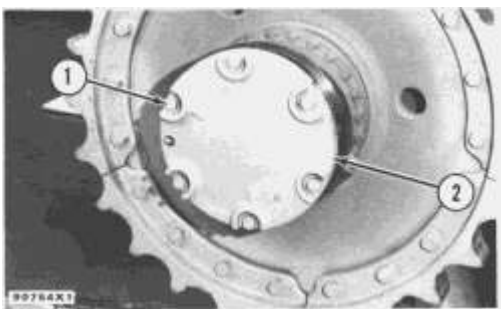


Tools Needed		A	B	C	D	E	F
1P2322	Puller Assembly	1					
8B7560	Step Plate	1	1				
1H3112	Bearing Cup Puller Attachment		1				
5F7379	Bolt		1				
1P492	Plate		1				
8B7548	Puller Assembly			1			
8B7554	Bearing Cup Puller Attachment			1			
7F9306	Wrench				1		
1F7057	Yoke					1	
9S5800	Pump Group						1
9S8900	Cylinder Group						1
1P5590	Adapter						1
5F9879	Adapter						1
8F6220	Nut						1
5F9306	Arm						3
5F9888	Adapter						1
6H4158	Pin						3
7B2499	Ring						6
5F9892	Pin						1

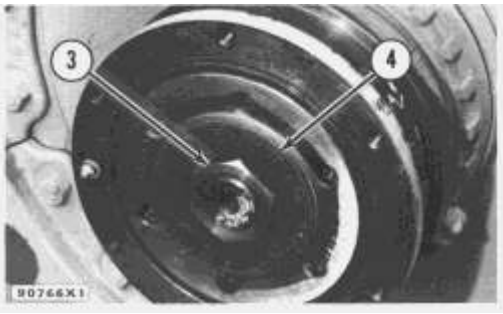
start by:

a) remove track roller frame

1. Drain the oil from the final drive case.



2. Remove bolts (1) from the cap. Remove cap (2).



3. Remove lock (4) and nut (3) from the sprocket shaft.

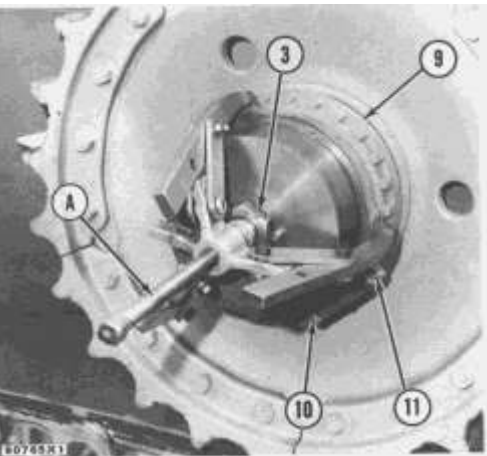


4. Remove retainer (5) and support (6).



5. Remove seal (8) and bearing (7) from the support.

6. Remove the shims that are used for the alignment of the track roller frame.



7. Remove bolt (11) and lock (10) that keeps nut (9) from turning.

NOTICE

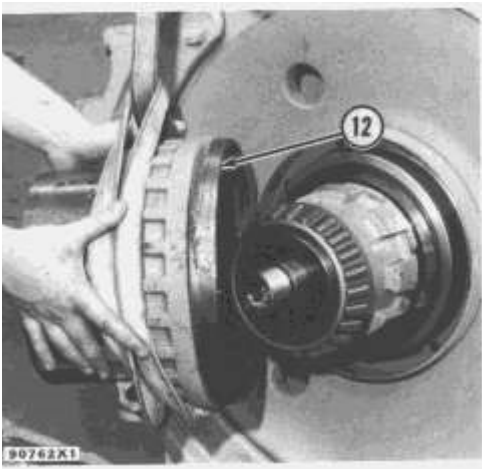
Nut (3) will stop the holder assembly from coming off of the sprocket shaft during removal.

8. Install nut (3) on the end of the sprocket shaft until there is a distance of 1/4 in. (6.3 mm) between the nut and the holder assembly.

9. Install tooling (A) as shown. Remove the holder assembly with tool (A).

NOTE: If necessary, hit the end of the puller with a hammer for complete removal of the holder assembly.

10. Remove tooling (A) and nut (3).



11. Fasten a hoist to holder assembly (12). Weight of the holder assembly is 80 lb. (36.3 kg). Remove the holder assembly.



