

Product: WHEEL SCRAPER  
Model: 631G WHEEL SCRAPER DEM  
Configuration: 631G Wheel Scraper DEM00001-UP (MACHINE)

## Disassembly and Assembly 631G Wheel Tractor-Scraper Power Train

Media Number -REN8604-01

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i06636123

# Torque Converter - Assemble

SMCS - 3101-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	2P-8312	Retaining Ring Pliers	1
B	1P-0510	Driver Group	1

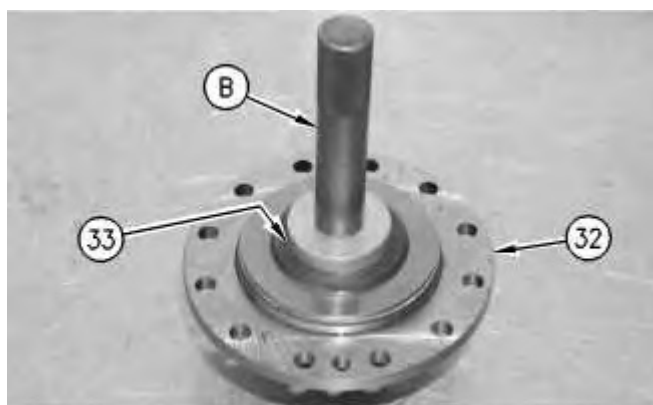


Illustration 1

g00528674

1. Use Tooling (B) and a suitable hydraulic press to install sleeve bearing (33) into flange (32).

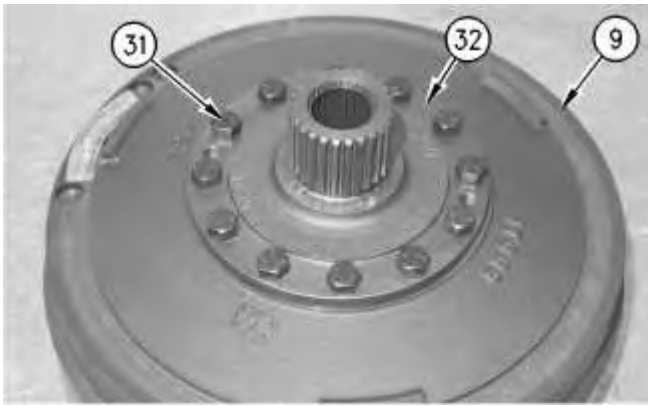


Illustration 2

g00528612

2. Position flange (32) and install bolts (31) onto housing (9). Tighten bolts (31) to a torque of  $120 \pm 15 \text{ N}\cdot\text{m}$  ( $89 \pm 11 \text{ lb ft}$ ).



