

Specifications

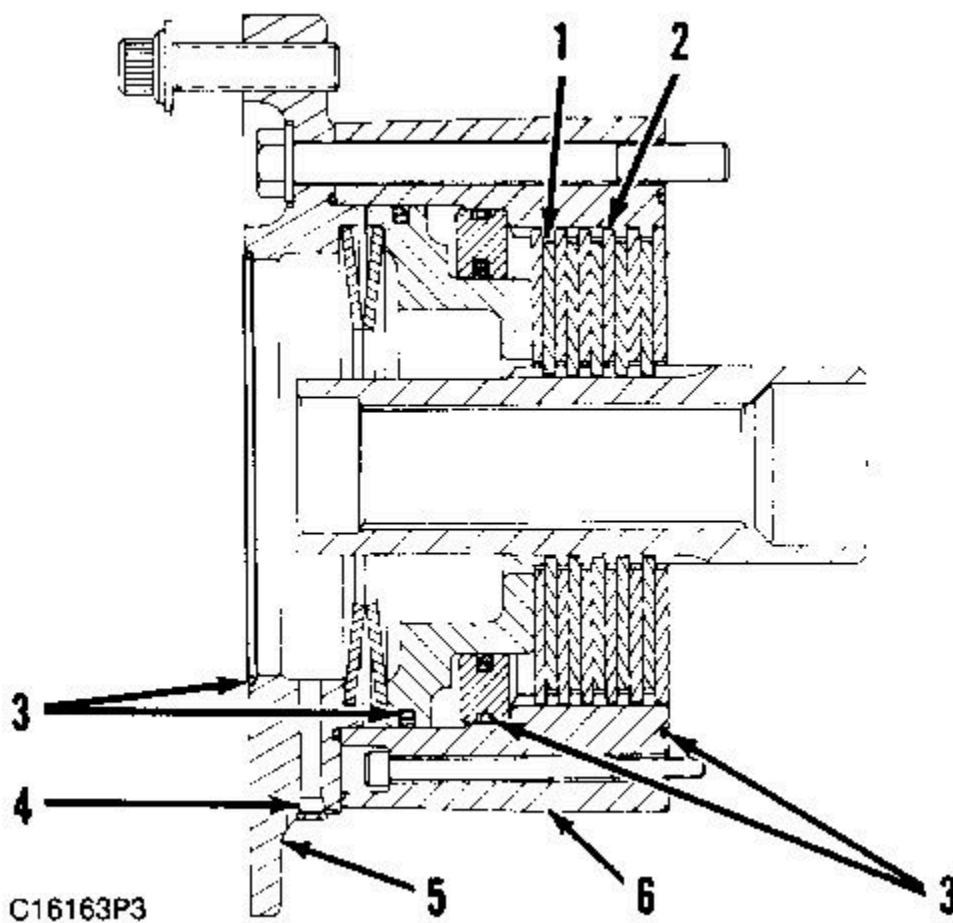
215D, 219D, 225D, 231D, 235C, 245B, 235D, 245D EXCAVATOR ATT
Media Number -SEN4943-01 Publication Date -01/04/1992

Date Updated -16/04/2009

SEN49430007

Track Brake (Part of 4E7481 Frame Arrangement) 9U2111

SMCS - 5050



Typical Example

1. Before assembly, put five discs (1) and six plates (2) in SAE 30 CD oil.
2. Lubricate seals (3) with lubricant being sealed.
3. Apply 1U8846 Gasket Maker to adapter (5) side mounting surface of housing assembly (6).
4. After the track motor has been installed, add 1.0 liter (.26 U.S. gal.) of SAE 30 CD oil through hole (4).

Specifications

215D, 219D, 225D, 231D, 235C, 245B, 235D, 245D EXCAVATOR ATT
Media Number -SENR4943-01