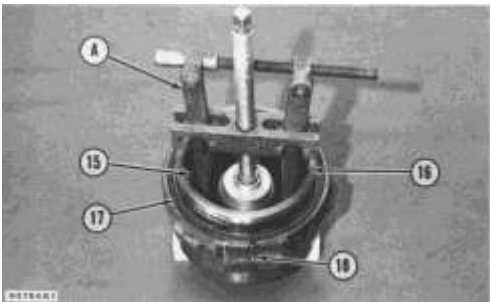
12. Remove Duo-Cone seal (13) from the holder assembly.



13. Remove Duo-Cone seal (14) from the sprocket.

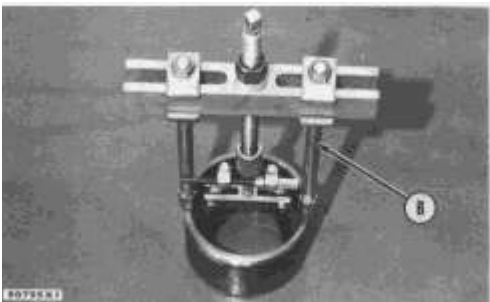
NOTE: Put identification on the Duo-Cone seals to prevent mixing at assembly.

14. Remove the nut used for adjustment of final drive hub bearings from the holder assembly.



15. Remove gasket (17) and seal (18) from the holder assembly.

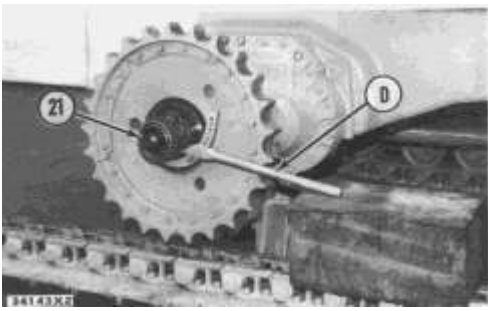
16. Remove cage (16) and bearing cup (15) as a unit with tooling (A).



17. Remove the bearing cup from the cage with tooling (B).



18. Bend lock (20) that prevents nut (19) from turning.

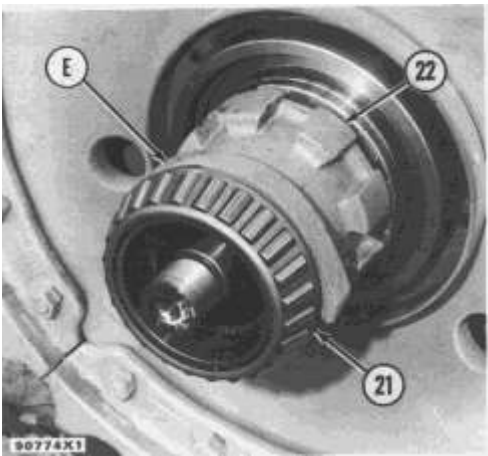


19. Remove bearing (21) as follows:

a) Put tool (D) and a wood block in the position shown.

b) Start the machine. Put the transmission in forward position. Move the sprocket forward until there is a distance of 1 in. (25.4 mm) between the nut and the sprocket.

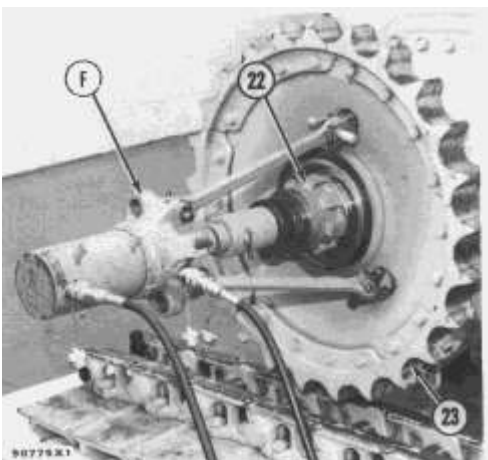
c) Remove tool (D) from the nut.



d) Turn nut (22) in (hand turn) until tool (E) can be installed between bearing (21) and nut (22).

e) Remove the bearing and nut with tool (D). Remove the lock from the sprocket shaft.

20. Install nut (22) on the hub again until there is .25 in. (6.3 mm) clearance between the nut and sprocket.



WARNING

The sprocket is installed on the hub with a pressure of 45 to 50 tons (40.9 to 45.4 M.tons). Nut (22) will keep the sprocket on the hub during removal.

