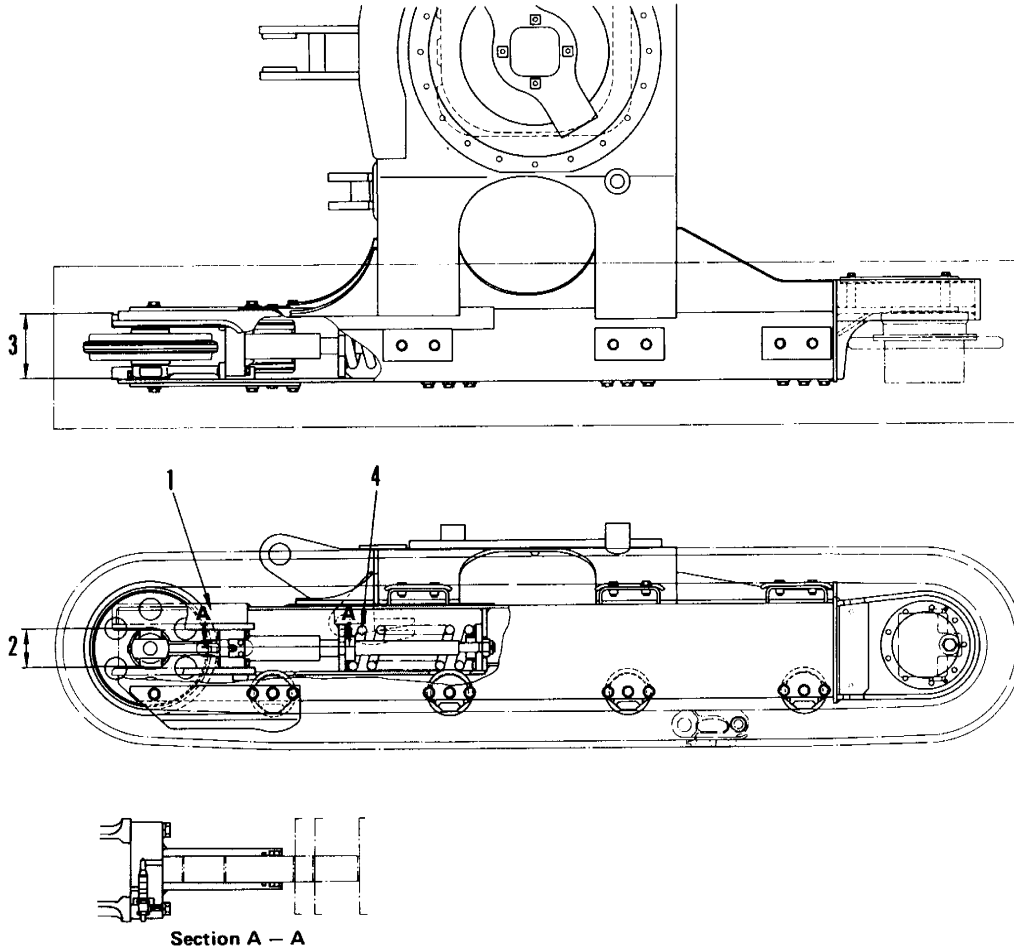


TRACK FRAME AND RECOIL SPRING (S/N 11999 & Below)



