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IMPORTANT:

Read complete manual before setting up and operating pin and bushing press.

CAUTION: OPERATOR MUST WEAR SAFETY GLASSES WHEN OPERATING PRESS. OPERATOR MUST WEAR SAFETY GLASSES AND EAR PROTECTORS WHEN OPERATING IMPACT WRENCH.

A. INSTALLATION

The pin and bushing press is shipped broken down into two (2) major pieces, main frame and power conveyor. The other major components are the conveyor sections and the impact wrench along with all the mounting hardware (optional).

- I. Track Press
 - a. Locate main frame on a level concrete floor. See Figure X for press overall dimensions. For dirt floors, use concrete pads under the press mounting pads. Bolt press to floor with 1" bolts (minimum diameter), and washers. Use heavy duty expansion bolt anchors.

Note: It is recommended that press be bolted to floor. If press is not bolted down, it will slide on the floor when winching large tracks to the conveyor.

- b. Place power conveyor on conveyor support, bolt to rear of press. Fasten to press and locate conveyor stand; bolt stand to floor with 1/2" bolts and washers. Connect lift cyclinder to power conveyor. See Figure IV.
- II. Conveyor System (Optional) and Pad Lifter (Optional)
 - a. Locate the horizontal conveyor sections with reference to the power conveyor on the conveyor stands. Bolt together and to stands. Fasten stands to floor with 1/2" bolts and washers. See Figure IV.
 - b. Locate and fasten incline conveyor.
 - c. Assemble Pad Lifter per Figure IV.
- III. Impact Wrench (Optional)

The impact wrench is shipped broken down as shown in Figure VI.

- a. Slide the carriage assembly onto the side rails. Move this assembly the full length of the conveyor to insure free movement. If the wheels bind or are too loose, adjust the distance between them by addition or deletion of spacers.
- b. Turn adjusting nut onto the carriage post and place bearing in circular groove. Place impact wrench on post. Balance of impact wrench can be adjusted by loosening bolts on pivot mount, shifting wrench frame and retightening bolts.
- IV. Hydraulic System
 - a. Connect two (2) hoses to hydraulic motor on winch, at end of power conveyor.
 - b. Connect two (2) hoses to hydraulic lift cyclinder for pad lifter. Hoses to be connected as marked.

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c. Fill hydraulic reservoir with 70 gallons of hydraulic fluid. Use a premium quality hydraulic oil DTE light or equivalent:

150 SSU at 100° F

50 SSU at 210° F

with anti-wear and anti-foaming additives.

V. Electrical

WARNING: VERIFY THAT ALL POWER CABLES ARE DISCONNECTED AND THAT ALL SWITCHES ARE OFF PRIOR TO MAKING ANY ELEC-TRICAL CONNECTIONS.

- a. Connect cables from electrical box on hydraulic power supply to conveyor drive motor and cord reel. See Figure II.
- b. Check power requirements on press against power availability to prevent damage to press electrical circuit. Connect press to AC power. Customer to furnish a proper sized fuseable disconnect.
- c. Connect impact wrench motor cable to AC power. Customer to furnish a proper sized fuseable disconnect. Locate and assemble the electrical cable carrier per Figure VII.
- VI. Start Up
 - I. Electrical
 - a. Check that all hydraulic connections are tight and that there are not any kinks in the hydraulic hoses.
 - b. Check hydraulic reservoir to verify it is full of oil.
 - c. Check that control valves are in the neutral position, center position. Turn ram force control valve counterclockwise to run system at minimum pressure, approximately 100 psi.
 - d. BR330S Before running the press, check the rotational direction of the hydraulic pump unit. The motor shall rotate in the direction shown by this arrow, located in red on the mounting base. To check it, jog the motor by pressing the START and STOP pushbuttons in rapid succession while someone watches the motor fan. If the motor rotates in the wrong direction, reverse the power leads. The low pressure pump may be run in either direction.
 - e. BR2505 The high-low pressure pumps may be run in either direction. Check rotation of impact wrench. When handle is rotated clockwise, impact wrench is loosening bolts; when rotated counterclockwise, wrench is tightening bolts. If rotation is reversed, disconnect power and interchange leads. Recheck.

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2. Hydraulic

Note: All air must be removed from the hydraulic circuit before the press is operated. A failure to remove air can result in a shockwave sufficient to damage hydraulic components. Any time a line is removed or the oil level falls below the suction filters, air will enter the circuit and it must be purged out.

- a. Start the press pump and let it run one (1) hour. Slowly extend and retract the right ram a couple of times. Repeat with the left ram. Place rams in retracted position and turn off press. Check hydraulic reservoir oil level. Oil should be one-half way between lines on level gauge. Add oil if required.
- Remove cover from hydraulic power supply. Start hydraulic press. Check all fittings for leaks and tighten if necessary. Advance both rams against a stationary load, such as a large, solid steel bar with ends parallel and a minimum of 15 square inches for the BR250S or 24 square inches for the BR380S. While holding one ram control valve handle in the advance position, turn ram force valve clockwise to increase pressure. At approximately 1000 psi increments, up to and including 5300 psi for BR3 0S and 6300 psi for BR250S, check all fittings for leaks. Tighten fittings if necessary. Recheck and retract rams. Check winch fittings by operating unit a few minutes.

Note: All hydraulic fittings are leaktight when press leaves the Centurion Industries, Inc. plant, but vibrations from shipping may cause them to loosen.

d. Operating range

BR2505	250 Tons per Ram (500,000 lbs.) at6300 psig
BR 3005	330 Tons per Ram (600,000 lbs.) at 5300 psig

B. OPERATION

I. Nomenclature

I. Pin and Bushing Press

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Operating Controls: Stop (Pushbutton) - De-engerizes electrical circuit, hydraulic pump stops.

Warning: Hydraulic circuit from control levers to the rams is a closed system; handles must be shifted through all positions to relieve pressure.

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Start (Pushbutton) – Energizes electrical circuit, hydraulic pump starts.

Right Ram Lever - Controls right ram. Lever shifted to the right, retracts ram; to the left, extends ram.

Left Ram Lever - Controls left ram. Lever shifted to the right extends ram; to the left, retracts ram.

Ram Force Control - Adjusts the pressure to the rams.

Pressure Gauge - Indicates ram pressure in psi.

Index Lift Up (Push Button) – Energizes solenoid valve and lifts conveyor.

Index Lift - Down (Push Button) - Energizes solenoid valve and returns conveyor to down position.

Manual Index - Forward (Push Button) - Advances track to saddle for disassembly.

Manual Index - Reverse (Push Button) - Pulls track from saddle for assembly.

Pad Lift - Up (Push Button) - Activates pad lifter, locks in up position. (Optional)

Pad Lift - Down (Push Button) - Returns pads to down position. (Optional)

Clamp (Push Button) - Holds track in saddle. (Optional)

Unclamp (Push Button) – Returns clamp bar to up position.

