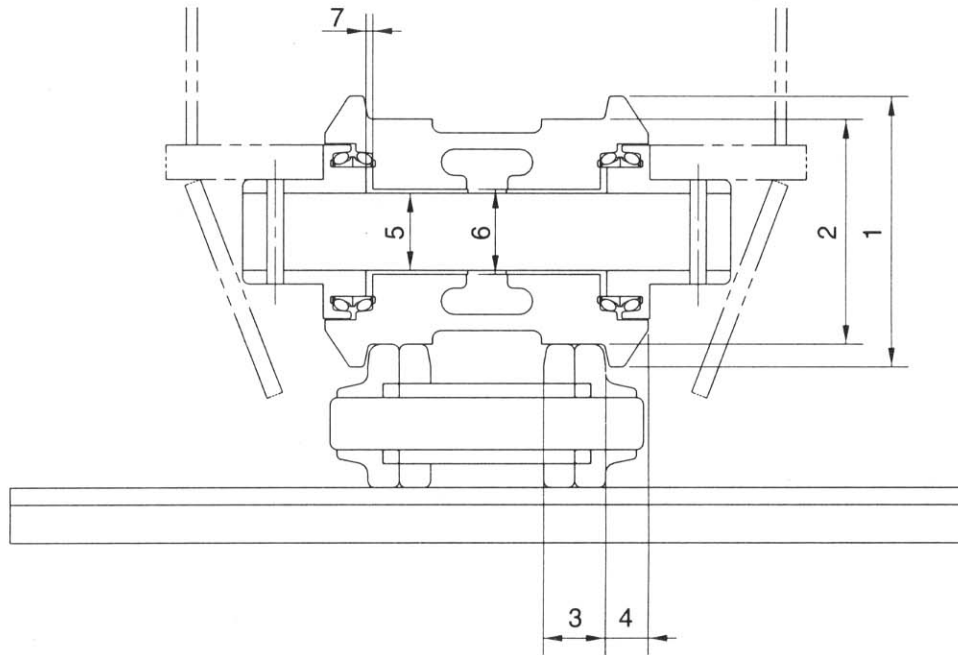


GROUP 3 TRACK AND WORK EQUIPMENT

1. TRACK

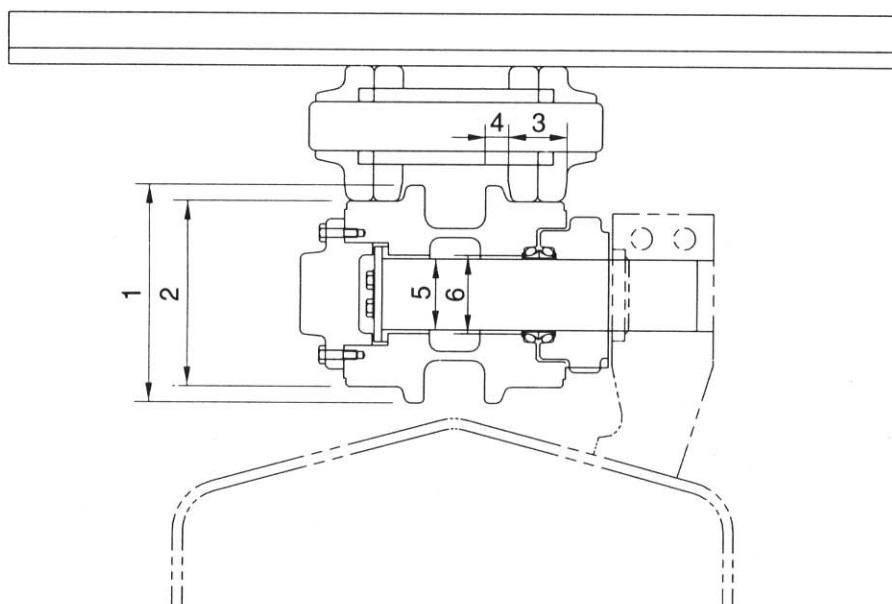
1) TRACK ROLLER



Unit : mm

No.	Check item	Criteria				Remedy
		Standard size	Tolerance		Repair limit	
1	Outside diameter of flange	Standard size			Repair limit	Rebuild or replace
		ø 216			-	
		ø 180			ø 168	
2	Outside diameter of tread	ø 180			ø 168	Rebuild or replace
3	Width of tread	49			55	
4	Width of flange	27			-	Replace bushing
5	Clearance between shaft and bushing	Standard size	Tolerance		Standard clearance	
		ø 65	Shaft	Hole	0.140 to 0.442	1.5
6	Interference between roller and bushing	Standard size	Tolerance		Standard Interference	Interference limit
		ø 72	Shaft	Hole	0.014 to 0.144	-
7	Side clearance of roller	Standard clearance		Clearance limit		Replace
		0.2 to 0.6		1.5		

