



Service Repair Manual

Models

**D7R XR TRACK-TYPE
TRACTOR**

Product: TRACK-TYPE TRACTOR

Model: D7R XR TRACK-TYPE TRACTOR DJR

Configuration: D7R TRACK-TYPE TRACTOR STD, XR, LGP DJR00001-UP (MACHINE) POWERED BY C9 Engine

Disassembly and Assembly D7R Track-Type Tractor Power Train

Media Number -UENR0042-02

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i02529261

Final Drive - Assemble

SMCS - 4050-016

Assembly Procedure

Table 1

Required Tooling			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Bracket	3
D	138-7573	Link Bracket	2
E	1P-0520	Driver Group	1
F	138-7573	Link Bracket	3
H	138-7574	Link Bracket	2
J	1U-6437	Seal Installer	1
K	6V-7030	Micrometer Depth Gauge Group	1
L	8T-2827	Spacer	1

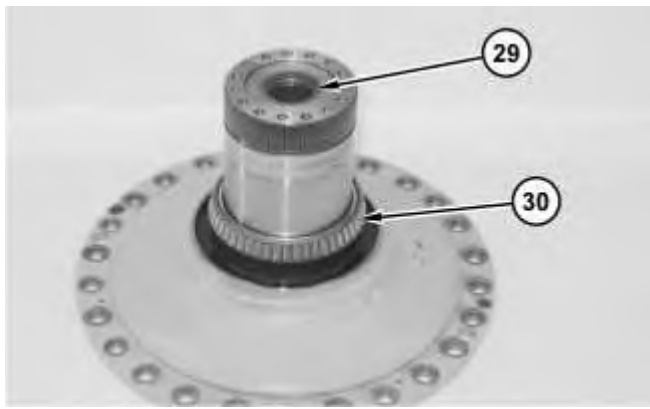


Illustration 1

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1. Use Tooling (A), and install lip seal (29). Place clean oil on the lip of the seal.
2. Raise the temperature of bearing cone (30). Install bearing cone (30).

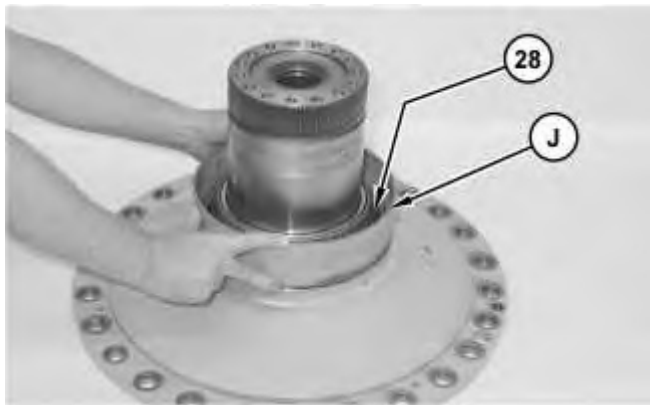


Illustration 2

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3. Use Tooling (J) in order to install the Duo-Cone seal (28). Refer to Disassembly And Assembly, "Duo-Cone Floating Seals - Install".



Illustration 3

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4. Lower the temperature of bearing cups (25) and (27). Install the bearing cups (25) and (27).

5. Use Tooling (J) in order to install the Duo-Cone seal (26).

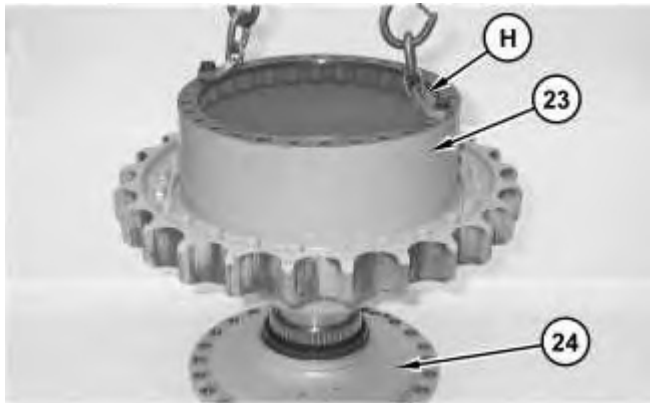


Illustration 4

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6. Attach Tooling (H) and a suitable lifting device to hub (23). The weight of hub (23) is approximately 260 kg (573 lb). Place hub (23) in position on hub (24).