Selector Switch - (Optional)

Disassembly - Advance track for disassembly. Assembly - Retracts track when assembling.

Auto Switch - (Push Button) - Lifts track and indexes for next operation. Mode determined by selector switch.

b. Clutch Control Lever - Located on the winch drum. Disengages the winch drum from the conveyor drive.

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Tooling Head - Mounts the track tooling to the rams.

- 2. Impact Wrench (Optional) Figure VI
 - a. Control Handle Controls direction of impact; clockwise rotation, disassembly or loosening of bolts; counterclockwise rotation, assembly or tightening of bolts.
 - b. Wrench Handle Use to position wrench and to apply downward pressure on the bolts.
 - c. Adjusting Nut Height adjusting nut permits raising and lowering of the wrench to insure that the socket fits the bolt head squarely. To insure that this accomplished, the frame of the wrench should be level at all times.
- II. Operating Procedure
 - I. Press Set Up and Track Positioning
 - a. Install the correct disassembly tooling set and saddle.
 - b. Position the track within reach of the winch cable, and in line with the conveyor, to avoid unnecessary handling.
 - c. Check that all control levers are in the neutral position.
 - d. Start the press, allow approximately five (5) minutes warm up time before operating.
 - e. Disengage winch clutch, draw cable over guide roller. Pull out to track at end of conveyor.
 - f. Attach winch cable to the track, thru third or fourth link, with a rod through the links.

CAUTION: CHECK THAT WINCH CABLE IS SECURELY ATTACHED TO TRACK AND CONVEYOR IS CLEAR OF OBSTRUCTIONS.

- g. Engage winch clutch, energize conveyor and winch drive. Pull track full length of roller conveyor. DO NOT REMOVE WINCH CABLE.
- h. Remove track shoes. See Section B.II.5.
- i. Use winch to pull track to power conveyor. Detach winch cable from track and wind on drum, attaching loop to bracket. Disengage winch clutch lever.
- 2. Disassembly Without Track Shoes
 - a. Adjust height of tooling, with set screws, so that tooling is in line with pin and bushing. Place selector switch in Auto mode (optional).

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SADDLE CLAMPING PROCEDURE

LBOLT TORQUE SEQUENCE TIGHTEN ALL BOLTS IN SEQUENCE SHOWN STEP 1. TIGHTEN ALL BOLTS TO 10 FT-LBS 2. RETIGHTEN ALL BOLTS TO 150 FT-LBS 3. IMPACT ALL BOLTS TO 600 FT-LBS

SADDLE ONLY. DO NOT USE KEY TO LOCK SADDLE IN PLACE. ζ () () 10 1 19 ⊕²⁰ O $\overset{r}{\odot}$ G 15@ <u>()</u> ا $^2 \oplus$ () آ 130 @14 4 @ @ 3 17 ① B/Đ 80 \bigcirc ⁷ 21 1 @22 @ 11 12 @ ξ

NOTE:

KEY IS USED TO ALIGN

- b.
- Insert master bushing spacer into the pin sleeve to remove the master bushing.

CAUTION: TO PROTECT THE LIFE OF THE TOOLING, USE ONLY THE REQUIRED PRESSURE TO OBTAIN THE DESIRED RESULT.

Note: See manufacturer's manual for track rebuilding criteria.

- b. Extend the right ram to remove the master bushing and pin, retract the ram. This action will carry the right side link on the pins.
- c. Extend the left ram to remove the bushing and pin, retract the ram.
- d. Remove and store the disassembled parts from the left and right ram pins and the saddle.
- e. Remove master bushing spacers from the pin sleeves.
- f. Lift conveyor; advance track, with power conveyor, one link and lower conveyor. Disassemble track. Repeat steps b through d and Step f until track is completely disassembled.
- 3. Assembly Without Track Shoes
 - a. Install the correct assembly tooling set, adjust, and place selector switch in assembly.
 - b. Position track pin and bushing in saddle nearest operator. Place right and left side links over the locating pins on the tooling.
 - c. Extend the right ram until the side link contacts the saddle, the ram must remain extended, return control lever to the neutral position.
 - d. Extend the left ram until the bushing is in contact with both sidelink seats. Extend left and rim ram until the track pad holes are aligned. Check hole location with the track gauge plate.

Retract rams.

CAUTION: SEALED AND LUBRICATED TRACK

It is important to adjust the track press pressure to the correct assembly force for the track being assembled. There must be enough force to install the links so the thrust rings are pushed against the bushing ends at the bottom of the link counterbore to insure correct height for the seal assembly. Use of an assembly force higher than the maximum force

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given in the chart that follows can cause damage to the thrust rings and seals.

See manufacturer's manual for proper track press pressure.

- e. Lift conveyor, slide back until bushing drops into rear saddle. Lower conveyor. After a few lines are assembled, depending on size, the power conveyor will pull the track back.
- f. Repeat steps b, c, d, and e, until entire track has been assembled.
- g. Insert the master bushing spacers into the right and left bushing pins to install the master bushing.
- h. Assemble track shoes.

4. Disassembly With Track Shoes

On some types of tracks the grouser interlocks laterally with the link assembly behind it. The BR200/BR300 is designed to allow disassembly or assembly of track with shoes attached to one side link of each track segment.

Note: The following procedure is based on unbolting the track shoe from the left side link. The right side may also be used by reversing right and left pressing order.

a. Insert master bushing spacer into the pin sleeve to remove the master bushing. (See 2.a.)

CAUTION: TO PROTECT THE LIFE OF THE TOOLING, USE ONLY THE REQUIRED PRESSURE TO OBTAIN THE DESIRED RESULT.

- b. Extend the right ram to remove the master bushing and pin, retract the ram. Lift out the right link and track shoe assembly.
- c. Extend the left ram to remove the bushing and pin, retract ram. Remove the link and bushing.
- d. Remove master bushing spacers from the pin sleeves.
- e. Lift conveyor, advance track one link and lower conveyor. Disassemble track. Repeat steps until track is completely disassembled.
- 5. Assembly With Track Shoes

The height of the track alignment arms for assembly with track shoes is very important.

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TRACK TOOL SET AGO-1273



FIGURE V

- a. Install the correct assembly tooling set and saddle. (See 3.a.)
- b. Position track pin and bushing in saddle nearest operator and the left link over the locating pins on the tooling. The right link, with track shoe attached, on the right track alignment arm, against the saddle side, pushing the pin and bushing to the left.
- c. Extend the right ram until the sleeve presses the right link against the saddle. Ram must remain extended, return control lever to neutral position.
- d. Extend the left ram, press both rams until the left hand track shoe bolts can be hand started into the side link.

