

Product: TRACK-TYPE TRACTOR

Model: D6M TRACK-TYPE TRACTOR 2YS

Configuration: D6M XL & D6M LGP TRACTORS / POWERSHIFT / 2YS00001-UP (MACHINE) POWERED BY 3116 ENGINE

## Disassembly and Assembly D6M Track-Type Tractor Power Train

Media Number -SEN9482-04

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i01361761

# Torque Converter - Assemble

SMCS - 4170-077

## Assembly Procedure

Table 1

Tools Needed	A	B	C	D	E	F	G
1P-1855 Retaining Ring Pliers	1						
1P-510 Driver Group		1					
6V-2156 Link Bracket			2				
2P-8312 External Retaining Ring Pliers				1			
1P-520 Driver Group					1		
8B-7551 Bearing Puller Assembly						1	
8S-2328 Dial Indicator Group							1

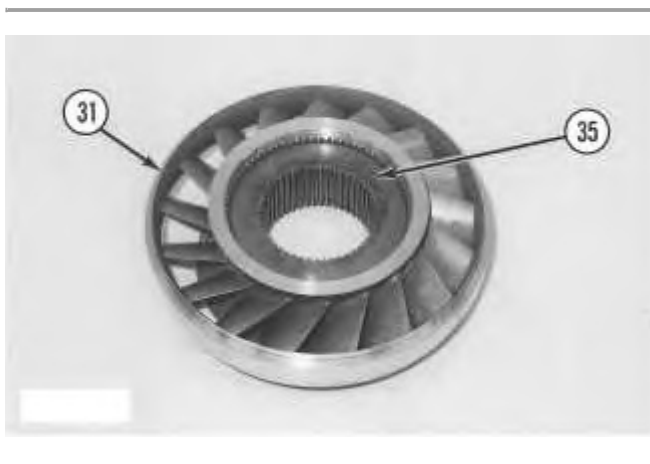




Illustration 2

1. Install race (34) and ring (33) in one side of stator (31) .
2. Lower the temperature of adapter (35). Install the adapter in stator (31) .
3. Install race (34) and ring (33) in the other side of stator (31) .

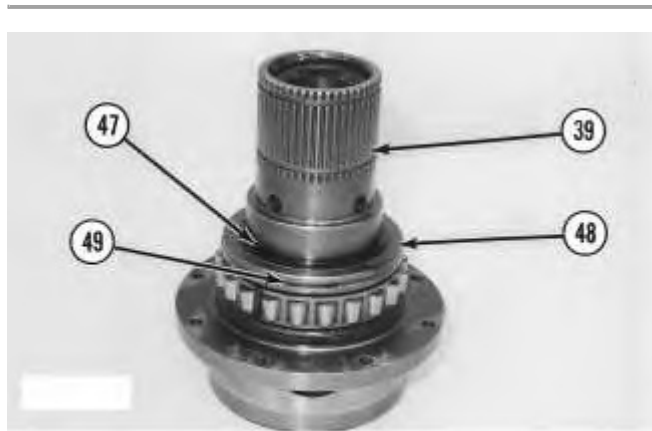


Illustration 3

4. Heat the bearing and carrier (48) to maximum temperature of 135°C (275.0°F). Install the parts on carrier (39), as shown.
  5. Install ring (47) on carrier (39) .
  6. Install ring (49) on carrier (48) .
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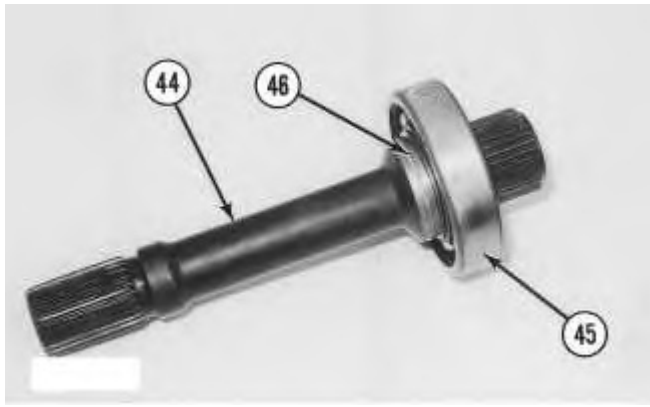


Illustration 4

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7. Use a press in order to install bearing (45) on shaft (44) .
8. Install ring (46) on the shaft.

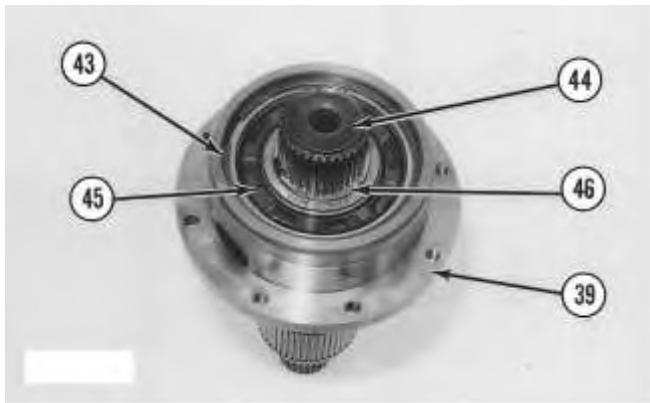


Illustration 5

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9. Install bearing (45) and shaft (44) in carrier (39) as an assembly.
10. Install ring (43) in order to hold the bearing in position.
11. Use Tool (D) in order to install snap ring (46) on shaft (44) .