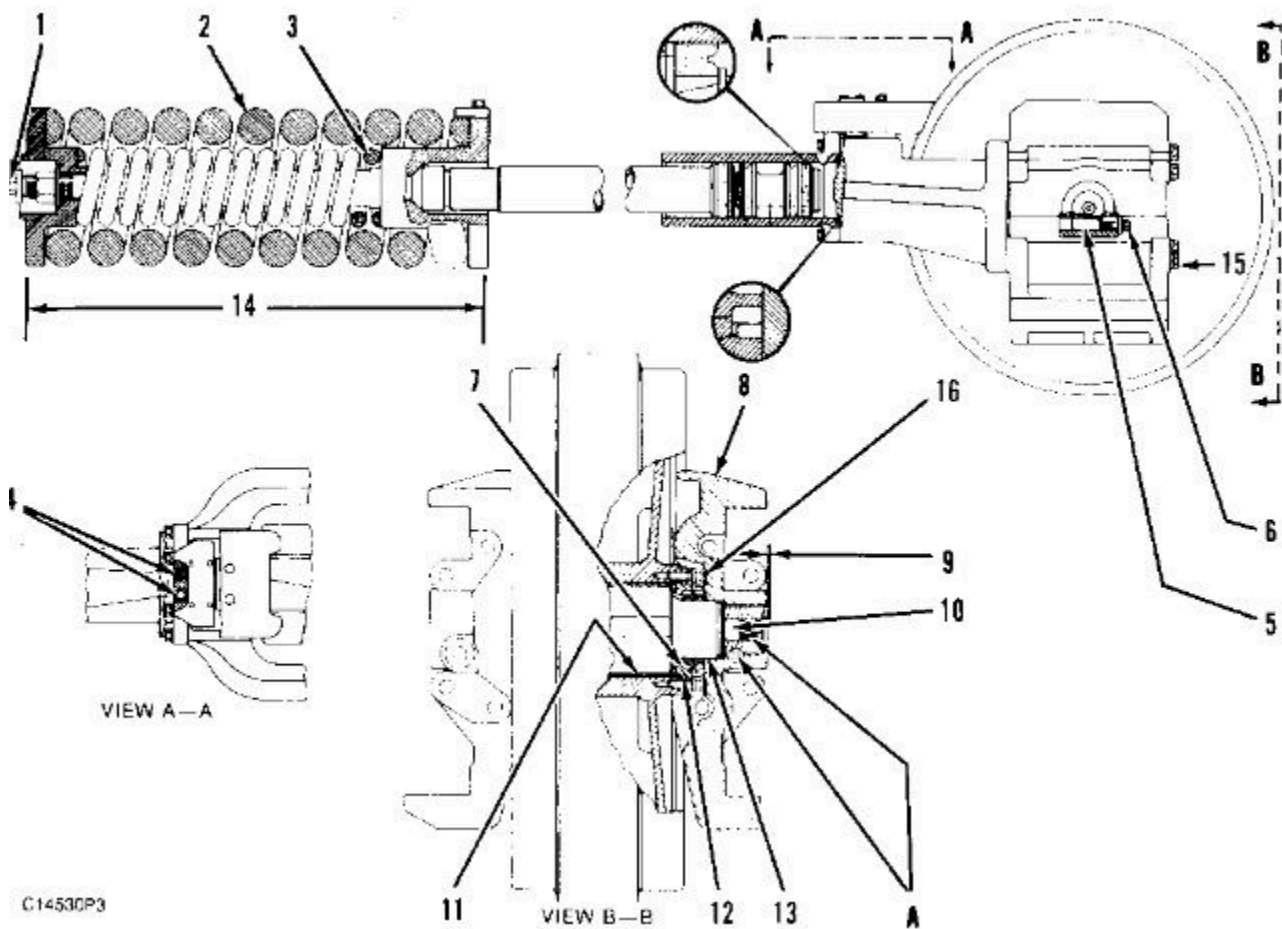
Publication Date -01/04/1992

Date Updated -16/04/2009

SENR49430010

Front Idler 9U0938 (Part of 4E7481 Frame Arrangement)

SMCS - 5050



(1) After assembly, loosen nut (1) until it is beyond the end of the recoil spring bolt ... 1.5 ± 0.3 mm ($.06 \pm .01$ in)

(2) 8K4103 Recoil Spring (outer):

Length installed ... 822.5 mm (32.38 in)

Free length ... 985.5 mm (38.80 in)

Force after installation ... 327 ± 26 kN (36.8 ± 2.9 tons)

Outside diameter ... 304.8 mm (12.00 in)

(3) 8K4102 Recoil Spring (inner):

Length under test force ... 591.3 mm (23.28 in)

Test force ... 63 ± 5 kN ($7 \pm .6$ tons)

Free length after test ... 744.7 mm (29.32 in)

Outside diameter ... 152.4 mm (6.00 in)

(4) Torque for four valves ... 34 ± 7 N·m (25 ± 5 lb ft)

(6) Torque taper lockpin bolts:

Apply 5P3931 Anti-Seize Compound to lockpin (5) and torque to ... 100 ± 15 N·m (75 ± 11 lb ft)

Hammer lock pin in place.

Torque bolt again to ... 100 ± 15 N·m (75 ± 11 lb ft)

(7) Rubber toric seals and all surfaces in contact with them must be clean and dry assembly. Put a thin layer of oil on the contacting surfaces of the metal seals just before installation. Lubricate all other seals at assembly.

Apply 5P3931 Anti-Seize Compound to surface A of bearings (8).

Put SAE 30 CD oil on the surface of bushing assemblies (11) and seals (12) and (13).

(9) End play

Maximum: 0.89 mm (.035 in)

Minimum: 0.15 mm (.006 in)

(10) Put SAE 30 CD oil in shaft ... 950 ± 25 ml ($2.01 \pm .05$ pt.)