CAUTION: SEAL AND LUBRICATED TRACK

It is important to adjust the track press pressure to the correct assembly force for the track being assembled. There must be enough force to install the links so the thrust rings are pushed against the bushing ends at the bottom of the link counterbore, to insure correct height for the seal assembly. Use of an assembly force higher than the maximum force given in the chart that follows can cause damage to the thrust rings and seals.

See manufacturer's manual for proper track press pressure.

- Lift conveyor, slide back until bushing drops into rear saddle. Lower conveyor. After a few links are assembled, depending on size, the power conveyor will pull the track back.
- f. Repeat steps b, c, d, and e until entire track has been assembled.
- g. Insert the master bushing spacers into the right and left bushing pins to install the master bushing.
- h. Tighten track shoe bolts.
- 6. Assembly Tooling Shims

е.

Centurion track assembly and disassembly tooling is designed to fit new track. The following procedure is used to adjust pressing dimension to allow for track wear. See Figure IX. On new track dimensions A_1 and A_2 are equal. Wear is encountered on the bushing face on the side links, causing dimension A_1 to be greater than A_2 . To correct for this wear, shims are inserted between the mounting plate and the plunger body to make A_2 equal to A_1 . This will assure proper alignment to pin, bushing and side links. At times, shims may be required between pin insert base and pin tool holders.



FIGURETX TOOLING

ASSEMBLY

THSASSEMBLY

7. Impact Wrench Socket Alignment

Locate socket so that it fits over and square with the track pad bolt head/nut. If socket does not fit bolt head, check size of bolt and socket. If bolt head has been damaged or deformed, it will be necessary to re-size head. This can be done with an old socket of proper size and a hammer. Place socket on head and hit with hammer or the head can be shaped with a chisel.

8. Impact Wrench Track Shoe Removal

Place socket on bolt head. Turn on unit in proper direction.

Note: Do not allow impacting to continue for more than 15 seconds unless the head is turning. If the nut fails to start in this length of time, stop the motor, reverse the direction of rotation and allow the wrench to impact on the nut for about 2 seconds. When the wrench is agin operated in the proper direction, the frozen nut usually will break loose and will turn.

Note: The amount of torque is governed by the time of impacting. Impacting continuously for more than 15 seconds at a time on a bolt, places a severe strain on the impact wrench.

9. Impact Wrench Track Shoe Assembly

Insert bolt through track pad and link, turn nut on hand tight. Tighten bolt and nut with impact wrench to specified torque. After tightening, check with a torque wrench. With a little practice, the operator will soon determine the amount of impacting required to obtain the proper torque of the bolt and nut.

10. Pad Lift

Used to hold pads above track while rebuilding. Pads will align with side plates, when lowered on re-built track.

C. MAINTENANCE

- I. Pin and Bushing Press
 - I. Hydraulic System
 - a. The hydraulic system is shown schematically in Figure III. The track press features an open-center control and dual pump system. The open center, dual pump control, allows the system to deliver low pressure, high volume flow for the rapid traverse of the rams. High pressure is used only as required by the rams for disassembly and assembly of the track. When the track press is in the idle period, control valves in the open or off possition, there is a minimum of heat generated and electrical power used.

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CAUTION: Always bleed the hydraulic system if the fluid has been exposed to air in any way. Serious damage may otherwise occur.

b.

Hydraulic Fluid Replacement

Due to the build-up of contamination in the hydraulic system, the fluid must be changed periodically to prevent clogging and malfunction of the components. Replace the fluid after the first four (4) months of operation, and every eight (8) months thereafter.

The hydraulic tank holds approximately 70 gallons of fluid. Remove drain plug at end of tank and drain into a suitable container. Dispose of used fluid in approved disposal sites.

Fluid Replacement Procedure:

- I. Retract rams.
- 2. Disconnect electrical power.
- 3. Open fill cap.

4. Drain tank.

Note: Do not operate equipment while draining tank.

- 5. Replace filter.
- 6. Fill tank with proper hydraulic fluid. See Section A.VI.b.
- 7. Connect electrical power and bleed system.
- c. Return Line Filter

Replace hydraulic fluid filter after first 100 hours of operation and every 500 hours of operation thereafter. Filter operation can be checked by observing pressure guage that is mounted on filter frame.

- 2. Lubrication (Figure I, Sheet I)
 - a. Guide roller bearing, located on the power conveyor, should be greased every twelve (12) weeks with a Lithium based grease.
 - b. Drive chain and bearings do not have to be greased. The drive chain is a self-lubricating chain, while the bearings are greased at the factory for life.
 - c. Pad lifter axle to be greased every twelve (12) weeks with a

Lithium based grease.

3. Electrical (Figure II)

The electrical system for the press consists of a start and stop switch, control push buttons, solenoid valve coils, motor starter and the fuseable disconnect, furnished by the customer. Most failures in the electrical circuit can be traced to an open fuse caused by a momentary overload.

4. Cleaning

The external surfaces of the press and the floor should be kept clean. The hydraulic components, lines, valves and pump, should be kept clean to minimize the possibility of contaminants entering the system when maintenance is performed. Clean hydraulic connections will also simplify inspection for hydraulic leaks.

5. Winch

For information on the winch hydraulic motor, see section on Hydraulics, C.I.I.

a. Inspect cable weekly. If cable shows signs of fraying, remove frayed end or replace entire cable.

CAUTION: A frayed, cut, or otherwise damaged cable is not to be used. The winch has a pulling capacity of 8000 lbs. and a broken cable can cause serious injury or death.

- b. Check oil level in winch gear box weekly, adding oil if required. Drain gear box every six (6) months, refill with gear lubricant EP 90.
- c. Grease clutch bearing monthly with a Lithium based grease.
- 6. Power Conveyor
 - a. Conveyor drive chain does not require any lubrication as it is self-lubricated.
 - b. Grease drive roll and idler bearings same as guide roller bearings.
- II. Impact Wrench (Optional)
 - I. Belt Tensioning

Belts must be kept at a proper tension during wrench operation. After first week of operation, belts are to be checked and retightened using the following procedure: NOTE: See Figure VI for location and description of components.

- a. Remove wrench head cover and motor guard, inspect belts.
- b. Loosen motor adjustment bolts and idler assembly hold-down bolts.
- c. Tension short belt first (impactor to idler), tighten idler assembly hold-down bolts.

NOTE: Belts are adjusted by tightening bolt which moves the motor mounting back.

d. Tension long belt (idler to motor), tighten motor adjustment bolts.

IMPORTANT: After initial tensioning of belts, they should be inspected at three (3) month intervals and tensioned if necessary.