21. Install tooling (F) on the sprocket and hub as shown. Remove sprocket (23).

WARNING

When you are using hydraulic cylinders and puller studs, always ensure that the rated capacity of the puller stud meets or exceeds the rated capacity of the hydraulic cylinder. If the puller stud does not meet or exceed the rated capacity of the hydraulic cylinder, a sudden failure of the puller stud could occur. The sudden failure of the puller stud could result in personal injury or death.

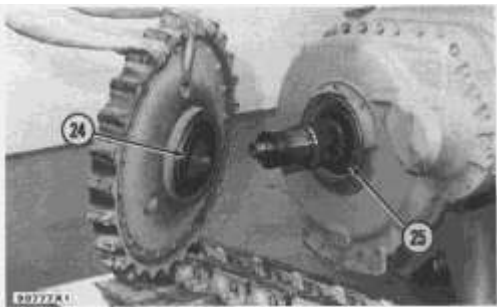
NOTICE

Do not use threaded rods that have not been hardened as tooling with hydraulic cylinders. The maximum rated tonnage should be stamped on one end of the puller studs. Do not use threaded rods that have not been stamped with the rated tonnage.

NOTE: Do not apply more than 6400 psi to tooling (F) as tooling (F) is rated at 70 tons.

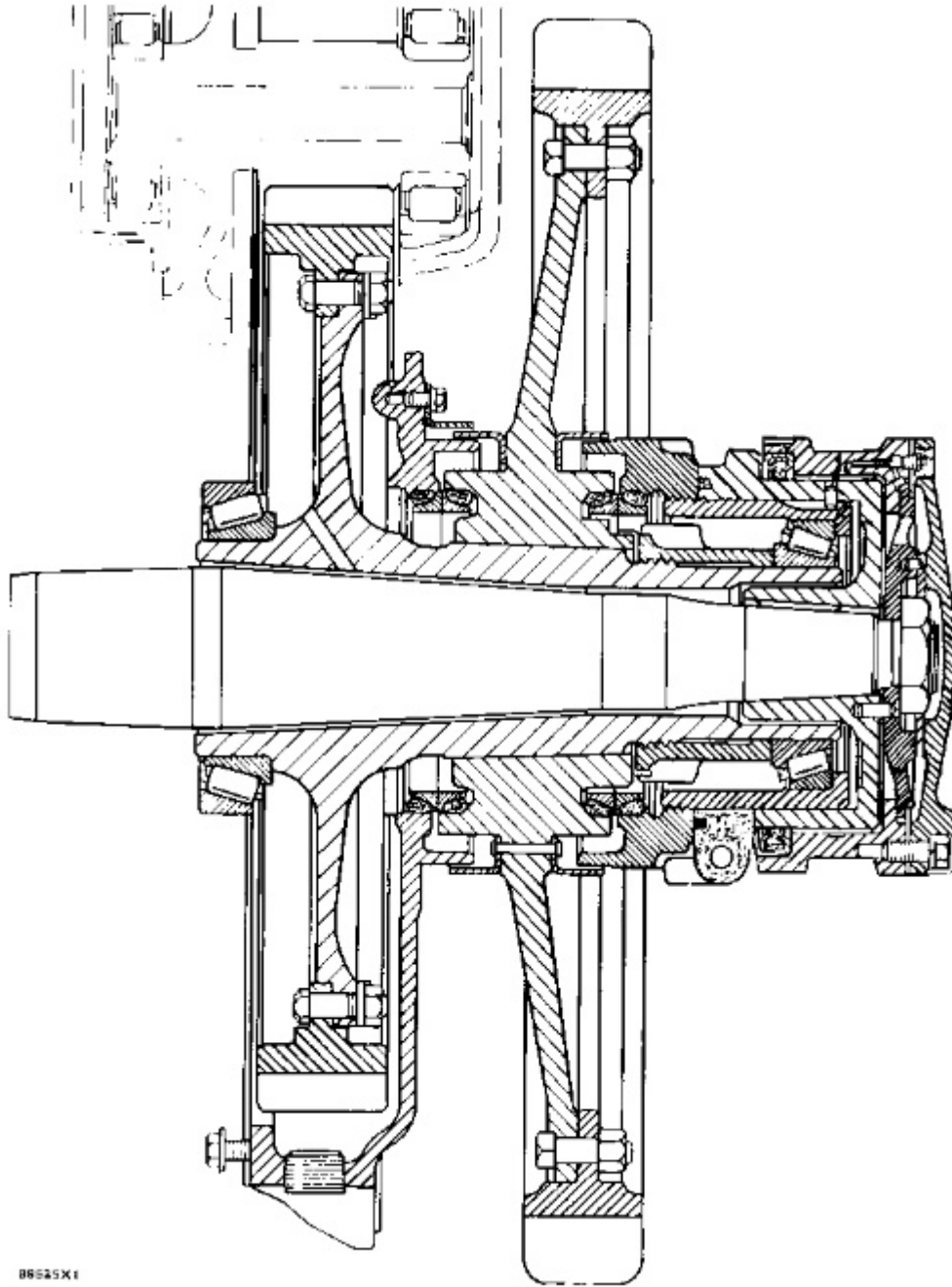
22. Remove tooling (F) and nut (22).