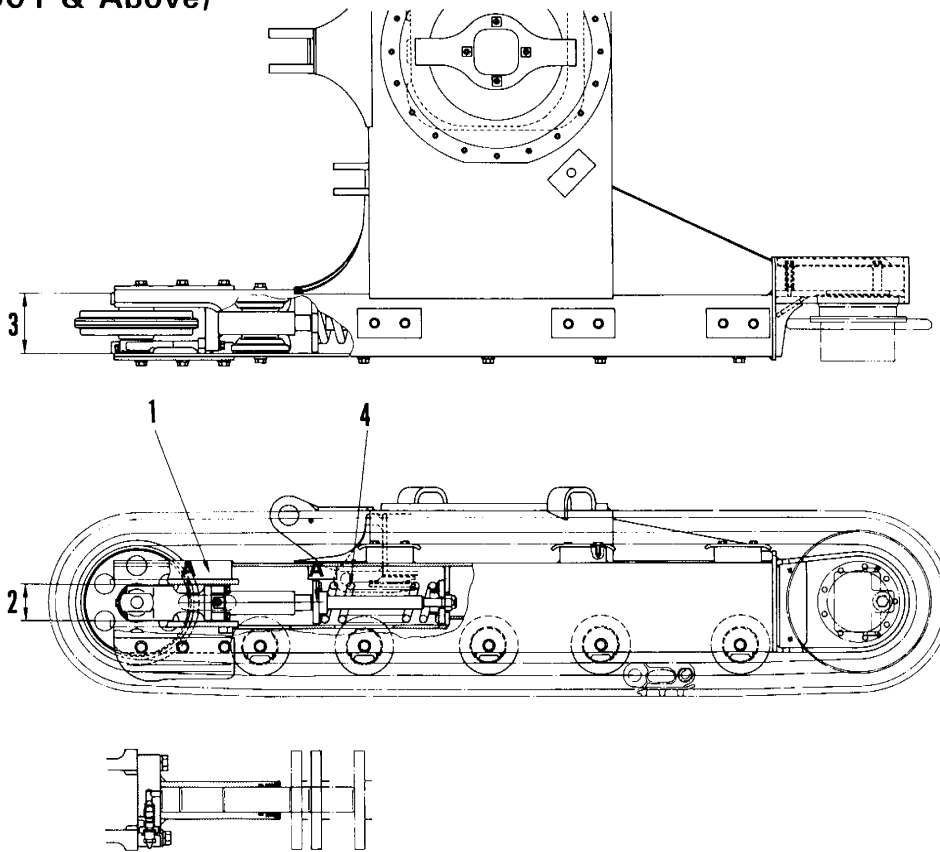
20TF05027

Unit: mm

No.	Check item	Criteria			Remedy
1	Deformation of frame	Repair limit			Rebuild
		Curvature	5 (for every 1000 mm of length)		
		Torsion	3 (for every 300 mm of level length)		
		Opening of idler portion	5		
2	Vertical width of idler guide	Standard size			Build up welding
		Track frame	96		
		Idler support	94		Build up welding or replace
3	Horizontal width of idler guide	Track frame	161		Build up welding
		Idler support	159		Build up welding or replace
4	Recoil spring	Standard size			Replace
		Free length	Installed length	Installed load	
		400	320	2,750 kg	

TRACK FRAME AND RECOIL SPRING

(S/N 12001 & Above)



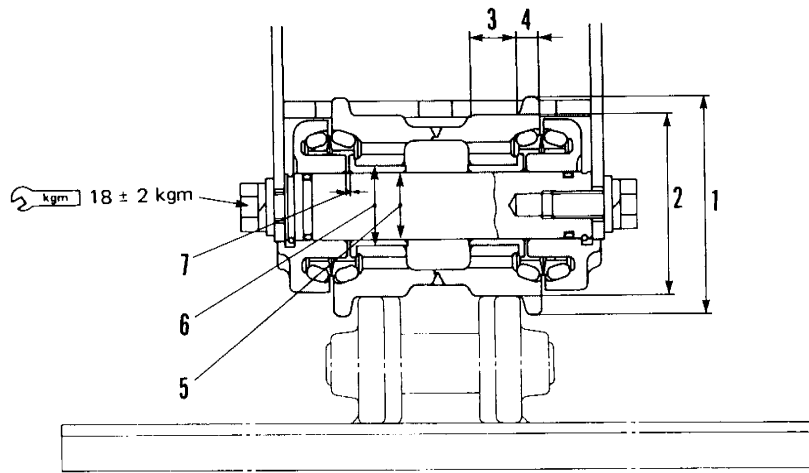
Section A-A

20TF06018

Unit: mm

No.	Check item	Criteria			Remedy
1	Deformation of frame	Repair limit			Rebuild
		Curvature	5 (for every 1000 mm of length)		
		Torsion	5 (for every 300 mm of level length)		
		Opening of idler portion	5		
2	Vertical width of idler gauge	Standard size			Build up welding
		Track frame	96		
		Idler support	94		Build up welding or replace
3	Horizontal width of idler guide	Track frame	161		Build up welding
		Idler support	159		Build up welding or replace
4	Recoil spring	Standard size			Replace
		Free length	Installed length	Installed load	
		248	206.4	2,000 kg	