2. Lubrication

a. Impact Wrench

- Proper lubrication is of prime importance for trouble free service and efficiency of this wrench. After each four (4) hours of operation, or as experience indicates, insert about 1-1/2 ounces (44.4 ml) of Centurion Impact Grease #57128 through the grease fitting, Item 7, Figure II. A substitute for 57128 is not recommended, but in an emergency, a good sticky, semi-fluid gear grease may be used. Use grease sparingly. Excessive lubrication will retard the action of the tool.
- 2. IMPORTANT: Occasionally remove the impact unit, as described in the next section, for lubrication inspection. Check, and if necessary, coat with Centurion Impact Grease 57128, the jaws of both hammer and anvil, the pilot of the arbor that enters the anvil, and the shank of the anvil that takes its bearing in the hammer case. Apply grease evenly and sparingly. An excessive accumulation of grease in the hammer case will result in sluggish operation. Insert about 1/2 teaspoonful of 57128 grease into each of the two holes in the wall of the hammer, working it back into the cam grooves.
- b. Carriage and Drive

All bearings are sealed and require no lubrication.

- 3. Hammer Unit Maintenance
 - a. Remove impact wrench from housing by removing bolts and

b.

Disassembly - withdraw the hammer complete 058147 and the anvil 058150 from the hammer case 058148, Figure IX. Lift the anvil 058150 and the anvil driver 058149 from the arbor 058151. After washing as much grease as possible from the hammer assembly, set it upright on the table of an arbor press so that the rear face of the ball cam 058142 is supported. Slide a suitable sleeve (2" pipe, 2-1/2" long) over the pilot of the arbor 058151 and seat it on the top of the hammer jaws. Press on the sleeve, forcing the hammer over the ball cam until the cam balls 058145 emerge from the holes in the hammer wall. Release the press pressure and lift off the hammer 058147, arbor 058151 and hammer spring 058146. Slide the hammer spring thrust bearing 058144 and the friction drive washer 058143 from within the ball cam.

1. Hammer Case - (Refer to section drawing) Figure IX

The hammer case <u>058148</u>, which houses the ball-andcam type impact unit, is the largest extend aluminum casting. Its front bore, through which the anvil <u>058150</u> protrudes, is fitted with a steel hammer case bushing 058152, which is renewable.

2. Bushing Renewal

Stand the hammer case upright on its large open face on the table of an arbor press. Place a suitable arbor, preferable one that will pilot in the bushing bore, against the top face of the bushing and press the bushing from the case. Support the front end of the hammer case on the table of an arbor press in such a manner that the support will not interfere with the front end of the bushing, should it protrude slightly from the case when installed to full depth. Place the bushing within the hammer case and start the small end of the bushing squarely into the small bore at the front of the case. Press the bushing in until its flange seats against the should in the case.

CAUTION: THE BUSHING IS PRESSED INTO A STEEL INSERT WHICH IS CAST INTO THE HAMMER CASE. DO NOT PRESS ON THE INSERT; PRESS ONLY ON THE BUSHING.

c. Assembly

Place the friction drive washer <u>058143</u> in the ball cam <u>058142</u>. Arrange the three parts of the hammer spring thrust bearing <u>058144</u> so that the retainer and balls are between the grooved faces of the front and rear races. Lubricate the bearing with #57128 Centurion Impact Grease and slide it into the ball cam so that the race containing the hexagon hole



ITEM	DESCRIPTION	PART NO.	ITEM	DESCRIPTION	PART NO.
1 2 3 4 5 6 7 8 9	Grease Fitting Shaft Pulley & Bushing Adaptor Bearing Gasket Ball Cam Friction Washer Thrust Bearing	031-102 B49-844 062-135 C49-441 025-237 058-141 058-142 058-143 058-144	11 12 13 14 15 16 17 18 19	Hammer Spring Hammer Hammer Case Anvil Driver Anvil Arbor Case Bushing Lock Pin Lock Ring	058-146 058-147 058-148 058-149 058-150 058-150 058-151 058-152 058-124 058-123
10	Cam Ball	058-145	20	Adapter	058-122

FIGURE VIII IMPACT HEAD

enters the ball cam first. Place the ball cam, containing the washer and bearing, on the table of an arbor press. Insert the arbor 058151 into the cam, passing its hexagon end through the bearing bore until it engages the hexagon hole in the rear race. Slip the hammer spring 058146 down over the pilot end of the arbor, seating it on the front race of the bearing. Hold the hammer 058147, jaw end up, align the diametrically opposite holes in the hammer wall with the points of the cam grooves in the ball cam and slide it down over the arbor and ball cam until it rests on the end of the spring. Place a suitable sleeve (2" pipe, 2-1/2" long) over the protruding end of the arbor and against the jaw end of the hammer. Press on the sleeve, forcing the hammer down over the ball cam until a cam ball 058145-can be entered into each cam groove through the holes in the hammer wass. Enter one ball in each hole. With the thumb and forefinger, cover the holes in the hammer to prevent the balls from dropping out, and slowly release the press pressure. The cam balls will hold the parts together as a unit. Remove it from the press and slide the anvil driver 058149, lug end first, onto the pilot of the arbor that protrudes from the front of the hammer. Make certain that the rear hexagon section of the arbor is entered in the hexagon hole in the hammer spring thrust bearing rear race and kept in engagement until the Impact Wrench is completely assembled. If the arbor can be rotated with the fingers, the parts are not engaged. Enter the pilot of the arbor 058151 into the bore of the anvil 058150 making sure that the jaws of the anvil do not seat against the ends of the anvil driver lugs, but will contact the sides of the lugs when rotated.

d. Installation

Check shaft and bearings, Figure VIII. Lightly grease shaft. Slide impact wrench on shaft and bolt in place.

III. Conveyor System (Optional)

The conveyor system should not require any maintenance. The bearings in the rollers are lubricated for life.

IV. Tooling (Optional)

Visually inspect the pin and bushing tooling before use on a track. If they are damaged, bent or flared they should be replaced.

D. TOOLING

- I. Pin and Bushing Press
 - 1. Instruction
 - a. Figure V illustrates the basic tooling used for the disassembly and assembly of track. The tooling components are identified

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on the tooling chart, Section D.I.2.

b. Each tooling adapter is mounted on the tooling head, and bolted into place. The pin side of the tooling adapter is always toward the conveyor.

- E. SEALED AND LUBRICATED TRACK DISASSEMBLY AND ASSEMBLY PROCUEDURE
 - I. Follow manufacturer's procedure for disassembly and assembly of sealed and lubricated track.
 - II. Seal Assembly
 - A. Adjust track press pressure to correct assembly force. DO NOT USE HIGHER PRESSURE OR SEALS CAN BE DAMAGED.