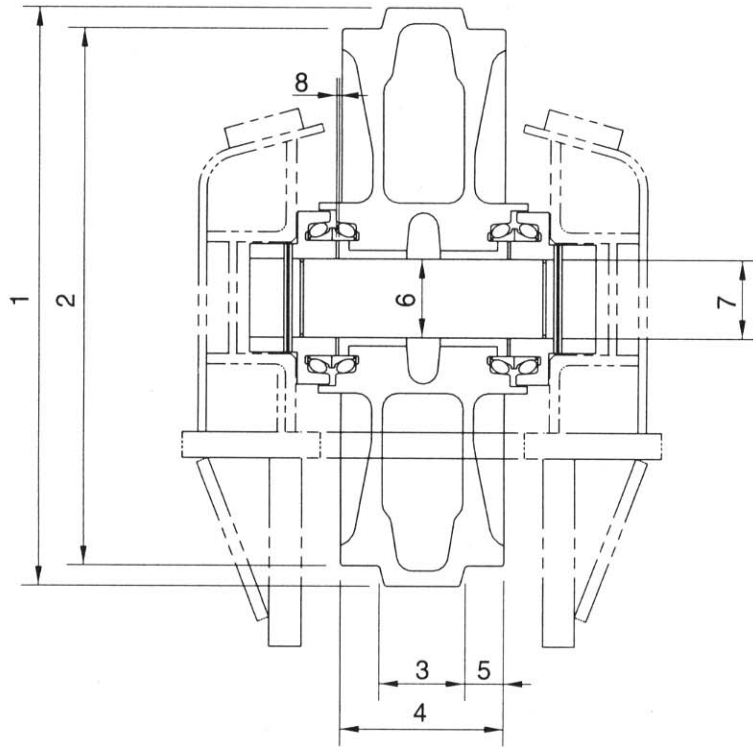
2) CARRIER ROLLER



Unit : mm

No.	Check item	Criteria				Remedy	
		Standard size		Repair limit			
1	Outside diameter of flange	ø 200		-		Rebuild or replace	
2	Outside diameter of tread	ø 168		ø 158			
3	Width of tread	54		62			
4	Width of tread	18.25		-			
5	Clearance between shaft and bearing	Standard size	Tolerance		Standard clearance	Clearance limit	Replace bushing
		ø 55	+0.085 +0.066	+0.370 +0.330			
6	Interference between roller and seal bushing	ø 65	+0.125 +0.090	+0.03 0	0.06 to 0.155	-	Replace bushing

