

# Service Updates

## **Chain Case Updates**

## **Section 3**

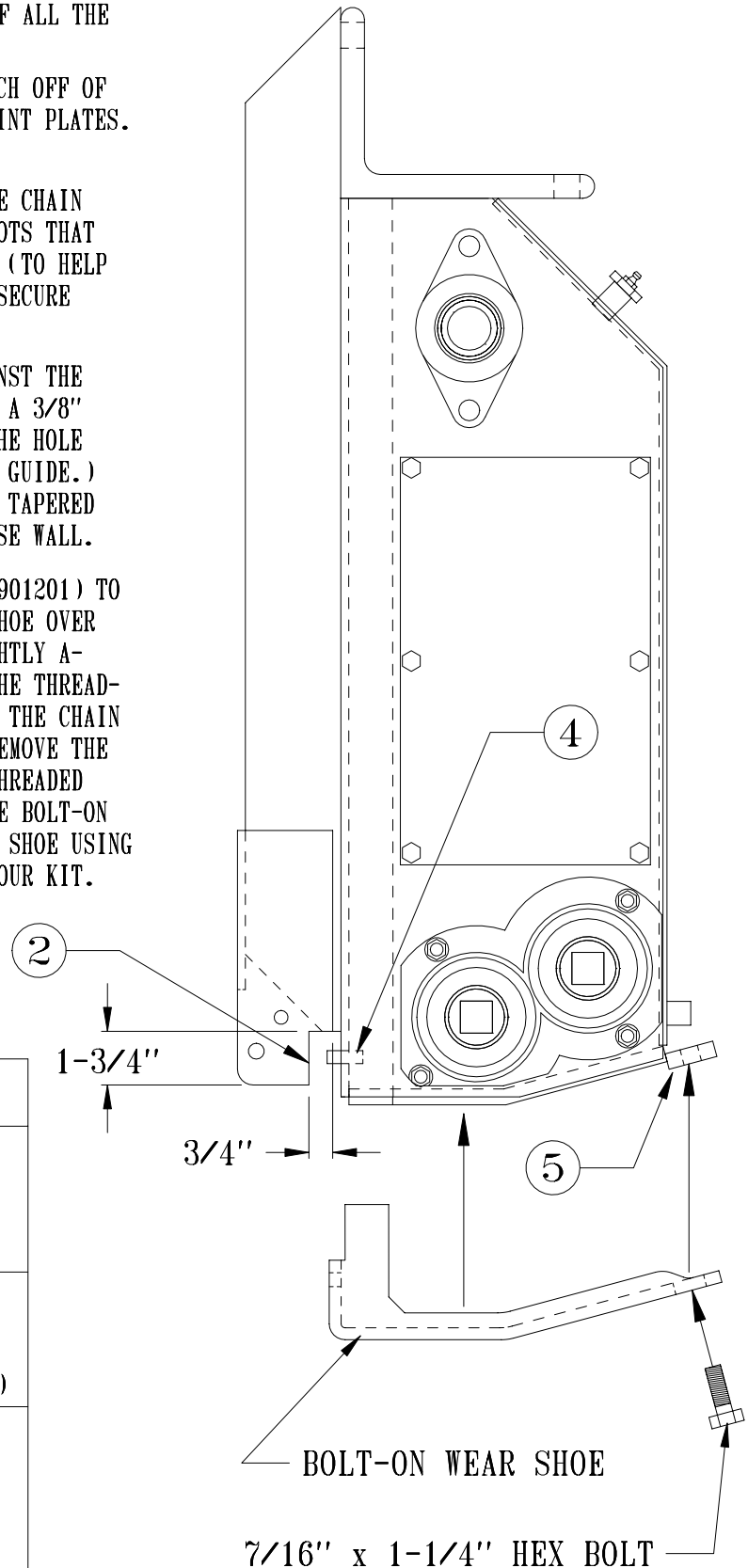
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