TRACK PRESS PRESSURE

	FORCE MAX. LBS.	CENTURION BR200/300
CAT DI0	270,000	2390
CAT D9	250,000	2210
CAT D8,983	200,000	1770
CAT D7,977	150,000	1325
D6,955*	120,000	1060
D5,951,955#	100,000	885
D3,D4 931,941	72,000	635

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- B. Position track pin and bushing in track press. The locating mark on the end of the pin must be toward the wear surface of the track link, down, and the worn surface of the bushing up, 180° from the mark.
- C. Clean end of bushing and put lubricating oil on end. Clean and remove burrs from thrust ring and install on track pin.
- D. Put liquid gasket on outer one-third of link track pin bore.
- E. Lubricate face of seals and remove dirt from the seal band area. DO NOT REMOVE HARDENED DIRT FROM OUTSIDE THE SEAL BAND.

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- F. Position track links on press and assemble links to bushing.
- G. Check bushing projection beyond the link.



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IV. Seal Test and Lubrication

Test seal and lubricate per CENTURION MODEL STL SEAL TESTER AND LUBRICATOR MANUAL.

CENTURION IMPACT WRENCH SOCKETS



PART NUMBER	DESCRIPTION	PART NUMBER	DESCRIPTION
058125 058126 058127 058128 058129	Socket, 3/4" x 1" Socket, 13/16" x 1" Socket, 7/8" x 1" Socket, 15/16" x 1" Socket, 1" x 1"	058130 058131 058139 058140	Socket, 1-1/16" x 1" Socket, 1-1/8" x 1" Socket, 1-5/16" x 1" Socket, 1-1/2" x 1-1/2"

* Part No. 058140 has 1-1/2" drive. All other sockets have 1" drive.

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ATTACHMENTS

PART NUMBER

DESCRIPTION

058122	Adapter 1-1/2" Female to 1" Male
058123	Lock Ring - 1-1/2" Drive
058124	 Lock Pin - 1-1/2" Drive
058132	Lock Ring - 1" Drive
058133	Lock Pin – 1" Drive

CENTURION HODEL 2505 AND 3305 PIN AND BUSHING PRESS

HYDRAULIC SYSTEM

MAINTENANCE: HYDRAULIC OIL SHOULD BE CHANGED EVERY SIX (6) MONTHS. CHECK FOR DIRT, MOISTURE AND DISCOLORATION OF OIL. IF THE SYSTEM HAS BECOME CONTAMINATED, THEN THE OIL MUST BE CHANGED.

THE FOLLOWING HYDRAULIC OILS ARE RECOMMENDED FOR OPERATIONS ABOVE 30 DEGREES F.:

TEXACO RANDO OIL HD-A CONOCO SUPER HYDRAULIC 15 STANDARD RYKON NO. 15 MOBILE DTE 23 SINCLAIR DURO AW16 GULF NO. 171

OR IF THE ABOVE HYDRAULIC OIL IS NOT AVAILABLE, USE A PREMIUM QUALITY HYDRAULIC OIL WITH:

150 SSU AT 100 DEGREES F. 50 SSU AT 210 DEGREES F.

WITH ANTI-WEAR AND ANTI-FOAMING ADDITIVES.

THE HYDRAULIC SYSTEM HOLDS ABOUT 90 GALLIONS OF FLUID.

DISASSEMBLY OF WINCH 1000, 1100, 1200 SERIES

- Loosen set screw in end bearing collar. Turn collar counter-clockwise with punch to release it from bearing and shaft. Remove end housing assembly from drum shaft.
- Remove retaining ring and drum from shaft. On clutch models remove phenolic friction block and spring from gear case.
- 1000, 1100 SERIES: Drain oil from gear case. Remove hydraulic motor, thrust spacer, bearings and worm shaft from gear case.

1200 SERIES: Drain oil from gear case and brake housing. Remove hydraulic motor, thrust spacer and bearing from gear case. Remove brake housing cover, brake components and brake housing. Remove bearing, spacer and worm shaft from gear case. For brake assembly and adjustment see "ABSEMBLY INSTRUCTIONS - OIL COOLED ADJUSTABLE AUTOMATIC SAFETY BRAKE".

 Remove gear case cover. Remove bronze gear and drum shaft as a unit being careful not to damage shaft seal.

> NOTE: Bronze gear is press fit on shaft. DO NOT remove unless absolutely necessary.

Model number prefix (stamped in gear case cover) indicates model series and drum shaft size:

No prefix designates 1000 Series winch with 1-1/4" drum shaft.

Prefix "10" designates 1000 Series winch with 1-1/2" drum shaft.

Prefix "27" designates 1000 Series winch with 1-1/2" drum shaft and old style 27:1 ratio gears.

Prefix "11" designates 1100 Series winch with 1-1/2" drum shaft. Prefix "12" designates 1200 Series winch with 1-1/2" drum shaft.

ASSEMBLY OF WINCH 1000, 1100 SERIES

- 1. Clean gear case and all parts thoroughly.
- 2. If bronze gear has been removed from shaft, care should be used to press the gear onto the shaft squarely. Locate end of gear hub (the set screw side) 21/32" from the shaft end on 1-1/4" shaft models and 3/4" on 1-1/2" shaft models (Section A-A).



SECTION A-A

- 3. Install oil seal and bearings. Install drum shaft assembly into gear case carefully to prevent damage to the shaft seal.
- 4. Bolt cover to gear case without shim gaskets. Tighten the screws lightly and evenly. Measure clearance with a feeler gage (Section A-A) and remove cover. For proper bearing pre-load, install shim gaskets (red -.002"; blue - .005"; brown - .010") as required with a thickness that is .003" to .005" less than the measurement. Re-bolt cover securely.
- 5. Install worm shaft. Be sure that the shaft end opposite the motor is seated properly in the bearing cone. Install bearing cone and cup on motor end being sure large end of bearing cone is seated against worm shoulder (Section 8-8).
- 6. Place thrust spacer against bearing. Bolt motor to gear case without shim gaskets with cap screws and lock washers. Tighten the screws lightly and evenly. Measure clearance with a feeler gage (Section B-B) and remove motor. For proper bearing pre-load, install shim gaskets (red - .002"; blue - .005"; brown - .010") as required with a thickness that is .003" to .005" less than the measurement. Re-bolt motor securely.



CONTRACTOR STATES

7. DIRECT DRIVE: Place drum and drive dog on shaft. Install retaining ring. Place end housing assembly on drum shaft and slide toward drum until there is about 1/16" clearance between housing and drum. Place collar on bearing being sure it is properly seated on bearing eccentric. Turn collar clockwise with punch until bearing and shaft are held tight, then tighten set screw.

Install spring and phenolic friction block in gear case. CLUTCH MODEL: Grease drum shaft (including splines) with multi-purpose lithium grease or equivalent to assure free operation of drum and clutch dog. Place drum on shaft and install retaining ring to hold drum against friction If yoke is not already securely fastened to clutch handle shaft, block. refer to" REPLACEMENT OF CLUTCH HANDLE AND YOKE" page. Grease clutch dog groove and place on drum shaft with spring and washer. Install end housing assembly on drum shaft placing yoke in clutch dog groove. Slide end housing toward drum until there is about 1/16" clearance between housing and drum. Place collar on bearing being sure it is properly seated on bearing eccentric. Turn collar clockwise with punch until bearing and shaft are held tight, then tighton set screw.