Illustration 3

g00525322

3. Install thrust bearing (29) and thrust race (30) into housing (9).

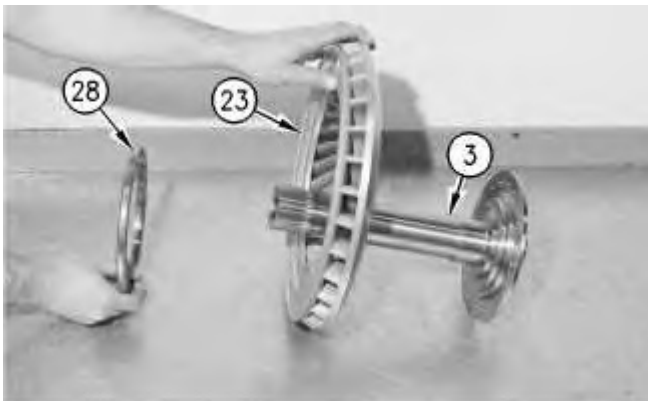


Illustration 4

g00525321

4. Install turbine (23) and clamp ring (28) onto hub (3).

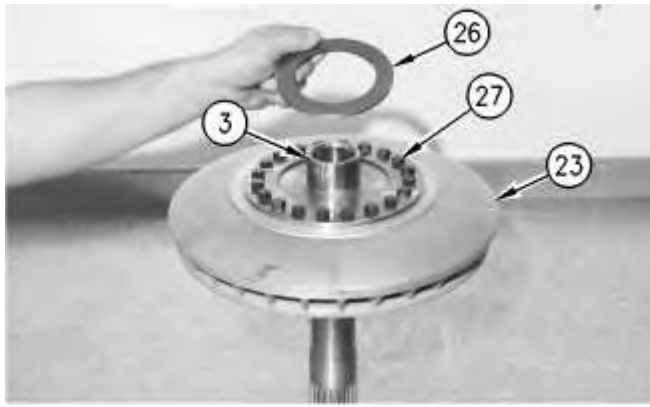


Illustration 5

g00525320

5. Install bolts (27) into turbine (23). Tighten bolts (27) to a torque of  $50 \pm 7 \text{ N}\cdot\text{m}$  ( $37 \pm 5 \text{ lb ft}$ ). Install thrust race (26) onto hub (3).

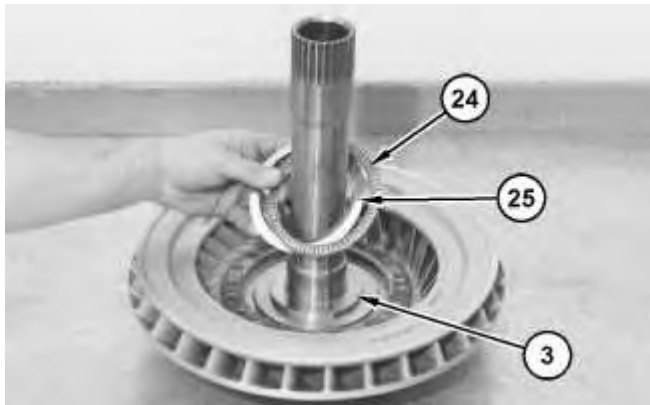


Illustration 6

g01102582

6. Install thrust race (25) and thrust bearing (24) onto hub (3).

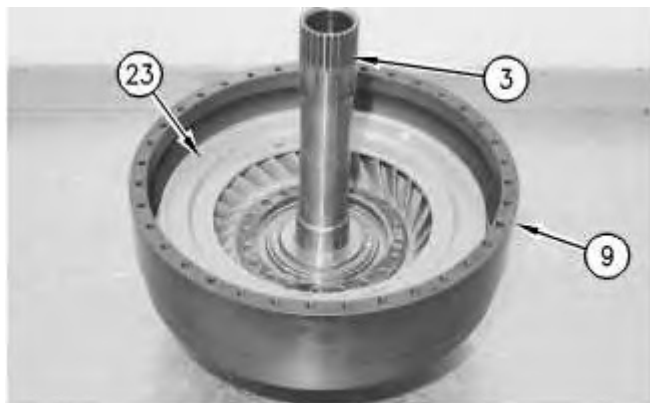


Illustration 7

g00525315

7. Install turbine (23) and hub (3) as a unit into housing (9).

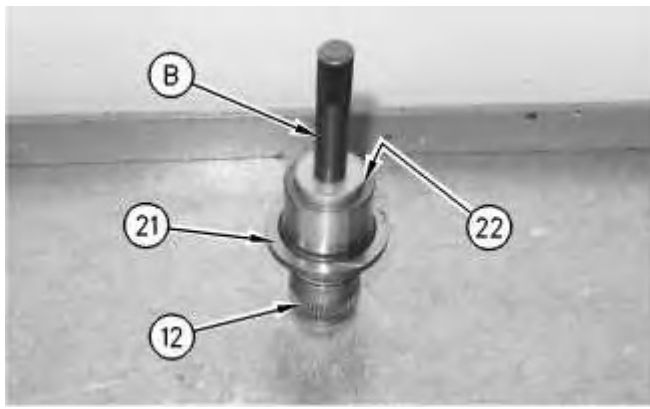


Illustration 8

g00528953

8. Use Tooling (B) and a suitable press to install sleeve bearing (22) into carrier assembly (12). Install thrust bearing (21) onto carrier assembly (12).

