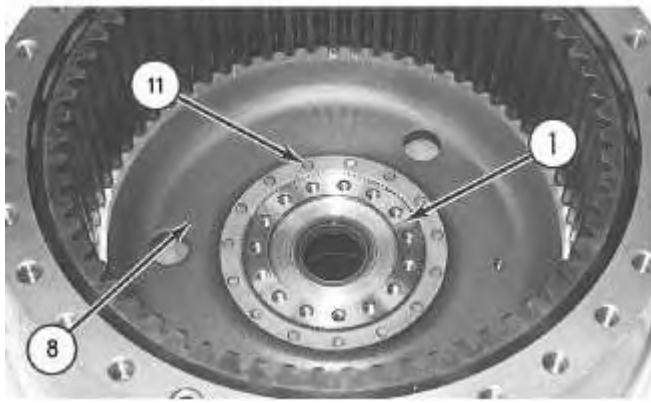


Illustration 8

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11. Insert pins (11) in the hub. Hub (7) should be positioned below the end of hub (1) .

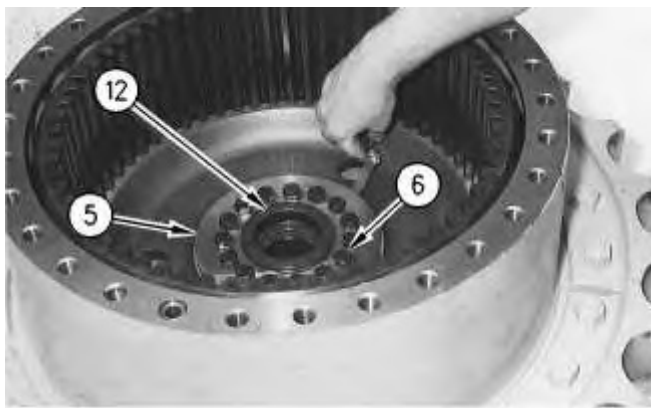


Illustration 9

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12. Use Tooling (A) and a press in order to install ring (12) in retainer (5) .
13. Install retainer (5) and bolts (6) on the hub.

Note: The retainer must be in metal-to-metal contact with the hub.

14. Use a feeler gauge in order to measure the distance between retainer (5) and pins (11). The correct dimension is 0.08 ± 0.05 mm (0.0031 ± 0.0020 inch).

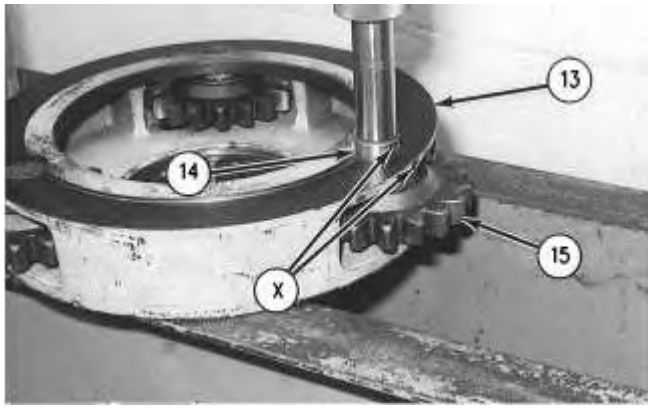


Illustration 10

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15. Install the two bearings in each gear (15) .
16. Install gears (15) in planetary carrier (13) .
17. Lower the temperature of shaft (14). Align hole (X) in shaft (14) with hole (X) in planetary carrier (12). Use a press in order to install shaft (14). Install the roll pin in hole (X) in order to retain shaft (14) .

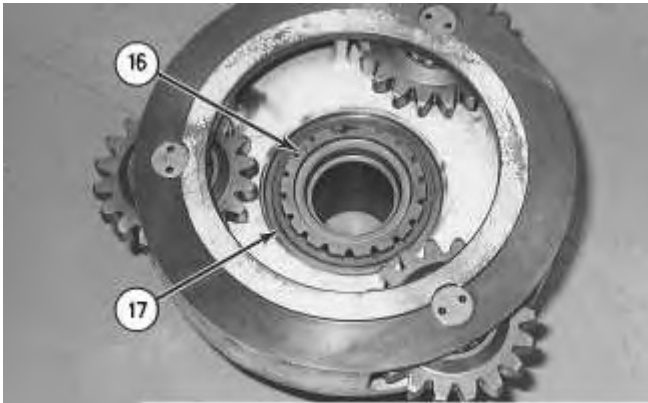


Illustration 11

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18. Use a hoist in order to install planetary carrier (13) on sun gear (16). The weight of planetary carrier is approximately 32 kg (71 lb).
19. Install spiral ring (17) .

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