



Service Repair Manual

Models

641B and 651B
WHEEL TRACTOR

Product: WHEEL TRACTOR
Model: 641B WHEEL TRACTOR 65K
Configuration: 641B & 651B TRACTORS 65K00001-00984 (MACHINE)

Disassembly and Assembly 3406E and 3456 Engines for Caterpillar Built Machines

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i02241902

Gear Group (Front) - Install

SMCS - 1206-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
B	9S-3263	Thread Lock Compound	1
C	8T-2998	Lubricant	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

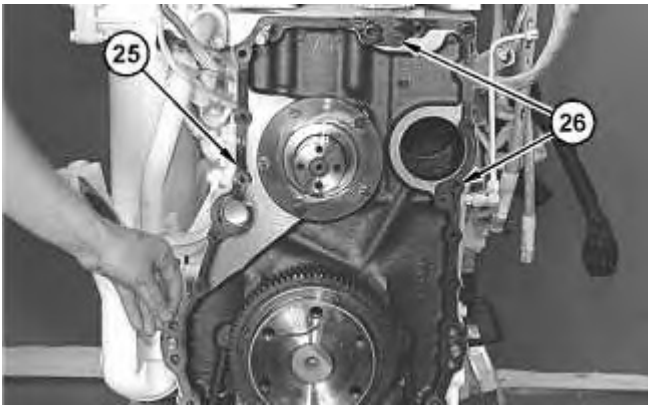


Illustration 1

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1. Thoroughly clean the gasket material from the cylinder block.
2. Install a new gasket (25) and O-ring seals (26) on the cylinder block.

Note: On newer blocks, an integral seal is used instead of O-ring seals (26) and gasket (25) .

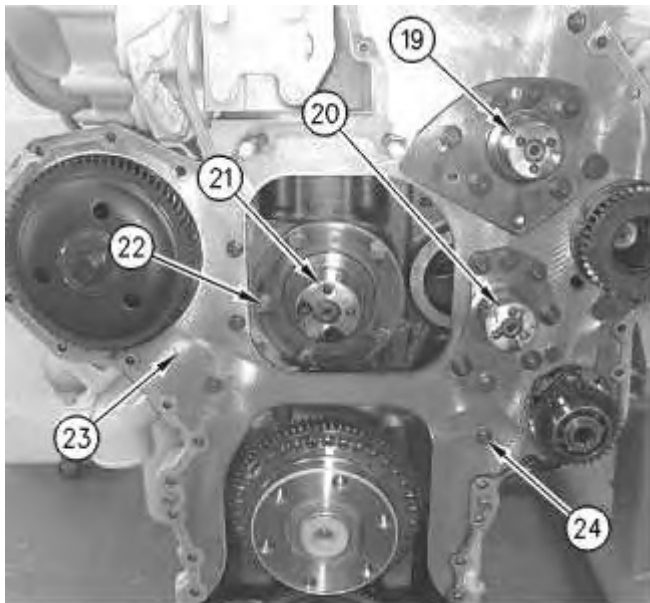


Illustration 2

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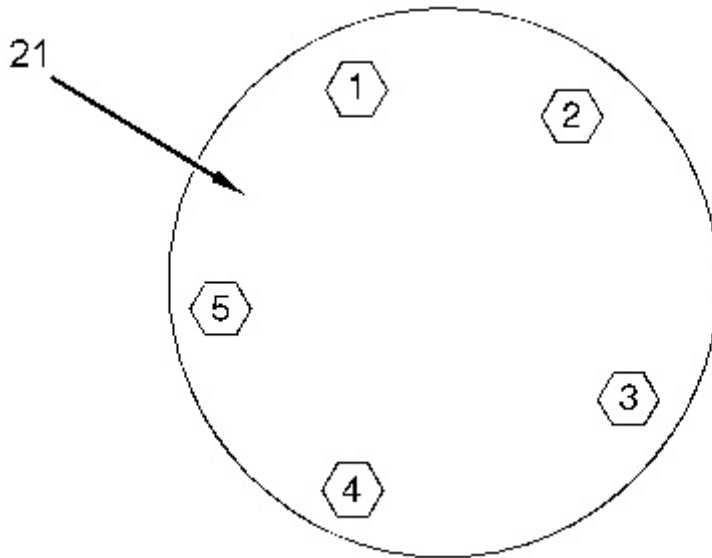