The dog is designed to engage fully into the drum when the springloaded clutch handle pin is in the hole closest to the drum. Check that the drum turns freely when the clutch handle pin is in the hole farthest from the drum. Refer to "REPLACEMENT OF CLUTCH HANDLE AND YOKE" page.

8. Fill gear case with (2) pints BLOOM #601 trans-worm gear oil. The hardened steel worm shaft must run in oil. For emergency situations when BLOOM #601 oil is not immediately available, use Philube SMP gear oil SAE Grade 80-90 or equivalent. Continuous use of oil other than BLOOM #601 oil may shorten the life of the gears. DO NOT mix BLOOM #601 oil with more than 50% of any other kind of oil.



*For tapped holes and milled top pads order tow protile parts.

F. REPLACEMENT PARTS

I. How to order parts

All parts may be ordered through Factory:

CENTURION INDUSTRIES, INC. 45 Capitol Drive Oconomowoc, WI 53066 Phone: 414-567-3993 Twx: 62899469 Fax: 414-567-4307

WHEN ORDERING, ALWAYS GIVE THE FOLLOWING INFORMATION;

- 1. Part Numbers(s) listed on the component or assembly drawing. (Never order by Item Number or Code Number.)
- 2. Complete Part Description.
- 3. Serial Number and Model Number found on the metal label of each machine.

4. State quantity desired.

5. State when delivery is required.

-NTURION INDUSTRIES INC. PAS HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR G.125 PITCH \$3-931

		Y			
PIN SIZE	LINK ASSEMBLY		D3,931 SEALEI 659605 1.127øx6.156 1.850øx4.222	1.128\$×6.16	GY1711 1.127 8×6156
DESCRIPTION	QTV			x 3.707	SEALED
SADDLE	1	DI054-017A	D1054 017A	E1054-017A	
TOOL MOUNT	4	757A	757A	TSTA	AFER
SPACER, BUSHING	2	· N/A	761	N/A	N/A
DISASSEMBLY	2	812	11/27	812	1127
BUSHING TOOL DISASSEMBLY	2	811	811	811	811
PIN HOLDER ASBEMBLY	2	816	816	816	816
PIN INSERT ASSEMBLY	2	814	814	814	814
BUSHING HOLDER ABSEMBLY	2	815	815	815	815
BUSHING INSERT ASSEMBLY	2	813	1128	813	112.8
SPRING	4	56-0146	56-0146	56-0146	56-0146
GAUGE PLATE	1	N/A	36A	N/A	36A
SET SCREW	4	36-0261	36-0261	36-0261	36-0261
JAM SCREW	4	36-0262	36-0262	36-0262	36-02.62
SOC HO SCREW	4	36-0371	36-0371	36-0371	36-0371
SHIM (PIN)	0J	B1927-022	B1927-022	61727-022	B1927-022

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SHEET 2 OF 3

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CATERPI	L	AR 6.125	PITCH	Q3-931	
PIN SIZE BUSHING SIZE	INK ASSEMIBLY PIN SIZE BUSHING SIZE				
SADDLE	١	D1054-017A	. <u></u>		
TOOL MOUNT	4	757A			
SPACER, BUSHING	2	761			
PIN TOOL DISASSEMBLY	2	1127	a sugara ya waka waka waka ya su ya su ya ka ka waka waka su ya su ya ka		
BUSHING TOOL DISASSEMBLY	2	811			
PIN HOLDER ASSEMBLY	2	816			
PIN INSERT ASSEMBLY	2	814			
BUSHING HOLDER ASSEMBLY	2	815			
BUSHING INSERT ASSEMBLY	2	1128			
SPRING	4	56-0146			
GAUGE PLATE		36A			
SET SCREW	4	36.02.61			
JAM SCREW	4	36-0262			
SOC HD SCREW	4	36.0371			
SHIM (PIN)	5	B1927-022			

INTURION INDUSTRIL INC.

845 HICKORY STREET

PEWAUKEE, WISCONSIN 53072 USA (414) 691 4150

DESCRIPTION		REQUIRED			REQUIRED		
DESCRIPTION	QTY	I.D.	PART Nº	QTY	1.D.	PART Nº	
SADDLE	1	N/A	DI054-017				
TOOL MOUNT	4	757A	B1900-016A				
SPACER, BUSHING	2	761	B1905.028				
PIN DISASSY	2	812	B1902-035	2	1127	B1902.074	
BUSHING. "	2	811	B1901.039				
PIN HOLDER , ASS'Y	2	816	B1904-078				
PIN INSERT , "	2	814	B1903-077				
BUSH HOLDER "	2	815.	131904-077				
BUSH INSERT "	S	813	B1903-076	2	1128	B1903-140	
GAGE PLATE "		36A	CO439-013				
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SOC HD SCREW	4		36-0371		2		
SHIM (PIN)	5		B1927-022				
SPRING	6		56-0146				
SET SCREW .	4	ar say agt an ideal at a say a	36-0261		an a		
JAM NUT	4		36-0262				
SOC HD SCREW	9445438 ¹⁰		36-0259				
D3	ANT.	DESCRIPTI	ON				
	PEWAUKEE, WISCONSIN 53072						
TITLE	TITLE G.125 PITCH						
	TOOL SET						
		*****		**************************************		2730-000	
DRAWN		олта	L BCALS /	PPROVE		ORA WING NUMBER	
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MODEL LINK ASSEMBLY PIN SIZE BUSHING SIZE DESCRIPTION QTV			4K7136 1.314\$X7.00 1.994\$X7.804	11314 px 7.22	
SADDLE	١	D1054-004	01054-004	D1054-004	D1054-004
TOOL MOUNT	4	760A	760A	760A	760A
SPACER, BUSHING	2	789	789	N/A	
PIN TOOL DISASSEMBLY	2	914	914	914	914
BUSHING TOOL DISASSEMBLY	2	1145	1145	911	911
PIN HOLDER ASSEMBLY	2	795	795	795	795
PIN INSERT ASSEMBLY	2	793	793	793	793
BUSHING HOLDER ASSEMIBLY	2	794A	794A	919A	919A
BUSHING INSERT ASSEMBLY	2	792	792	837	837
SPRING	4	56-0146	56-0146	56-0146	56-0146
GAUGE PLATE		32	1391	1392	1392
SET SCREW	4	36-0261	36-0261	36.0261	36-0261
JAM SCREW	4	36-0262	36-0262	36-0262	36-0262
SOC HD SCREW	4	36-0371	36-0371	36-0371	36-0371
SHIMI (PIN)	5	A2904-001	A2904-001	A2904 001	A2904-001