# BOLT-ON WEAR SHOE MOUNTING INSTRUCTIONS

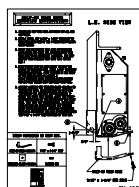
## L.H. SIDE VIEW

1. REMOVE THE OLD WEAR SHOE AND GRIND OFF ALL THE OLD WELDS.
2. WITH A TORCH, CUT A 3/4" x 1-3/4" NOTCH OFF OF THE LOWER BACK SIDE OF THE 2 SHANK POINT PLATES. GRIND SMOOTH.
3. PLACE THE NEW BOLT-ON WEAR SHOE ON THE CHAIN CASE BOTTOM AND CHECK FOR ANY HIGH SPOTS THAT WILL NEED TO BE REMOVED BY A GRINDER. (TO HELP PREVENT SHOE BREAKAGE THIS MUST BE A SECURE FIT.)
4. HOLD THE NEW BOLT-ON SHOE FIRMLY AGAINST THE BOTTOM FRONT OF THE CHAIN CASE. DRILL A 3/8" HOLE THRU THE CHAIN CASE WALL. (USE THE HOLE IN THE FRONT OF THE BOLT-ON SHOE AS A GUIDE.) USE A PERMANENT BRAND LOCKTITE ON THE TAPERED PIN AND SEAT FIRMLY INTO THE CHAIN CASE WALL.
5. LOOSELY ASSEMBLE THE THREADED PLATE (901201) TO THE BOLT-ON SHOE. PLACE THE BOLT-ON SHOE OVER THE TAPERED PIN AND HOLD THE SHOE TIGHTLY AGAINST THE CHAIN CASE BOTTOM. ALIGN THE THREADED PLATE (901201) TO THE BACK SIDE OF THE CHAIN CASE. TACK WELD THE THREADED PLATE. REMOVE THE BOLT-ON SHOE AND FINISH WELDING THE THREADED PLATE TO THE CHAIN CASE. REINSTALL THE BOLT-ON WEAR SHOE AND TIGHTEN THE REAR OF THE SHOE USING THE 7/16" x 1-1/4" BOLT PROVIDED IN YOUR KIT.



### ITEMS CONTAINED IN THIS KIT.

	
BOLT-ON SHOE (119116)	7/16" x 1-1/4" BOLT
	
THREADED PLATE (901201)	1" TAPERED PIN (NO.7)