(14) Assembly length ... 886 ± 5 mm ($34.9 \pm .2$ in)

(15) Torque for 16 bolts ... 480 ± 48 N·m (350 ± 35 lb ft)

(16) Torque for 24 bolts ... 135 ± 20 N·m (100 ± 14.80 lb ft)

Specifications

215D, 219D, 225D, 231D, 235C, 245B, 235D, 245D EXCAVATOR ATT

Media Number -SEN4943-01

Publication Date -01/04/1992

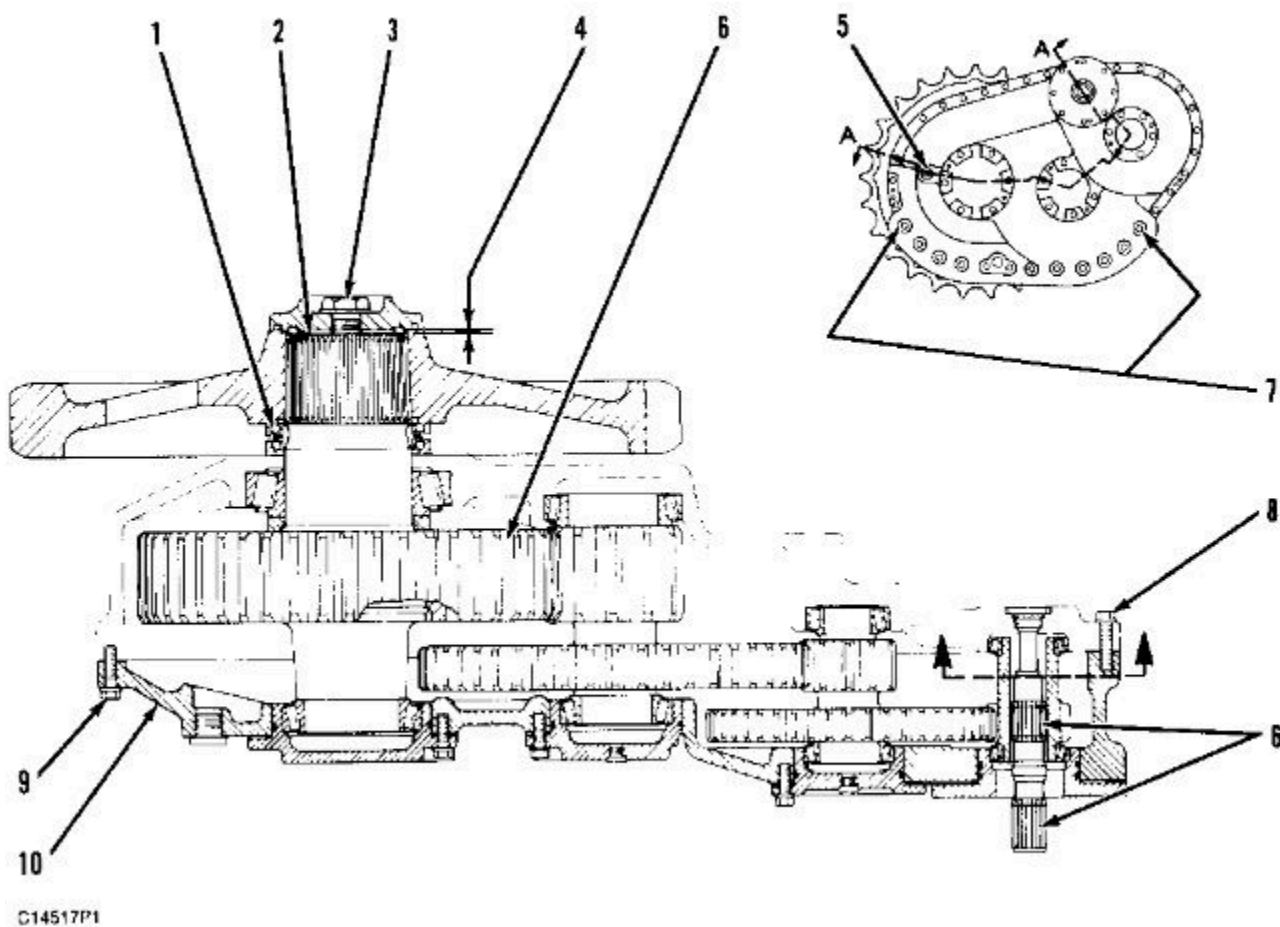
Date Updated -16/04/2009

SEN49430011

Final Drive

9U0701 (Part of 4E7481 Frame Arrangement)

SMCS - 5050



(1) Rubber toric seals and all surfaces in contact with them must be clean and dry at assembly. Put a thin layer of oil on the contacting surfaces of metal seals just before installation. Lubricate all other seals at assembly. Seal rings must be assembled square with the bore and thus must not be bulged or twisted. Before installing cages and smaller covers, lubricate the respective bores with lubricant being sealed.

(3) Torque for bolt ... 2440 ± 270 N·m (1810 ± 200 lb ft)

(4) Distance between the sprocket shaft and retainer should be 2.7 ± 1.9 mm ($.11 \pm .07$ in) after the sprocket is pressed on with a force of ... 550 to 590 kN (61.6 to 66.0 tons)