CATERPILLAR 6735 PITCH

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 6735 PITCH

PIN SIZE BUSHING SIZE	LINK ASSEMBLY PIN SIZE BUSHING SIZE		943 Hi RAIL 774629 1.315 Øx7.22 2.119 /2.244Ø X 4.437	D 4.H 3T0352 1.315 \$ x 7.22 2.205 \$ x 4.437	D6, B SEALED 257579,257577 1.4420×8.125 2.1190×5.704			
SADDLE	١	D1054-004	D1054-001A	D1054-001A	D1054-001A			
TOOL MOUNT	4	760A	760A	760A	760A			
SPACER, BUSHING	2	NIA	N/A	N/A	668			
PIN TOOL DISASSEMBLY	2	791	791	791	1146			
BUSHING TOOL DISASSEMBLY	2	911	911	1144	911			
PIN HOLDER ASSEMBLY	2	795	795	795	686			
PIN INSERT ASSEMBLY	2	793	1175	1175	688			
BUSHING HOLDER ASSEMBLY	2	912A	912A	912A	685A			
BUSHING INSERT ASSEMBLY	2	913	913	913	687			
SPRING	4	56-0146	56-0146	56-0146	56-0146			
GAUGE PLATE	1	N/A	N/A	N/A	27			
SET SCREW	4	36-0261	36-0261	36-0261	36-0261			
JAM SCREW	4	36-0262	36-0262	36-0262	36-0262			
SOC HD SCREW	4	36-0371	36-0371	36-0371	36-0371			
SHIM (PIN)	0	A2904-001	A2904-001	A2904-001	A2904-001			

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DEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 6735 PITCH

MODEL 215 EXC D4, C, DSENLED 215 EXC SUS EXC </th <th colspan="7"></th>							
TOOL MOUNT 4 760A 760A 760A SPACER, BUSHING 2 835 835 917 PIN TOOL 2 914 914 914 DISASSEMBLY 2 914 914 914 BUSHING TOOL 2 911 911 911 DISASSEMBLY 2 911 911 911 DISASSEMBLY 2 913 795 795 PIN HOLDER 2 793 793 793 ASSEMBLY 2 915A 836A 919A BUSHING HOLDER 2 915A 836A 919A BUSHING HOLDER 2 915A 836A 919A BUSHING INSERT 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0262 JAMI SCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36	LINK ASSEMBL PIN SIZE BUSHING SIZE	LINK ASSEMBLY PIN SIZE BUSHING SIZE		7152049 1.314 Øx7.000 2.119 Øx 4.804	GTO511 1,314"ØX7.222 2.119"ØX4.996	5W4165 1.325 \$×6.970 2.118/2.125 \$	
SPACER, BUSHING 2 835 835 917 PIN TOOL 2 914 914 914 DISASSEMBLY 2 911 911 911 BUSHING TOOL 2 911 911 911 PIN TOOL 2 911 911 911 BUSHING TOOL 2 911 911 911 PIN HOLDER 2 795 795 793 PIN INSERT 2 793 793 793 BUSHING HOLDER 2 915A 836A 919A ASSEMBLY 2 915A 836A 919A BUSHING INSERT 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0262 36-0262 JAMI SCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36-0371 36-0371 36-0371	SADDLE	١	D1054-023	01054-004	D1064-023		
PIN TOOL 2 914 914 914 DISASSEMBLY 2 911 911 911 911 BUSHING TOOL 2 911 911 911 911 PIN HOLDER 2 795 795 795 PIN HOLDER 2 793 793 793 PIN INSERT 2 793 793 793 BUSHING HOLDER 2 916A 836A 919A BUSHING HOLDER 2 915A 837 837 BUSHING INSERT 2 837 837 837 SEMBLY 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0261 JAM SCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36-0371 36-0371 36-0371	TOOL MOUNT	4	760A	760A	760A		
DISASSEMBLY 2 914 914 914 914 BUSHING TOOL DISASSEMBLY 2 911 911 911 911 PIN HOLDER ASSEMBLY 2 795 795 795 PIN INSERT ASSEMBLY 2 793 793 793 BUSHING HOLDER ASSEMBLY 2 715 793 793 BUSHING HOLDER ASSEMBLY 2 915A 836A 919A BUSHING HOLDER ASSEMBLY 2 915A 836A 919A BUSHING HOLDER ASSEMBLY 2 837 837 837 BUSHING HOLDER ASSEMBLY 2 837 837 837 SPRING HOLDER ASSEMBLY 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0262 36-0262 JAM SCREW 4 36-0371 36-0371 36-0371	SPACER, BUSHING	2	835	835	917		
DISASSEMBLY C III III III III PIN HOLDER 2 795 795 795 ASSEMBLY 2 793 793 793 PIN INSERT 2 793 793 793 BUSHING HOLDER 2 915A 836A 919A BUSHING HOLDER 2 915A 836A 919A BUSHING INSERT 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0261 JAMI SCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36-0371 36-0371 36-0371	1	2	914	914	914		
ASSEMBLY C 195 195 195 PIN INSERT 2 793 793 793 BUSHING HOLDER 2 915A 836A 919A BUSHING INSERT 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0262 36-0262 JAMI SCREW 4 36-0262 36-0262 36-0262	BUSHING TOOL DISASSEMBLY	2	911	911	911		
ASSEMBLY C 193 193 193 193 BUSHING HOLDER 2 915A 836A 919A BUSHING INSERT 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0261 JAM SCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36-0371 36-0371 36-0371		2	795	795	795		
ASSEMBLY C IIII COULD NIME BUSHING INSERT 2 837 837 837 ASSEMBLY 2 837 837 837 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0261 JAM SCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36-0371 36-0371 36-0371	3	S	793	793	793		
ASSEMBLY 4 051 051 051 051 SPRING 4 56-0146 56-0146 56-0146 GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0261 JAMISCREW 4 36-0262 36-0262 36-0262 Soc HD SCREW 4 36-0371 36-0371 36-0371	BUSHING HOLDER ASSEMBLY	2	915A	836A	A919A		
GAUGE PLATE 1 916 1391 1393 SET SCREW 4 36-0261 36-0261 36-0261 JAM SCREW 4 36-0262 36-0262 36-0262 SOC HD SCREW 4 36-0371 36-0371 36-0371		2	837	837	837		
SET SCREW 4 36-0261 36-0261 36-0261 JAM SCREW 4 36-0262 36-0262 36-0262 SOC HD SCREW 4 36-0371 36-0371 36-0371	SPRING	4	56-0146	56-0146	56-0146		
JAM SCREW 4 36-0262 36-0262 36-0262 SOC HD SCREW 4 36-0371 36-0371 36-0371	GAUGE PLATE	ł	916	1391	1393		
SOC HD SCREW 4 36-0371 36-0371 36-0371	SET SCREW	4	36-0261	36-0261	36-0261		
	JAM SCREW	4	36-0262	36-0262	36-0262		
SHIM (PIN) 5 A2901-001 A2901-001 A2901-001	SOC HD SCREW	4	36-0371	36-0371	36-0371		
	SHIM (PIN)	5	A2901-001	A2901-001	A2961-001		