INSTRUCTIONS

T.Tolman 4-19-96

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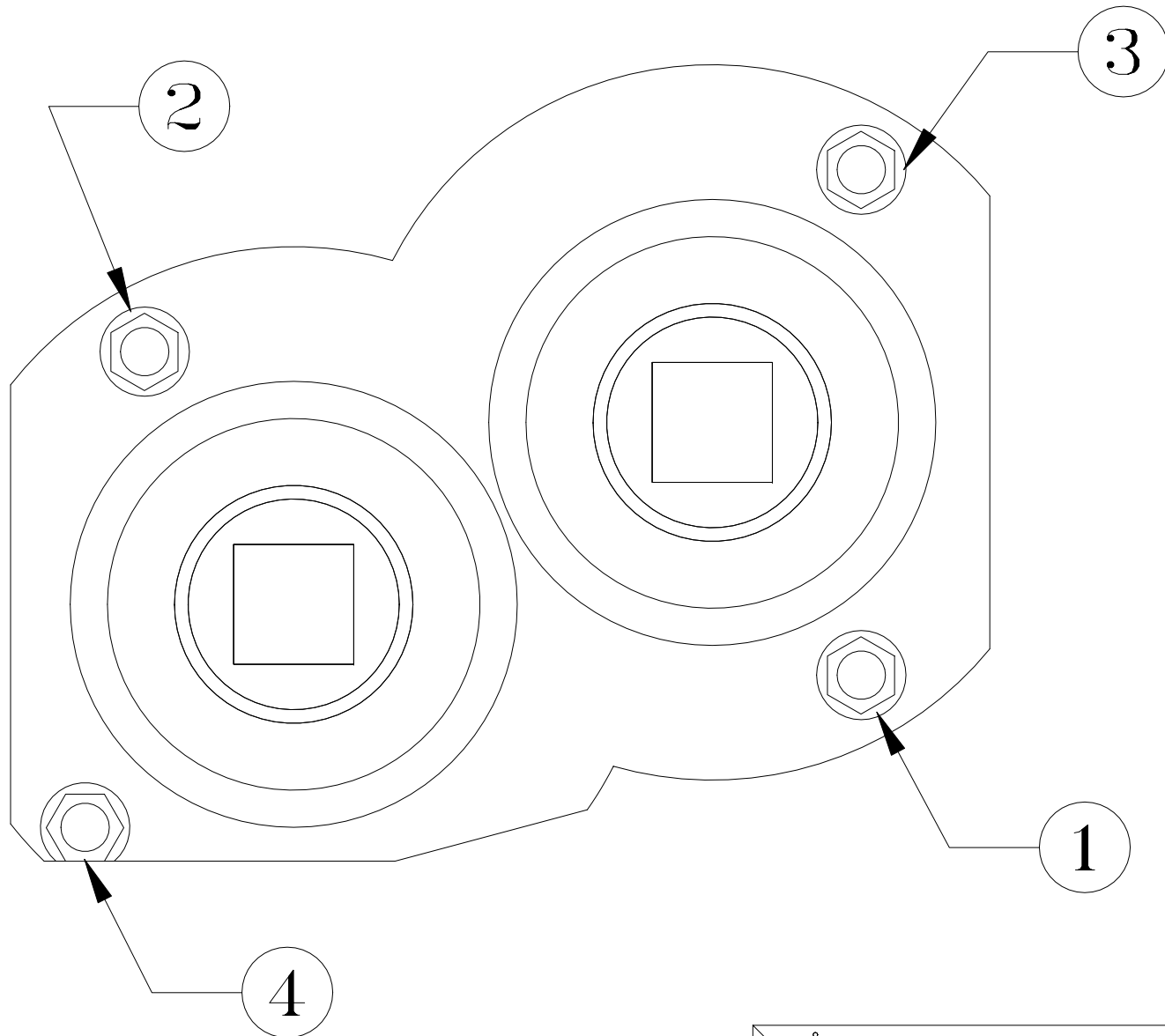
**BOLT-ON WEAR SHOE UPDATE KIT (901242)****Parts List**

<u>Item No.</u>	<u>Part No.</u>	<u>Qty</u>	<u>Description</u>
1.	119116	1	Shoe, Bolt-on Wear
2.	901201	1	Threaded Plate (weld-on)
3.	901242	1	Mounting Instructions

**Hardware List**

<u>Item No.</u>	<u>Part No.</u>	<u>Qty</u>	<u>Description</u>
A.		1	7/16" × 1¼" NC Hex Bolt
B.		1	1" Tapered Pin (No. 7)

★ This kit number 901242 replaces kit no. CCK-0001.



BEARING CAP BOLT  
REPLACEMENT SEQUENCE

# Installation of Serrated Bolts in Bearing Cap Sleeves on Chain Case

PLEASE READ INSTRUCTIONS COMPLETELY BEFORE INSTALLATION.

## Materials Needed

Torque Wrench and socket  
Cleaning rags  
Cleaning solvent  
Grinder (where needed)  
New serrated bolts

## Preparation

Take necessary safety precautions to ensure that the machine is secure and that the chain case is easily accessible. Clean the bearing cap sleeves from all dirt and grease using rags and solvent. Locate bolts to be replaced. If **only** replacing bolts, do **not** remove bolts at this time. If doing additional chain case maintenance, the bolts may be removed. Inspect the area of the bearing cap sleeve where the serrated bolt will contact. Take special care that this contacting surface is clean and dry. Where needed, grind spot welds and other irregular surfaces. **Special Note:** A groove will be in the contacting surface if a serrated bolt has been removed. Do NOT grind this groove smooth. Once the surface for each bolt is prepared follow the Installation Procedure below.