Illustration 6

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12. If race (42) was removed, lower the temperature of the race. Install the race in gear (40) .

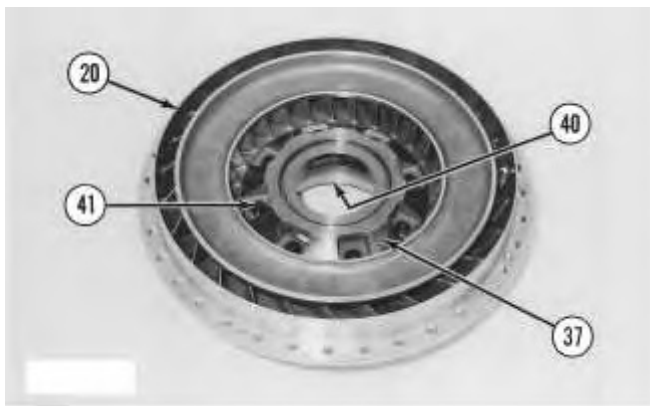


Illustration 7

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13. Put impeller (20) in position on gear (40) .
14. Align the bolt holes in hub (37) with the holes in gear (40). Put hub (37) in position on impeller (20) .
15. Install eight bolts (41). Tighten the bolts to a torque  $50 \text{ N}\cdot\text{m} \pm 7 \text{ N}\cdot\text{m}$  ( $37.0 \text{ lb ft} \pm 5.0 \text{ lb ft}$ ).

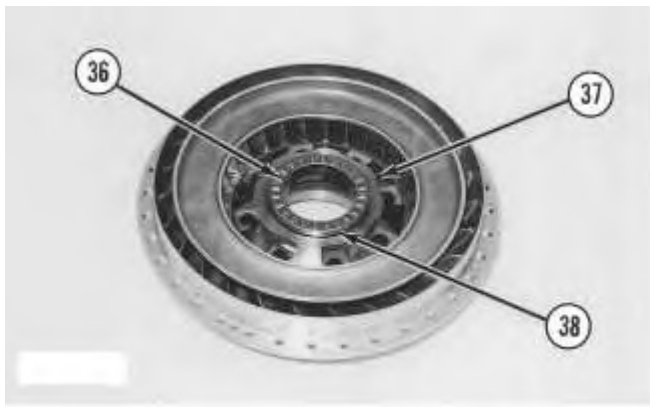


Illustration 8

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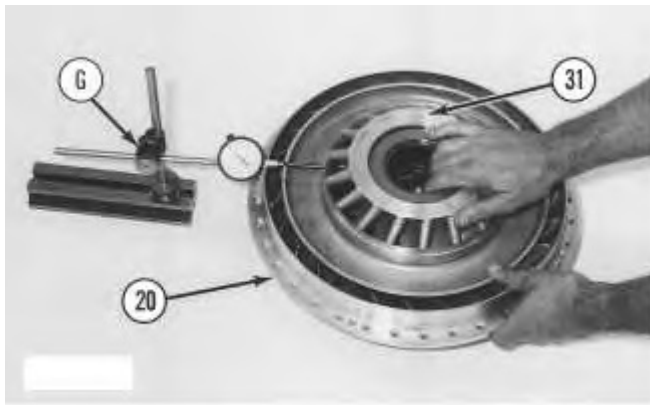


Illustration 9

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16. Check the clearance between stator (31) and impeller (20) in the following manner.
  - a. Put retainer (38), the race and bearing (36) in position on hub (37) .
  - b. Put stator (31) in position on bearing (36) .
  - c. Put Tool (G) in position with the point of the dial indicator against the surface of stator (31), as shown.
  - d. Push stator (31) toward Tooling (G) until the stator makes contact with the impeller. Adjust the dial indicator until the dial indicator is on zero. Slide the stator 180 degrees from Tooling (G) until the stator makes contact with the other side of the impeller. Make a record of this dimension.
  - e. Make this check at several locations around the housing. Make a record of each of the dimensions measured. The largest dimension that is measured is used for the clearance between the two parts. The total clearance that is measured across the diameters must be 0.49 mm to 1.01 mm (0.019 inch to 0.040 inch) for new parts. The maximum clearance with worn parts is 1.50 mm (0.059 inch).
  - f. Remove the stator, bearing (36), the race and retainer (38) .



