

## ASSEMBLING THE TRACK CHAIN

**IMPORTANT:** If a weld turn is being made, the parts of the track must be clean.

1. Remove the drive sprockets for disassembly and install the drive sprockets to assemble the track chain. The same carrier is used.
2. Use a straightedge and measure the offset of the drive sprockets. The offset of the drive sprockets must be 1.182 inches (30 mm). Add or remove shims between the long drive and base as required.
3. Adjust the roller value for the track press to 5521 psi (38.525 MPa).
4. If a weld turn is being made, install a new plug in each pin.
  - a. Make sure that the bore in the pin is clean and free of any lubricant.
  - b. Lubricate the bore in the pin with Lucas Safety Grease or water and soap.
  - c. Put the guide CAG 1852-25 on the end of the pin and lubricate the bore of the guide.
  - d. Use the driver CAG 1852-1 and press the plug into the pin. The plug must be approximately 0.39 inch (10 mm) below the end of the pin.



- e. Make sure that there is a good metal-to-metal contact of all the pins so that there will not be movement from the bore in the track when the links are pressed onto the pins.

5. The first link assembly to be assembled is the bushing half of the master link.
7. Install a bushing in the top notch. If the bushings are being turned, put the bushing in the carrier so that the mark made before disassembly is on top.
8. Install a link half on one of the drive sprockets and adjust the nuts to hold the link half against the carrier.
9. Install the other link half on the other drive sprocket and adjust the other nuts until the link half touches the bushing. Check to make sure that the parts are even with each other.
10. Adjust the nuts to press the bushings into both link halves.



11. Measure the bushing projection at both ends of the bushing. If the measurement is not 0.118 inches (3 mm), add or remove shims between the long drive and base as required.

12. Use the gauge and pin to check the spacing of the link halves.



13. Check to make sure the link halves are level.



14. Install a pin in the bushing so that the mark is on top. The remainder of the pin must be installed so that the plugs are all on the same side. Apply Molykote Type G to both ends of the pin spacers according to the instructions on the container. Then install spacers on both ends of the pin.

15. Apply the endnut from the hole to the outer half of the bore for the pin in both links. The bore for the endnut must be free of any foreign material.



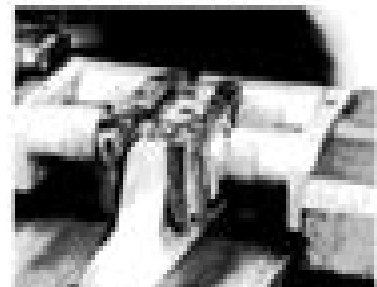
16. Make sure that the bore for the endnut and any hole of oil and install a seal in both ends.

17. Put the pins on the drive sprockets and a bushing in the carrier so that the mark is on top.



18. Install the master link bush and adjust the nuts until the drive sprockets touch the links.

19. Press the pins into the pin and bushing.



20. Use the gauge and pin to check the spacing between the links.



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