TRACK ROLLER (S/N 11999 & Below)

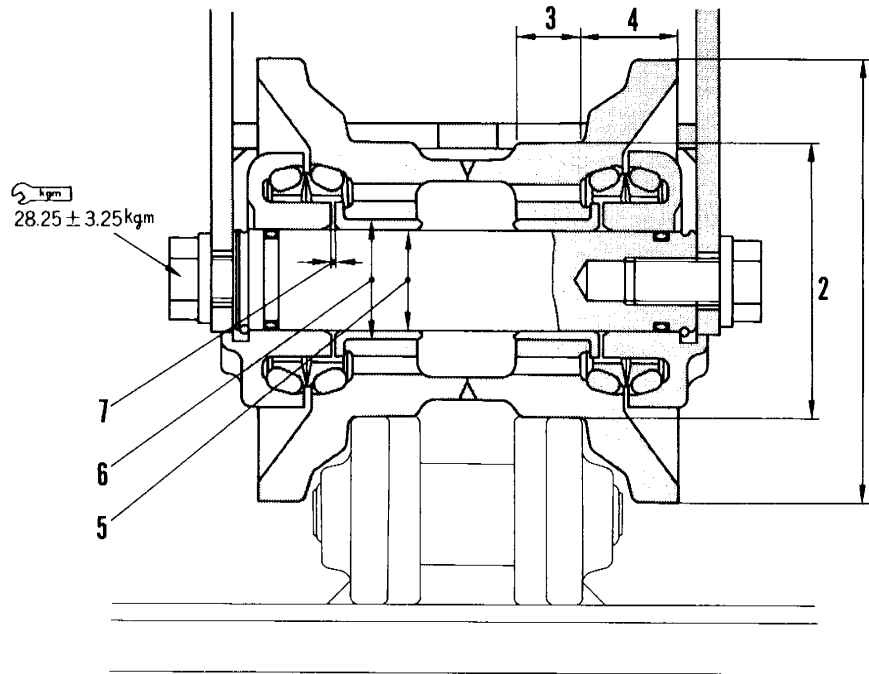


20TF05028

Unit: mm

No.	Check item	Criteria				Remedy	
		Standard size	Tolerance		Repair limit		
1	Flange (outside) outer dia.	115			107	Build up welding or replace	
2	Tread outside dia.	95			87		
3	Tread width	26.5			30		
4	Flange width	10.5			7		
5	Clearance between shaft and bushing	Standard size	Tolerance		Standard clearance	Clearance limit	Replace bushing
		35	Shaft -0.025 -0.050	Hole +0.142 +0.080	0.105 to 0.192	1.5	
6	Interference between roller and bushing	Standard size	Tolerance		Standard interference		Replace
		42	Shaft +0.079 +0.054	Hole +0.039 0	0.015 to 0.079		
7	End play of roller	Standard clearance			Clearance limit		Replace
		0.25			1.0		

TRACK ROLLER (S/N 12001 & Above)