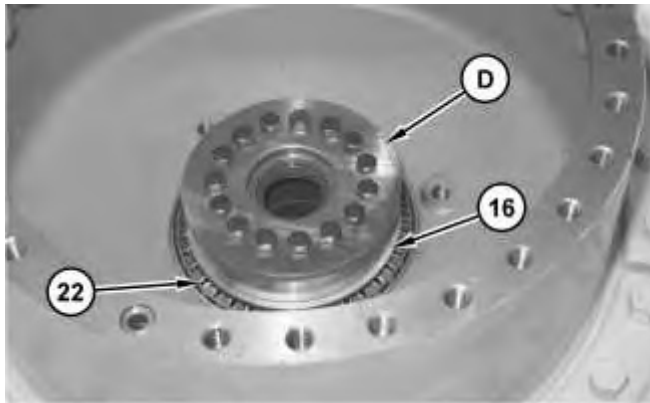
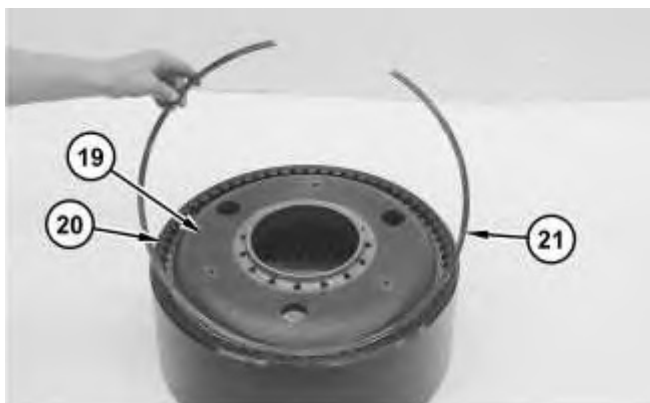


Illustration 5

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7. Raise the temperature of bearing cone (22). Install bearing cone (6) on the hub.
8. Place Tooling (L) in position on bearing cone (22). Install retainer (16). Turn the hub while you are tightening the bolts that hold retainer (16) to a torque of 135 ± 15 N·m (100 ± 11 lb ft). Allow bearing cone (22) to return to room temperature before retainer (16) and Tooling (L) are removed. Remove retainer (16) and Tooling (D).



- Place hub (19) in position in gear (20). Install retainer ring (21).



Illustration 7

- Invert hub (19) and gear (20) and install Tooling (E). Attach a suitable lifting device to Tooling (E) and install hub (19) and gear (20). The weight of hub (19) and gear (20) is approximately 73 kg (161 lb).

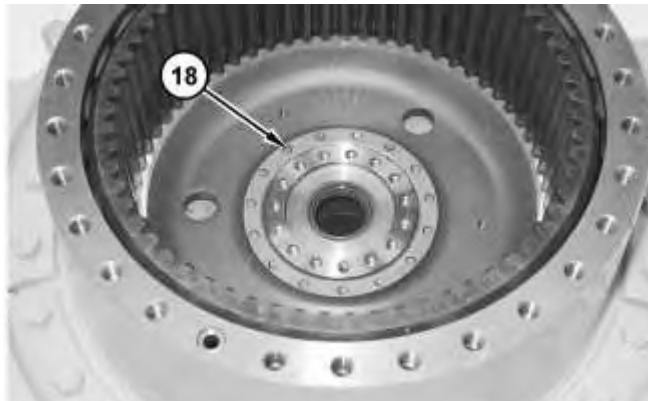


Illustration 8

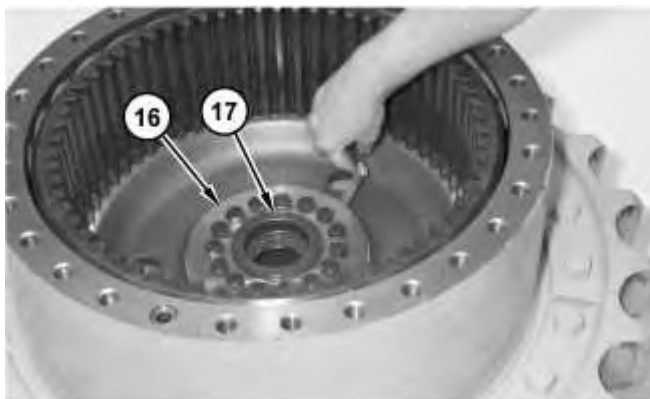


Illustration 9

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