**The serrated bolt will function properly where the bearing cap sleeve has been counter-sunk.**

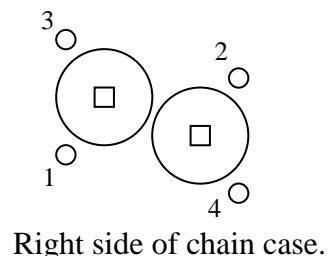
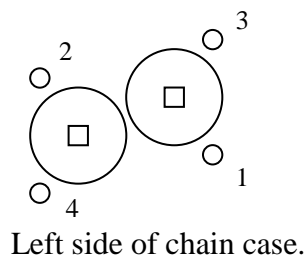
## Installation Procedure

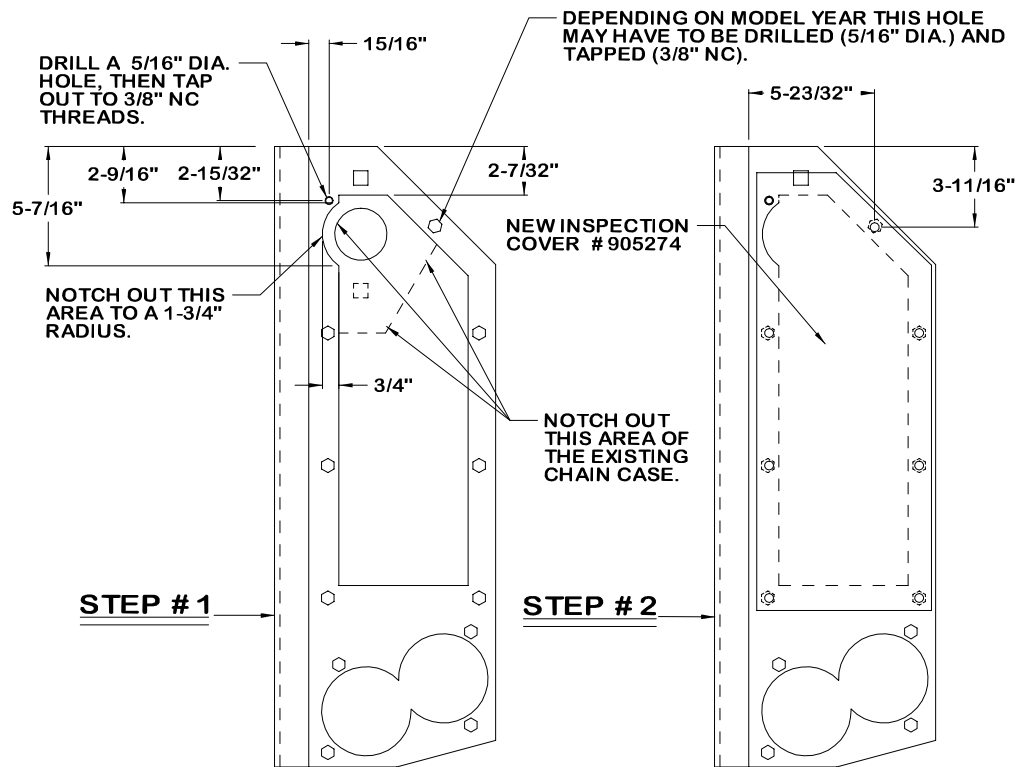
The following procedure is to be performed completely for a single bolt before working on additional bolts. If more than one bolt is to be replaced, refer to Recommended Bolt Replacement Order below. If replacing old serrated bolts with new serrated bolts follow steps 1,2,3 and 6 only.

- 1) Remove bolt.
- 2) Inspect bolt hole and contacting surfaces. Clean and dry where needed. **Special Note:** A groove will be in the contacting surface if a serrated bolt has been removed. This groove improves the bolt's effectiveness.
- 3) Insert a new serrated bolt and tighten to 40 ft-lb. of torque.
- 4) Loosen the serrated bolt and clean any metal particles from serration and bearing cap sleeve.
- 5) Tighten the serrated bolt a second time to 50 ft-lb.
- 6) Repeat procedure for additional bolts.