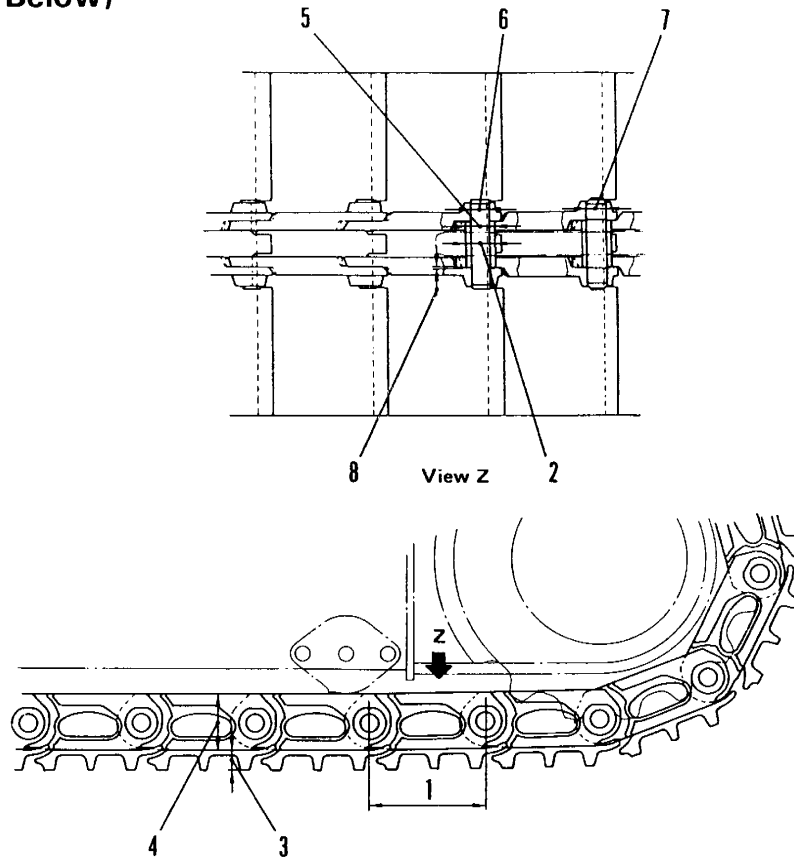


20TF06020

Unit: mm

No.	Check item	Criteria				Remedy	
		Standard size		Repair limit			
1	Flange (outside) outer dia.	151		145		Build up welding or replace	
2	Tread outside dia.	95		87			
3	Tread width	22		26			
4	Flange width	15.5		13.0			
5	Clearance between shaft and bushing	Standard size 35	Tolerance		Standard clearance 0.105 to 0.192	Clearance limit 1.5	
			Shaft	Hole			
6	Interference between roller and bushing	Standard size 42	Tolerance		Standard interference 0.015 to 0.079		
			Shaft	Hole			
7	End play of roller	Standard clearance			Clearance limit		Replace
		0.25			1.0		

TRACK SHOE (S/N 11999 & Below)