Illustration 3

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3. Thoroughly clean all gasket material from both sides of plate (23). Install plate (23) and bolts (24) .
4. Install shaft assembly (20). Apply Tooling (B) to the studs and to the bolt for shaft assembly (20). Tighten the nuts and the bolt for shaft assembly (20) to a torque of $55 \pm 10 \text{ N}\cdot\text{m}$ ($41 \pm 7 \text{ lb ft}$).

Note: The backlash for the camshaft gear and for the adjustable idler gear will need to be readjusted if shaft assembly (19) has been removed, loosened, or moved in any way. The camshaft gear must be installed and the adjustable idler gear must be removed in order to perform the backlash adjustment procedure. Refer to Testing and Adjusting, "Gear Group (Front) - Time".

5. Install shaft assembly (19). Do not tighten the nuts and the bolt for shaft assembly (19) at this time. The nuts and the bolt for shaft assembly (19) will need to be tightened when the backlash is adjusted.
6. Apply Tooling (B) to bolts (22). Install shaft assembly (21). Tighten bolts (22) to a torque of $55 \pm 10 \text{ N}\cdot\text{m}$ ($41 \pm 7 \text{ lb ft}$) in the following sequence: (1, 3, 4, 5, 2, 1, 2, 3, 4, 5, 1).

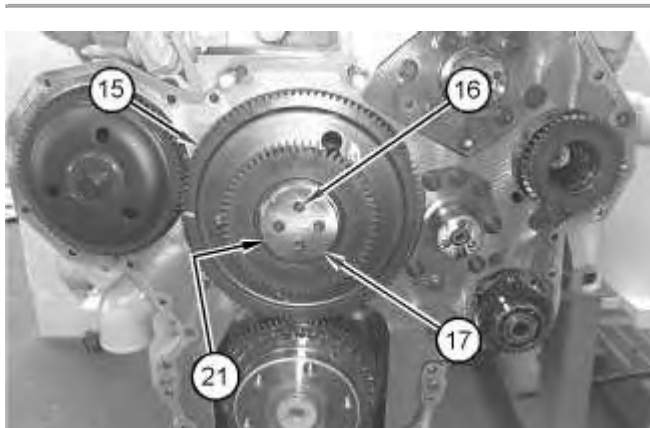




Illustration 5

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- Put cluster gear (15) on shaft assembly (21). Ensure that Timing Marks (V) are aligned on the cluster gear and on the crankshaft gear. Apply Tooling (B) to bolts (16). Install plate (17) and bolts (16). Tighten bolts (16) to a torque of 30 ± 7 N·m (22 ± 5 lb ft).

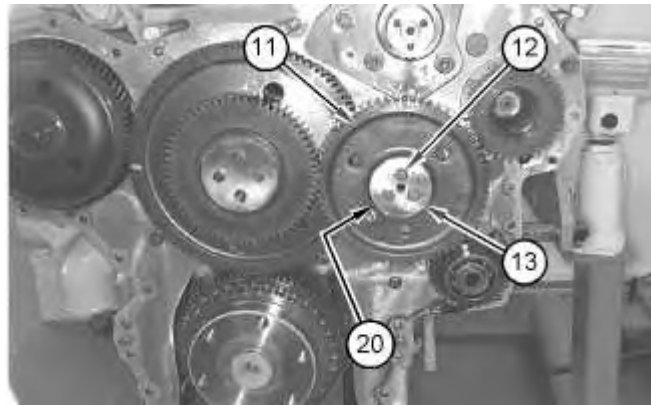


Illustration 6

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- Position idler gear (11) on shaft assembly (20). Apply Tooling (B) to bolts (12). Install plate (13) with the oil groove toward the gear face. Install bolts (12) and tighten the bolts to a torque of 30 ± 7 N·m (22 ± 5 lb ft).
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