23. Fasten a hoist to the sprocket. Weight of the sprocket is 320 lb. (145 kg). Remove the sprocket from the hub.



24. Remove Duo-Cone seal (24) from the sprocket. Remove Duo-Cone seal (25) from the final drive case.

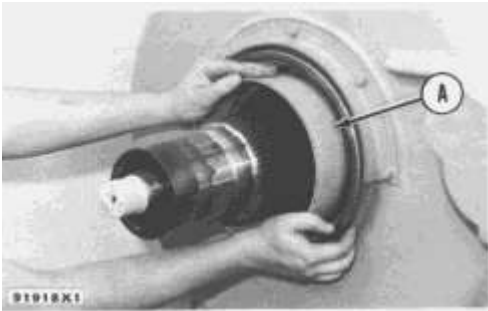
NOTE: Put identification on the Duo-Cone seals to prevent mixing at assembly.



8825X1

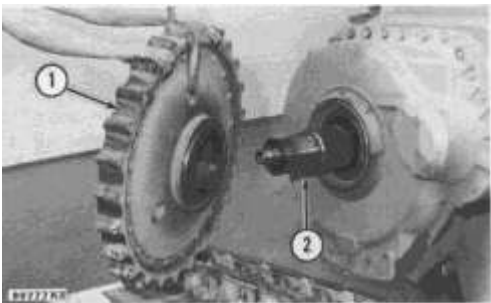
Install Sprocket Assemblies

Tools Needed		A	B	C
8M7911	Seal Installer	1		
9S5800	Pump Group		1	
9S8900	Cylinder Group		1	
5F9888	Adapter		1	
5F9879	Adapter		1	
5F9892	Pin		1	
8M9010	Sleeve		1	
7F5283	Head		1	
7F9306	Wrench			1



1. Install Duo-Cone in the sprocket and final drive case with tool (A).

NOTE: The rubber seals and all of the surfaces that make contact with the rubber seal must be clean and dry. Put clean SAE 30 oil on the contact surfaces of the metal seals.

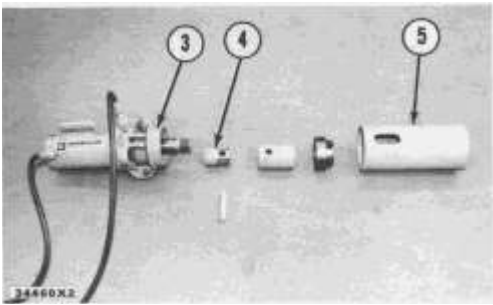


2. Fasten a hoist to sprocket (1). Push the sprocket on hub (2) as far as possible by hand.

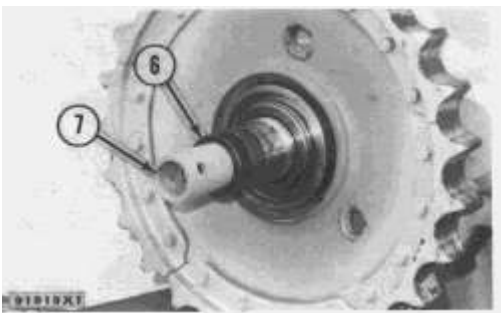
NOTICE

Make sure the splines on the hub are clean and dry.

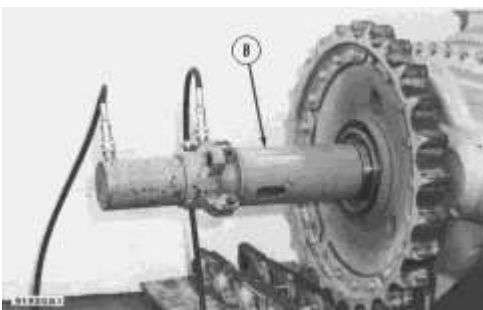
3. Install tooling (B) for installation of the sprocket as follows:



- a) Install head (3) on the cylinder group.
- b) Install adapter (4) on the cylinder group.
- c) Run the cylinder rod out all of the way.