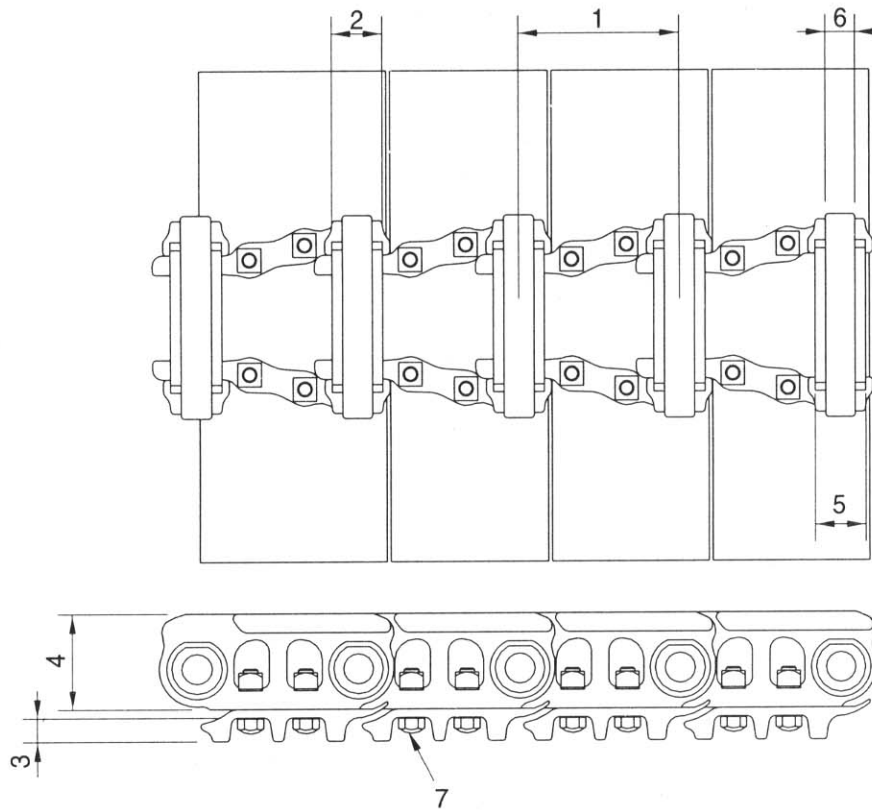
3) IDLER



Unit : mm

No.	Check item	Criteria		Remedy		
		Standard size	Repair limit			
1	Outside diameter of protrusion	ø 646	-	Rebuild or replace		
2	Outside diameter of tread	ø 594	ø 575			
3	Width of protrusion	104	-			
4	Total width	203	-			
5	Width of tread	50.5	55.5			
6	Clearance between shaft and bushing	Standard size & Tolerance		Standard clearance	Clearance limit	Replace bushing
		Shaft	Hole			
		ø 85 $\begin{matrix} 0 \\ -0.035 \end{matrix}$	ø 85.2 $\begin{matrix} +0.35 \\ 0.40 \end{matrix}$	0.35 to 0.435	1.5	
7	Clearance between shaft and support	ø 85 $\begin{matrix} 0 \\ -0.035 \end{matrix}$	ø 85 $\begin{matrix} -0.090 \\ -0.036 \end{matrix}$	0.036 to 0.125	0.15	Replace
8	Side clearance of idler (both side)	Standard clearance		Clearance limit		Replace
		0.4 to 1.0		2.0		