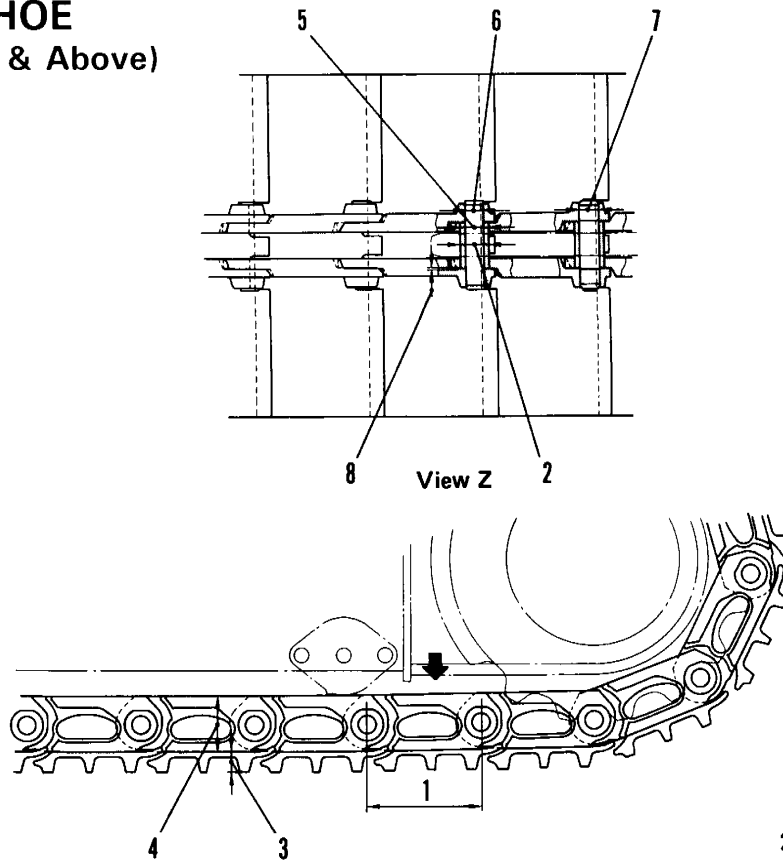


20TF05030

Unit: mm

No.	Check item	Criteria			Remedy
		Standard size	Turn limit	Repair limit	
1	Link pitch	Standard size	Turn limit	Repair limit	Turn or replace
		135	138	143	
2	Bushing outside dia.	35	32	—	Lug welding rebuild or replace
3	Grouser height	Standard size	Repair limit		
		18	10		
4	Link height	65	59		Rebuild or replace
5	Interference between bushing and link	Standard size	Tolerance		Standard interference
		Shaft 35 Hole 34.85	Shaft +0.030 0	Hole +0.040 0	
6	Interference between regular pin and link	Shaft 22.5 Hole 22.3	+0.060 0	+0.052 0	0.140 to 0.300
7	Interference between master pin and link	Shaft 22.5 Hole 22.3	-0.030 -0.070	+0.052 0	
8	Clearance between link joint surface	Standard clearance (each side)	Standard clearance (both side)	Clearance limit (both side)	
		0.2 to 0.9	0.4 to 1.8	—	

TRACK SHOE (S/N 12001 & Above)