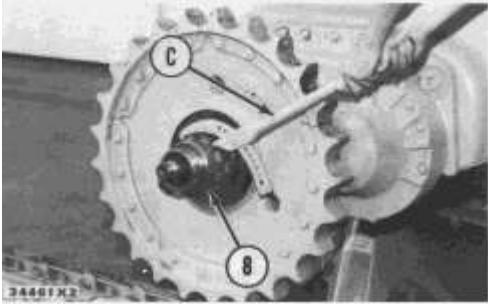
- d) Install adapters (6) and (7) on the sprocket shaft.
- e) Put the sleeve from tooling (B) on the sprocket shaft and connect the cylinder group to the adapters on the sprocket shaft.
- f) Put the pump group in position and put small amount of force on the sprocket.



4. Install the sprocket with tooling (B) with a force of 45 to 50 tons (40.9 to 45.4 M.tons).



5. Remove tooling (B) from the sprocket shaft. Check the distance between the end of the splines on the hub and the end of the splines on the hub and the end of the sprocket. The distance must be $.281 \pm .060$ in. (7.14 ± 1.52 mm).

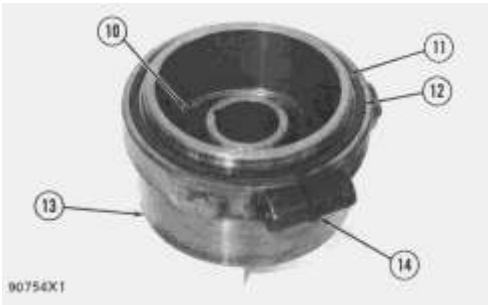


6. Install the lock and nut (8) on the hub. Tighten the nut with tool (C).



7. Heat bearing (9) in oil to a maximum temperature of 275°F (135°C). Install the bearing on the hub and against the nut as shown.

8. Bend the lock over the nut to hold it in position.



9. Lower the temperature of bearing cup (10). Install the bearing cup in cage (11).

10. Put cage (11) in position on holder (13) with the groove in the cage in alignment with the dowel in the holder. Use a soft hammer to install the cage in the holder.

11. Install a new gasket (12) in the holder. Install a new seal (14) in the holder.

NOTE: Put liquid soap on seal (14) before installation.

12. Install the nut on the holder for the outer bearing adjustment.

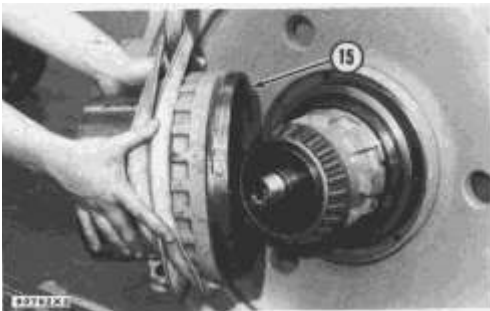


13. Install the Duo-Cone seal in the cage with tool (A).

NOTE: The rubber seals and all of the surfaces that make contact with the rubber seal must be clean and dry. Put clean SAE 30 oil on the contact surfaces of the metal seals.



14. Install the Duo-Cone seal in the sprocket with tool (A).



15. Fasten a hoist to the holder assembly (15). Put the holder assembly on the sprocket shaft.

NOTICE

Make sure the groove in the holder assembly is in alignment with the key on the sprocket shaft.



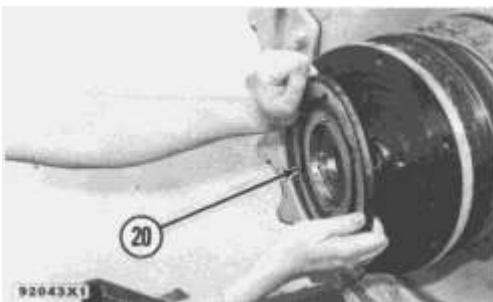
16. Lower the temperature of bearing (16). Install the bearing in the support.

17. Install seal (17) in the support with the lip of the seal toward the outside of the support. The seal is installed even with the outside edge of the support.