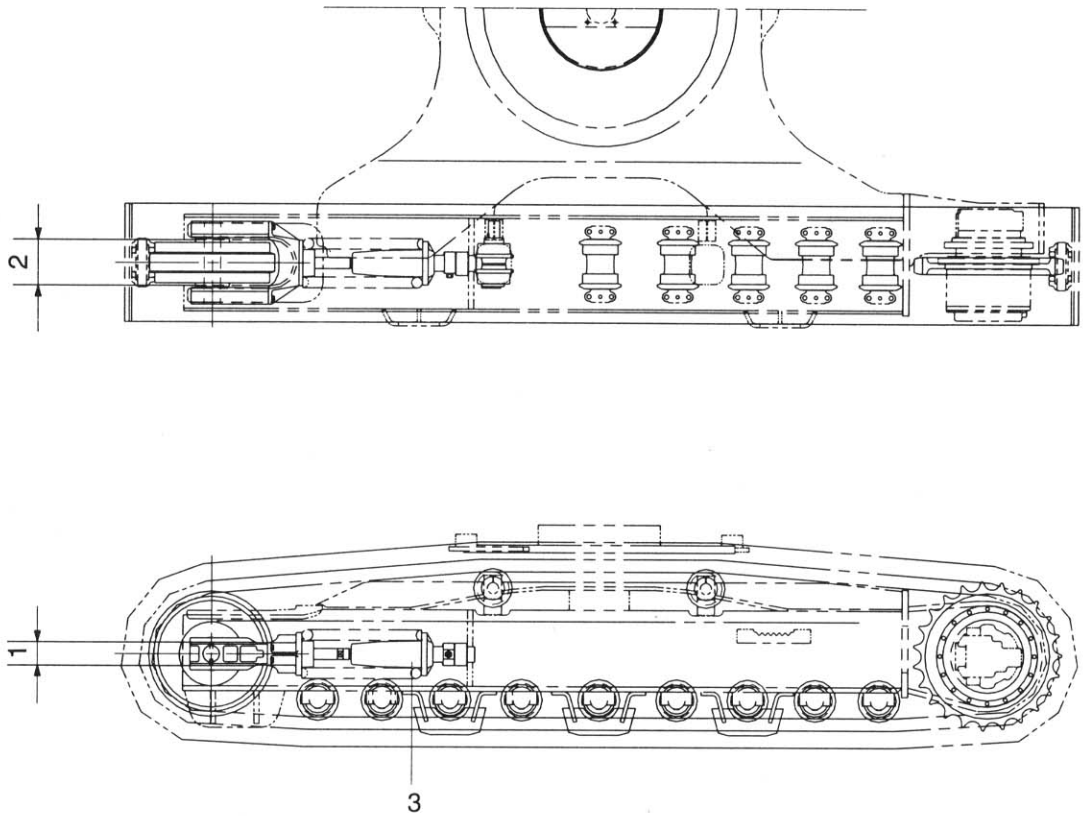
4) TRACK



Unit : mm

No.	Check item	Criteria				Remedy
		Standard size		Repair limit		
1	Link pitch	203.2		207.2		Turn or replace
2	Outside diameter of bushing	66.9		61.65		
3	Height of grouser	26		19		Rebuild or replace
4	Height of link	116.4		108.4		
5	Interference between bushing and link	Standard size & Tolerance		Standard interference	Interference limit	Replace
		Shaft	Hole			
6	Interference between regular pin and link	$\phi 66.65^{+0.05}_0$	$\phi 66.27^{+0.07}_0$	0.020 to 0.120	0.015	
		$\phi 44.45^{+0.1}_0$	$\phi 44.13^{+0.03}_0$			
7	Tightening angle method (Tightening angle method)	Initial tightening torque : 86+5 kg · m Additional tightening angle : $120 \pm 10^\circ$				Retighten

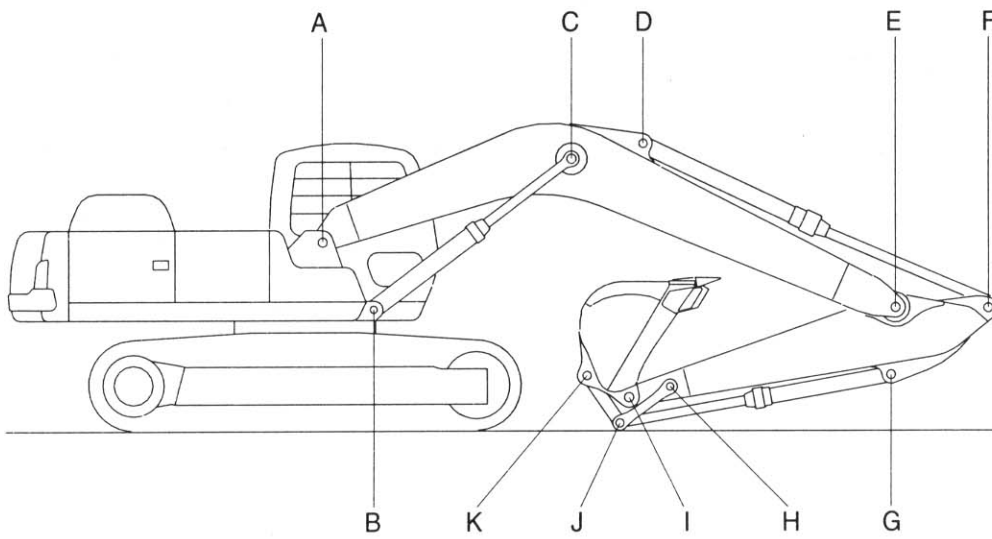
5) TRACK FRAME AND RECOIL SPRING



Unit : mm

No.	Check item	Criteria				Remedy	
		Item	Standard size	Tolerance	Repair limit		
1	Vertical width of idler guide	Track frame	123	+2 -1	127	Rebuild or replace	
		Idler support	120	0 -1.5	116		
2	Horizontal width of idler guide	Track frame	292	+3 -1	297		
		Idler	290	-	288		
3	Recoil spring	Standard size			Repair limit		Replace
		Free length	Installation length	Installation load	Free length	Installation load	
		∅251×732	615	17875kg	-	14300kg	

2. WORK EQUIPMENT



Unit : mm

Mark	Measuring point (Pin and Bushing)	Normal value	Pin		Bushing		Remedy & Remark
			Recomm. service limit	Limit of use	Recomm. service limit	Limit of use	
A	Boom Rear	100	99	98.5	100.5	101	Replace
B	Boom Cylinder Head	90	89	88.5	90.5	91	"
C	Boom Cylinder Rod	100	99	98.5	100.5	101	"
D	Arm Cylinder Head	100	99	98.5	100.5	101	"
E	Boom Front	100	99	98.5	100.5	101	"
F	Arm Cylinder Rod	100	99	98.5	100.5	101	"
G	Bucket Cylinder Head	90	89	88.5	90.5	91	"
H	Arm Link	90	89	88.5	90.5	91	"
I	Bucket and Arm Link	100	99	98.5	100.5	101	"
J	Bucket Cylinder Rod	90	89	88.5	90.5	91	"
K	Bucket Link	100	99	98.5	90.5	91	"