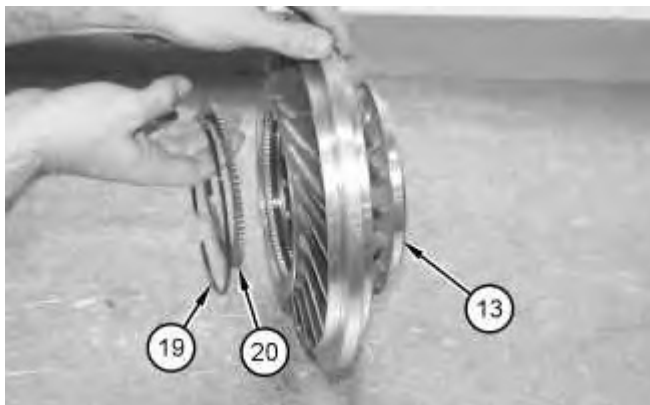


Illustration 9

g01110492

9. Install side plate (20) to stator (13). Use Tooling (A) to install retaining ring (19) to stator (13).

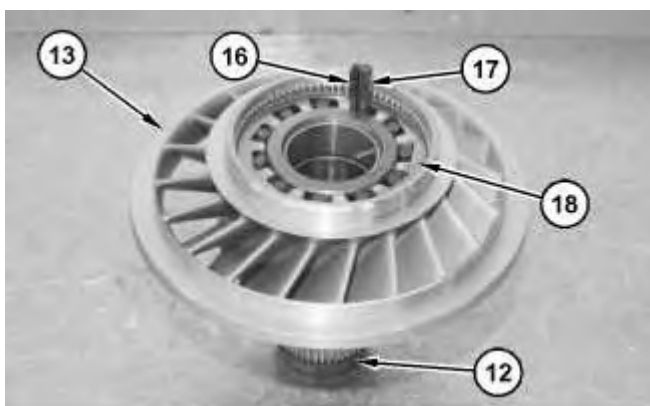


Illustration 10

g01102579

10. Use Tooling (B) and a suitable hydraulic press to install freewheel cam (18) into stator (13).

11. Install stator (13) to carrier assembly (12). Install freewheel springs (16) and freewheel rollers (17) to freewheel cam (18). Always install new freewheel springs (16) and freewheel rollers (17). Install freewheel springs (16) with the maximum number of loops in freewheel springs (16) to the outside of freewheel cam (18). Stator (13) should turn freely in the clockwise direction. Stator (13) should not turn freely in the counterclockwise direction.

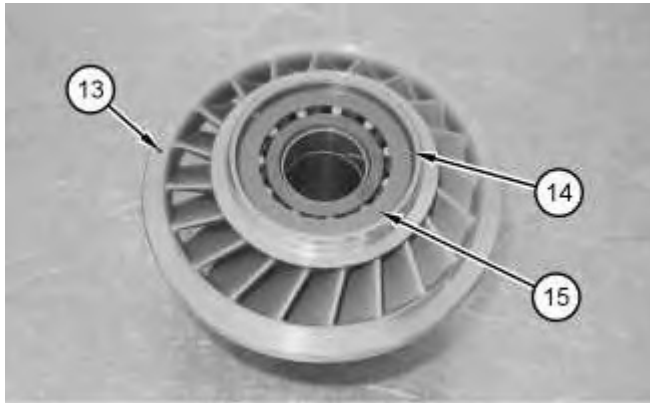


Illustration 11

g01110494

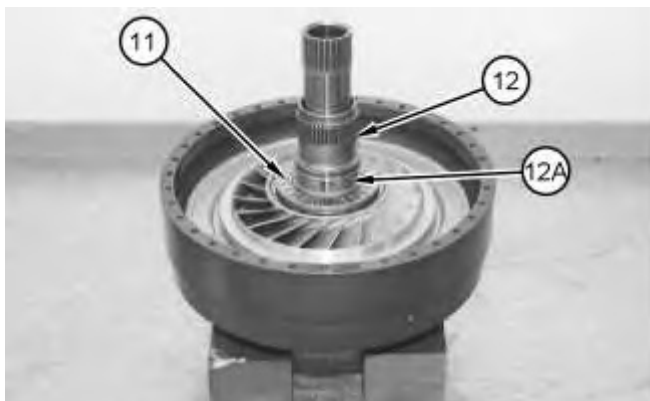
12. Install thrust race (15) to stator (13). Use Tooling (A) to install retaining ring (14) onto stator (13).