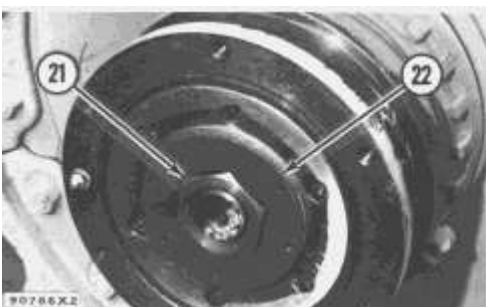


18. Put 1P808 General Purpose Lubricant on the lip of seal (17). Put 1P808 General Purpose Lubricant on the bearing cage holder and the bearing in the support. Install the support (19) on the holder.

19. Install shims (18) for the correct alignment of the track roller frame. See TESTING AND ADJUSTING for the correct procedure for alignment of the track roller frame.



20. Fill the inside of retainer (20) with 1P808 General Purpose Lubricant. Put the retainer in position on the dowels of the holder.



21. Install nut (21). Tighten the nut to a torque of 650 ± 50 lb.ft. (89.9 ± 6.9 mkg). Install lock (22).

22. Install the cap over the support.

23. Make an adjustment to the sprocket hub bearings. See SPROCKET HUB BEARINGS in LUBRICATION AND MAINTENANCE GUIDE.

end by:

a) install track roller frame

Product: TRACK-TYPE TRACTOR
Model: D6C TRACK-TYPE TRACTOR 69U
Configuration: D6C TRACTOR 69U00316-00612 (MACHINE)

Disassembly and Assembly D6 TRACTOR POWER TRAIN

Media Number -REG00856-02

Publication Date -01/11/1974

Date Updated -25/11/2013

REG008560012

Final Drive Cases

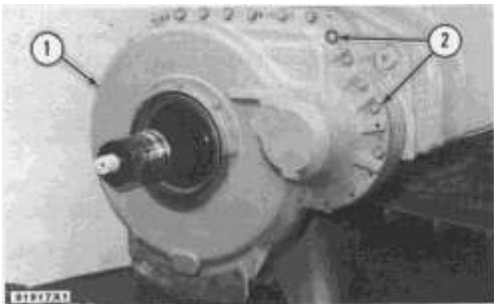
SMCS - 4059-11; 4059-12

Remove Final Drive Cases

start by:

a) remove sprocket assemblies

1. Remove the oil from the final drive case.



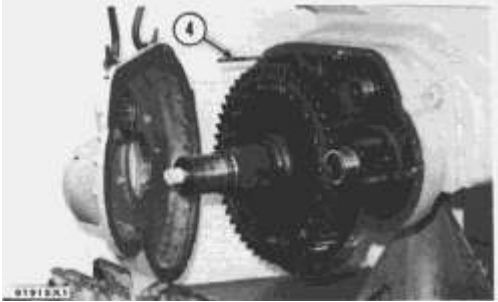
2. Remove bolts (2) and washers that hold the final drive case (1) to the steering clutch case.



3. Install three 1/2"-13 NC forcing screws (3) in the final drive case. Make a separation of the final drive case from the steering clutch case.

WARNING

Do not let the final drive case fall from the dowels of the steering clutch case.



4. Install two 1/2"-13 NC guide pins (4) in the steering clutch case and move the final drive case away from the steering clutch case.
5. Install two 1/2"-13 NC forged eyebolts in the final drive case. Fasten a hoist to the final drive case. Weight of the final drive case is 300 lb. (135 kg). Remove the final drive case (1) from the machine.

WARNING

Do not cause damage to the splines of the sprocket shaft. Do not let the hub and gear fall from the sprocket shaft.

Install Final Drive Cases



1. Clean the machined surfaces of the final drive case and the steering clutch case.
2. Put 7M7260 Liquid Gasket on the machined surfaces of the final drive case and the steering clutch case.
3. Install two 1/2"-13 NC guide pins in the steering clutch case. Fasten a hoist to the final drive case. Put the final drive case in position on the guide pins.

- 4.** Remove the hoist and eyebolts from the final drive case. Push the final drive case on the dowels of the steering clutch case.
- 5.** Install the bolts and washers that hold the final drive case to the steering clutch case. Tighten the bolts to a torque of 100 ± 10 lb.ft. (13.8 ± 1.4 mkg).
- 6.** Fill the final drive case with oil to the correct level. See LUBRICATION AND MAINTENANCE GUIDE.

end by:

- a)** install sprocket assemblies
-

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