Illustration 10

g00712916

17. Put turbine (25) in position on hub (23). Install bolts (26). Tighten the bolts to a torque of  $50 \text{ N}\cdot\text{m} \pm 7 \text{ N}\cdot\text{m}$  ( $37.0 \text{ lb ft} \pm 5.0 \text{ lb ft}$ ).

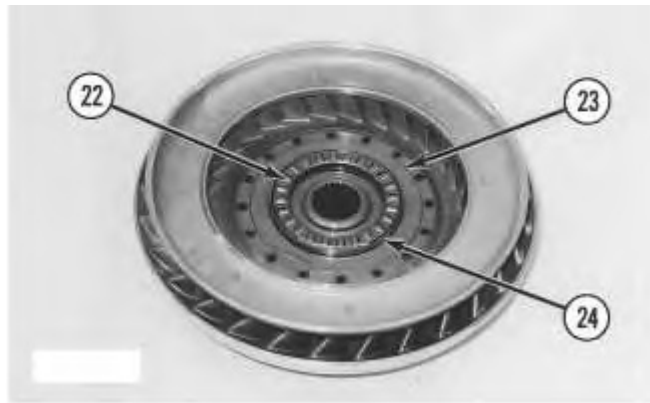


Illustration 11

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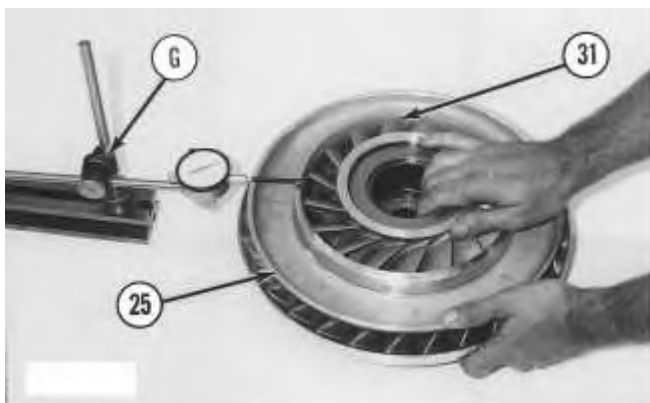


Illustration 12

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18. Check the clearance between stator (31) and turbine (25) in the following manner.

- a. Put retainer (24), the race, and bearing (22) in position on hub (23) .
- b. Put stator (31) in position on bearing (22) .
- c. Put Tool (G) in position with the point of the dial indicator against the surface of stator (31), as shown.
- d. Move the stator toward Tooling (G) until the stator makes contact with the inside diameter in the turbine. Adjust the dial indicator until the dial indicator is on zero. Slide the stator 180 degrees from Tooling (G) until the stator makes contact with the other side of the turbine. Make a record of the dimension measured.
- e. Make this check at several locations around the turbine. Make a record of each dimension measured. The largest dimension that is measured is used for the clearance between the two parts. The total clearance across the diameters must be 0.49 mm to 1.01 mm (0.019 inch to 0.040 inch) for new parts. The maximum clearance with worn parts is 1.50 mm (0.059 inch).
- f. Remove stator (31), bearing (22), the race, and retainer (24) from hub (23) .

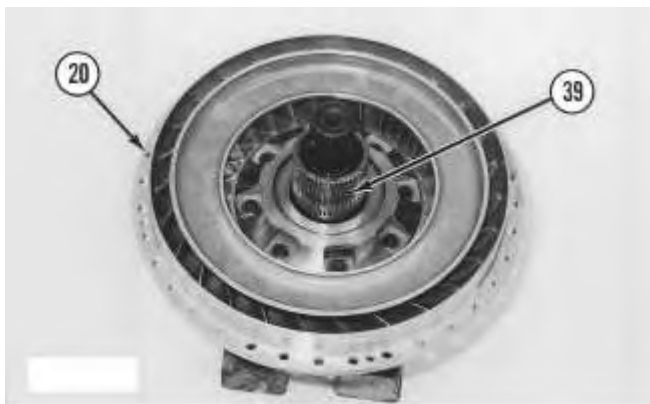
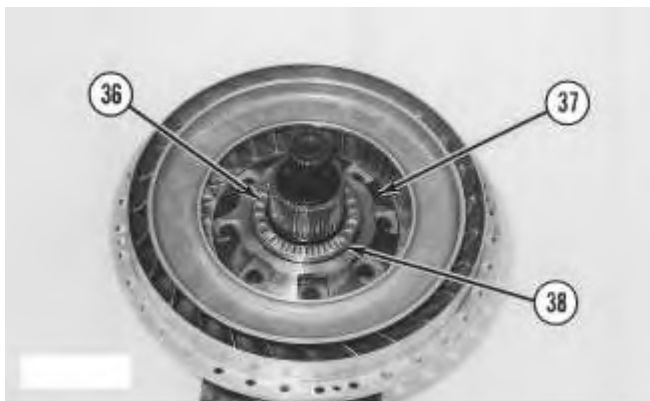


Illustration 13

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19. Put impeller (20) and the hub in position on carrier (39) .



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