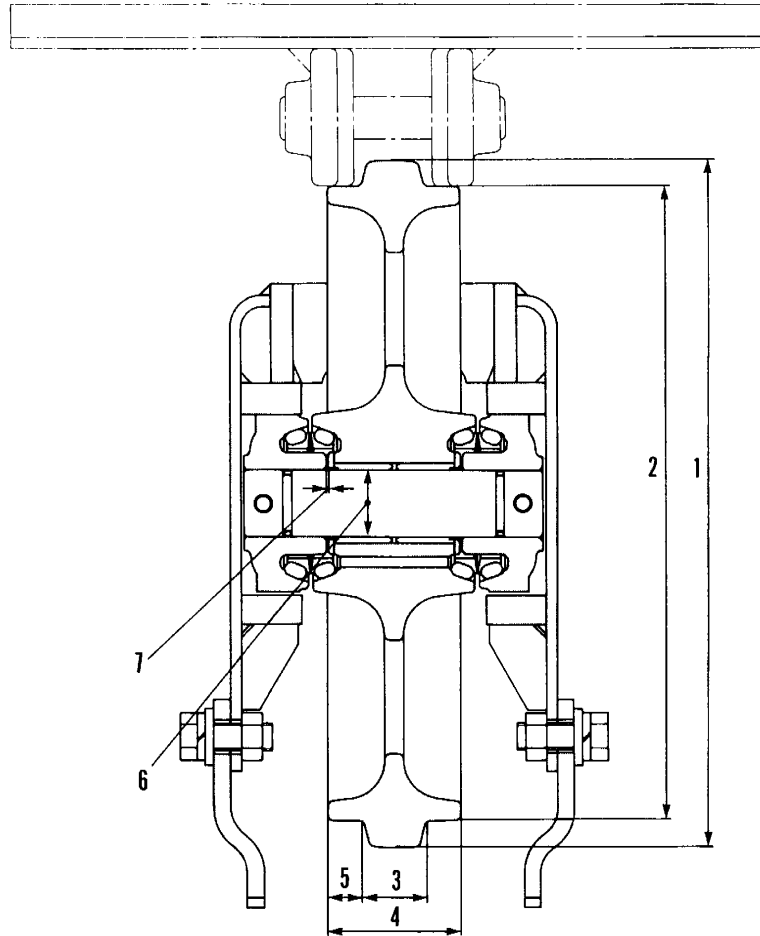
20TF05030

Unit: mm

No.	Check item	Criteria			Remedy
		Standard size	Turn limit	Repair limit	
1	Link pitch	Standard size	Turn limit	Repair limit	Turn or replace
		135	138	143	
2	Bushing outside dia.	35	32	—	
3	Grouser height	Standard size	Repair limit		Lug welding rebuild or replace
		18	10		
4	Link height	65	59		Rebild or replace
5	Interference between bushing and link	Standard size	Tolerance		Standard interference
			Shaft	Hole	
6	Interference between regular pin and link	Shaft 22.5 Hole 22.3	+0.060 0	+0.052 0	0.140 to 0.300
		Shaft 22.5 Hole 22.3	-0.030 -0.070	+0.052 0	
7	Interference between master pin and link	Shaft 22.5 Hole 22.3	-0.030 -0.070	+0.052 0	0.278 to 0.370
		Shaft 22.5 Hole 22.3	-0.030 -0.070	+0.052 0	
8	Clearance between link joint surface	Standard clearance (each side)	Standard clearance (both side)	Clearance limit (both side)	Replace
		0.2 to 0.9	0.4 to 1.8	—	

IDLER

(S/N 11999 & Below)

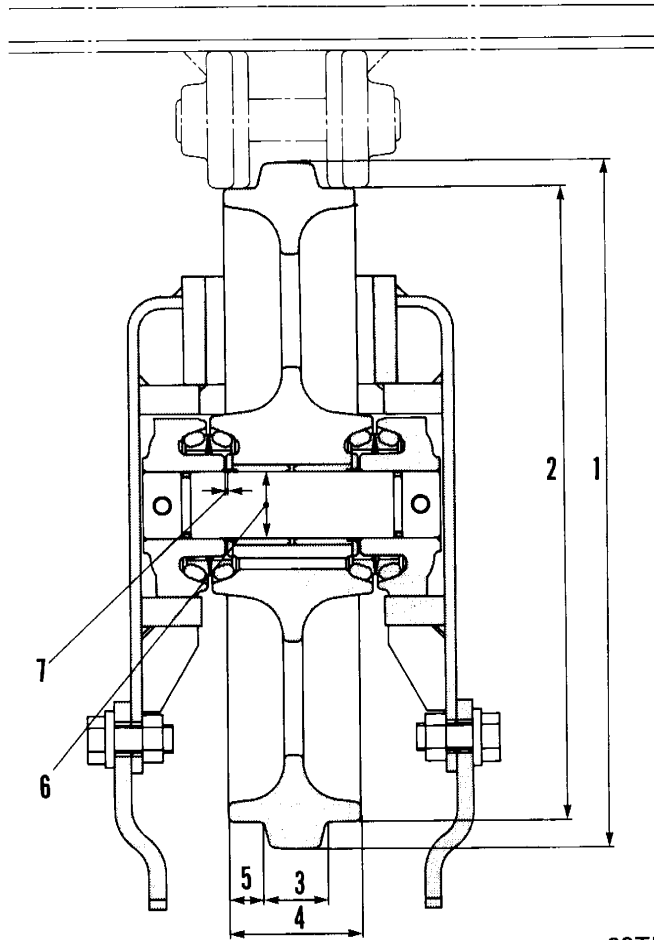


20TF05029

Unit: mm

No.	Check item	Criteria				Remedy	
		Standard size		Repair limit			
1	Outer dia. of protrusion	328		320		Build up welding or replace	
2	Outer dia. of tread	300		292			
3	Width of protrusion	28		20			
4	Total width	64		59			
5	Width of tread	18		22			
6	Clearance between shaft and bushing	Standard size	Tolerance		Standard clearance	Clearance limit	
			Shaft	Hole			
		35	-0.025 -0.064	+0.142 +0.080	0.105 to 0.206	1.5	Replace
7	End play of idler	Standard size		Repair limit			
		0.25		1.0			

IDLER
(S/N 12001 & Above)



20TF06019

Unit: mm

No.	Check item	Criteria				Remedy
		Standard size		Repair limit		
1	Outer dia. of protrusion	328		320		Build up welding or replace
2	Outer dia. of tread	300		292		
3	Width of protrusion	28		20		
4	Total width	64		59		
5	Width of tread	18		22		
6	Clearance between shaft and bushing	Standard size 35	Tolerance		Standard clearance 0.105 to 0.206	Clearance limit 1.5
			Shaft	Hole		
			-0.025 -0.064	+0.142 +0.080		Replace
7	End play of idler	Standard size		Repair limit		
		0.25		1.0		