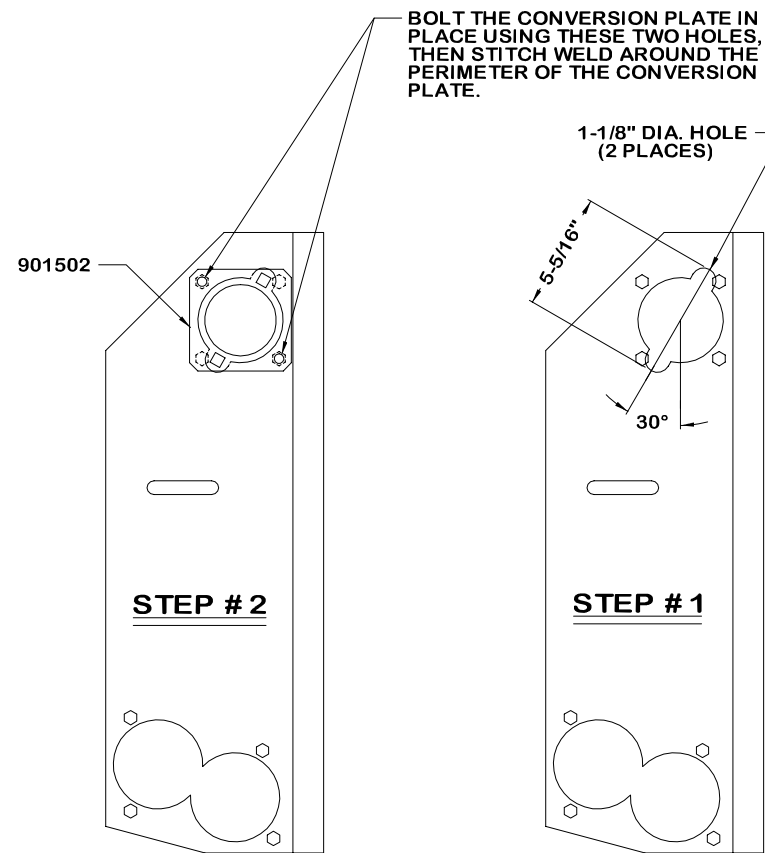
## Recommended Bolt Replacement Order

If more than one bolt is being replaced, follow the order given below for each side.

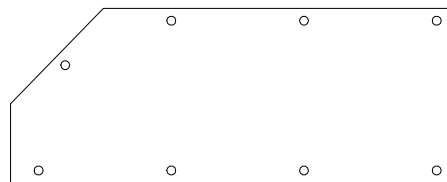




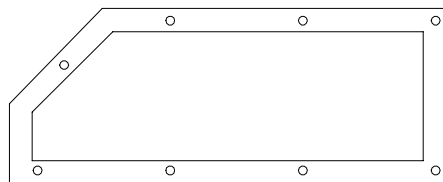
**L.H. SIDE VIEW**



**R.H. SIDE VIEW**



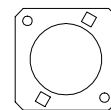
**INSPECTION COVER  
# 905274  
(1 REQUIRED)**



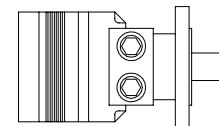
**INSPECTION COVER  
GASKET # 905271  
(1 REQUIRED)**



**INPUT DRIVE SPROCKET  
(60 BS 12 x 1") # 119014  
(1 REQUIRED)**



**HYDRAULIC MOTOR MOUNT  
WELD PLATE # 901502  
(1 REQUIRED)**



**HYDRAULIC MOTOR  
(ME SERIES) # 113030  
(1 REQUIRED)**



**PTO TO HYDRAULIC CHAIN CASE  
CONVERSION KIT # 405030**

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**PTO TO HYDRAULIC CHAIN CASE CONVERSION KIT #405030****Parts List**

<u>Item No.</u>	<u>Part No.</u>	<u>Qty</u>	<u>Description</u>
1.	113030	1	Motor, Hydraulic (ME Series)
2.	119014	1	Sprocket, Input Drive (60BS 12 × 1")
3.	901502	1	Hydraulic Motor Mount Weld Plate
4.	905274	1	Inspection Cover
5.	905271	1	Gasket, Inspection Cover