

Product: TRACK-TYPE TRACTOR

Model: D8R TRACK-TYPE TRACTOR T5X

Configuration: D8R TRACK-TYPE TRACTOR T5X00001-UP (MACHINE) POWERED BY 3406C Engine

## Disassembly and Assembly D8R Track-Type Tractor Power Train

Media Number -UENR1377-00

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i01022178

# Track Roller - Assemble

SMCS - 4180-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Description	Qty
A	1U-8840	Seal Installer	1
	8T-0534	Gauge	1
B	FT-1028	Sleeve	1
C	5P-7419	Plug Installer	1
D	FT-0575	Test Tool	1
E	8T-5096	Dial Indicator	1

**Reference:** See the procedure in Disassembly and Assembly, "Duo-Cone Conventional Seals - Install" in this module before you assemble the track rollers.

**Reference:** Refer to Specifications, SENR8324, "Track Rollers" in the Service Manual for your machine.

1. Clean the components. Inspect the components for wear and for damage. Replace any worn components or any damaged components.
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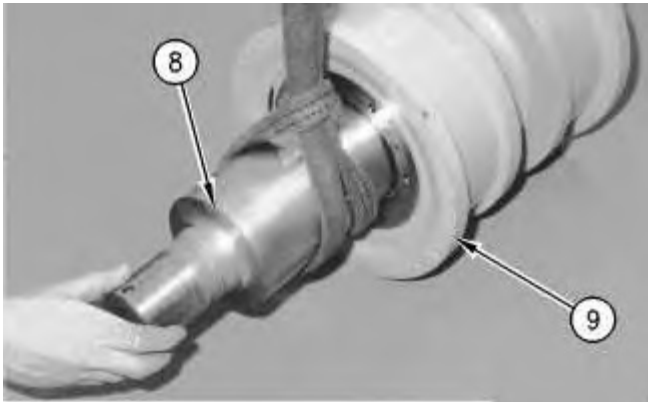


Illustration 1

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## NOTICE

**Follow this step carefully to avoid damage to the components during assembly.**

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**Note:** The shaft weighs 22 kg (49 lb).

2. Fasten a hoist to shaft (8). Carefully install the shaft in track roller (9).



Illustration 2

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**Note:** Early track rollers have no toric stabilizers (7).

3. Install toric stabilizers (7) on both ends of shaft (8).

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

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Illustration 3

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4. Install toric ring (10) in seal ring (6). Make sure that the toric ring is straight in seal ring (6).

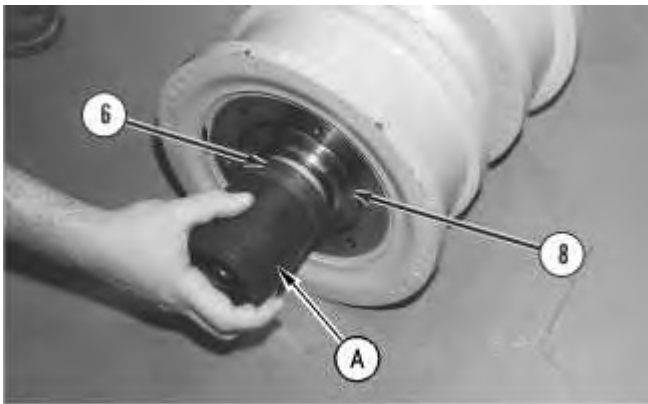


Illustration 4

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5. Use tool (A) to install the toric ring and seal ring (6) on shaft (8). Install the ring until tool (A) makes contact with the end of the shaft.



Illustration 5

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6. Use a depth micrometer (11) to measure the distance between seal ring (6) and the shaft. Measure the distance at four locations that are separated by 90 degrees. The difference in these measurements must not be more than 0.8 mm (0.0315 inch).

7. If adjustments to seal ring (6) are necessary, use tool (A) to adjust the seal ring on the shaft.
8. Repeat Steps 5 through 7 for installation of the toric ring. Also, install the seal ring on the other side of the track roller.



Illustration 6

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9. Install O-ring seal (12) on seal ring (4). Make sure that the O-ring seal is straight on the seal ring.

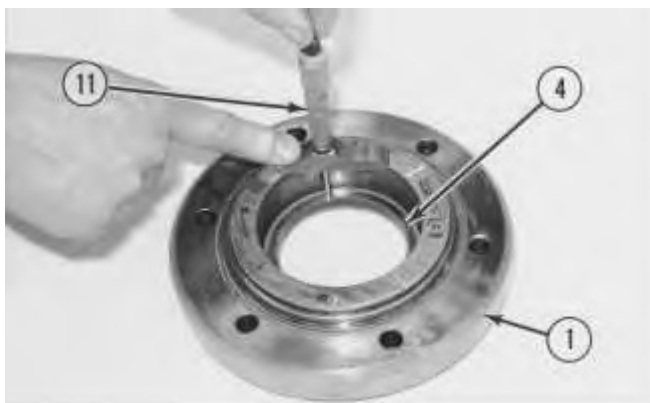


Illustration 7

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10. Lubricate the O-ring seal on the seal ring with isopropyl alcohol.
  11. Position the O-ring seal and seal ring (4) in retainer (1). Use tool (A) to install the seal ring in the retainer. Install the O-ring seal and seal ring (4) until the O-ring seal makes contact with the bottom of the retainer.
  12. Use depth micrometer (11) to measure the distance from the surface of the retainer to the surface of seal ring (4). Measure the distance at four locations that are separated by 90 degrees. The difference in these measurements must not be more than 0.08 mm (0.0315 inch).
  13. If adjustments to the seal ring are necessary, use tool (A) to adjust the seal ring in the retainer.
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