Illustration 12

g00525308

13. Install carrier assembly (12) and stator (13) as a unit into housing (9).



14. Install thrust bearing (11) and seal ring (12A) onto carrier assembly (12).

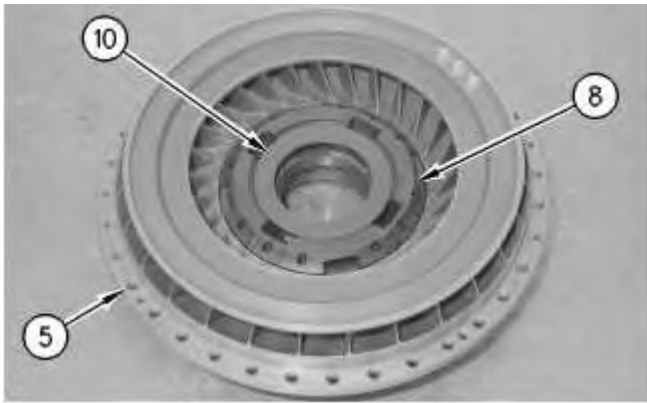


Illustration 14

g00525305

15. Install impeller hub (8) to impeller (5). Install thrust race (10) onto impeller (5).

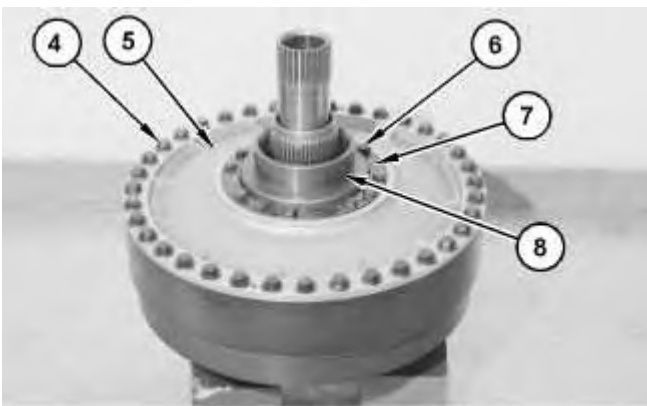
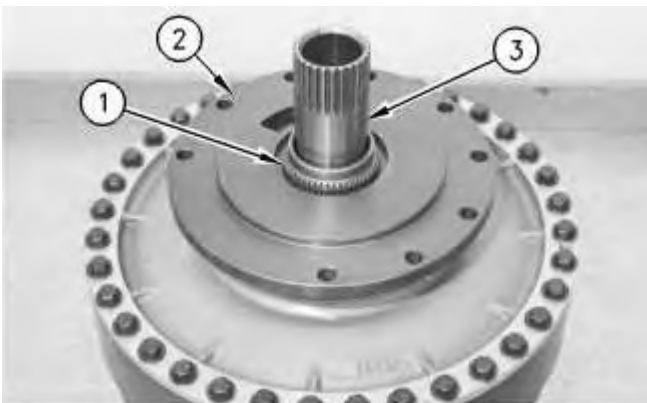


Illustration 15

g01102576

16. Install clamp plate (7) and bolts (6) onto impeller hub (8). Tighten bolts (6) to a torque of  $50 \pm 7 \text{ N}\cdot\text{m}$  ( $37 \pm 5 \text{ lb}\cdot\text{ft}$ ).
17. Install bolts (4) into impeller (5). Tighten bolts (4) to a torque of  $50 \pm 7 \text{ N}\cdot\text{m}$  ( $37 \pm 5 \text{ lb}\cdot\text{ft}$ ).



18. Use Tooling (B) and a suitable press to install the sleeve bearing in carriage support assembly (2). Install the sleeve bearing until the sleeve bearing is flush with the outside machined surface of carriage support assembly (2).
19. Install carriage support assembly (2) onto hub (3). Use Tooling (A) to install retaining ring (1) onto carriage support assembly (2).

**End By:**

- a. Install the torque converter. Refer to Disassembly and Assembly, "Torque Converter - Install".

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