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SHEET 3 OF 5

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FECOLOTION	REQUIRED			REQUIRED			
DESCRIPTION	QTY	1.D.	PART Nº	QTY	1.D.	PART Nº	
SADDLE	١	N/A	D1054-001A	١	N/A	01054-004	
SADDLE	1	N/A	D1054-023				
TOOL MOUNT	4	760A	81900-019A				
SPACER, BUSHING	2	789	B1905-032	2	835	81905-037	
SPACER, "	2	668	B1905-019	2	917	B1905-044	
PIN, DISASSY	2	914	B1902-045	2	1146	B1902-080	
PIN, "	2	791	B1902-033				
BUSHING , "	5	1145	B1901 - 071	.2	911	B1901-049	
BUSHING, "	2	1144	81901-070				
PIN HOLDER, ASSY	2	795	B1904-074	2	1	B1904-043	
PIN INSERT, "	2	793	B1903-073	2	688	B1903-045	
PIN INSERT, "	2	1175	B1903-150				
BUSH HOLDER "	2	-194A	B1904-073	2	836	81904-083	
BUSH HOLDER "	2	685A	B1904-042	2	912A	B1904-098	
BUSH HOLDER "	2	915A	B1904-099	5	9192	B1904-100	
BUSH INSERT "	2	792	B1903-072	2	837	B1903-082	
BUSH INSERT "	2	687	B1903.044	2	913	B1903-095	
SHIM (PIN)	10		A2904-001			and an a state of the	
SPRING	12		56-0146				
SET SCREW .	8		36-0261				
JAM NUT	8		36-0262		•		
SOC HD SCREW		Participant and an and a second se	36-0259		u vers wier a bassa de la construction		
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DESCRIP	TION		REQ	UIRED	>		REP	UIRED
		ΥTĢ	1.D.	PART	Nº	VTQ	I.D.	PART Nº
GAUGE PLAT	TE	1	32	CO439-	009	ļ	27	C0439-004
GAUGE PLA	TE	١	916	C0430	1.054	١	1391	C0439-070
GAUGE PLF	ITE	١	1392	C0439	- 071	1	1393	CO439-072
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	inen 1980 a	***		9999-9999-9999-9999-2099-2099-2099-2099			**********	аналан тарат да байла дабара бай на аласт на сило са на сило се на На сило се на
			a gana kanada fadi ta fa na dangan kana na	₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩	1		1997 - Harrison Haller an Long Harrison (1997)	
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	- Mini Oli - Bandari da da Miniye Mini Bana an Lan - Eli Manyake e da generada.	~~~~	**************************************	n 492-964 47745 manterally after by the solution of a solution of the solution of the solution of the solution		**************************************		9999-9999-9999-999-999-999-999-999-999
SOC HD SC	REW	8	1	36-0	371		4499-204 ⁹⁻¹ 0010-1149-0 ⁻¹ 09998-0999-0-0-40	249 Mar (240 Mar 14 Ang
SPRING			- - 	56-01	46		9 - Martin Million - Highey Jones I. an ang barakan dan sa	yen en anti OMails Regeleration and Regeleration and a specific and a
SET SCREN	N .			36.02	261	*สุของระเพราะขอ(75)ให้เข้าสุดเรื่า		ריי איז איז איז איז איז איז איז איז איז א
JAM NUT				36-02	52			
SOC HD SC	REW		and slopilarity	36.02	259			
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	C.R.	n Restor Specific Address of the	n an		VNH	(G M))	R N NR S	SINC.
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			6	RWAUKKE			78	
	TILS	Constant and the state of the s	6.71	35 F	NTC	24	442-7-52 ⁴⁴ - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1994 - 1	alen na ferset en sen en e
	*****	1	₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩₩			allen der och anderen	A	1731-001
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BAS HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 6.906 PITCH

MODEL LINK ASSEMBI PIN SIZE BUSHING SIZE DESCRIPTION		3P5757 1.4420x8.125 2.3120x5704	1	774637 1.443\$X8.122	977 (OPT) SEAL "FORMER" 1.442"\$ x8.125 2.312"\$ x5.704
SADDLE	١	D1054-007	01054-007	01054-029	D1054.007
TOOL MOUNT	4	565A	565A	565A	565A
SPACER, BUSHING	2	696	N/A	N/A	696
PIN TOOL DISASSEMBLY	2	1129A	735	735	11294
BUSHING TOOL DISASSEMBLY	2	736	736	-136	736
PIN HOLDER ASSEMBLY	2	738	738	1091A	738
PIN INSERT ASSEMBLY	S	740B	740B	7408	740B
BUSHING HOLDER ASSEMBLY	2	7374	737A	737A	737A
BUSHING INSERT ASSEMBLY	2	1130	739	739	1130
SPRING	4	56-0146	56-0146	56-0146	56-0146
GAUGE PLATE	1	26	N/A	N/A	26
SET SCREW	4	36-0261	36-0261	36-0261	36-0261
JAM SCREW	[:] 4	36-0262	36-0262	36-0262	36-0262
SOC HD SCREW	4	36-0371	36-0371	36-0371	36-0371
SHIM (PIN)	Б	A2904-001	A2904-001	A2904-001	A2904-001

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SHEET 1 OF 3

A2732 -000B

SHEET 2 OF 3

A2732-000R

CALCINI				
MODEL LINK ASSEMR PIN SIZE BUSHING SIZE	9) 2- 11-2-57	1.443¢ X8.122 2.312¢/2.441		
DESCRIPTION	VTQ	X5.214	 	
SADDLE	١	D1054-029		
TOOL MOUNT	4	565A		
SPACER, BUSHING	2	N/A		
PIN TOOL DISASSEMBLY	2	735		
BUSHING TOOL DISASSEMBLY	2	736		
PIN HOLDER ASSEMBLY	2	1091A		
PIN INSERT ASSEMBLY	2	740B		
BUSHING HOLDER ASSEMBLY	2	AREF		
BUSHING INSERT ASSEMBLY	2	739		
SPRING	4	56-0146		
GAUGE PLATE		N/A		
SET SCREW	4	36-0261		
JAM SCREW	4	36-0262		
SOC HD SCREW	4	36-0371		
SHIM (PIN)	5	A2904-001		
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CATERPILLAR 6.906 PITCH

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

INDUSTRILL INC.

		REQUIRED			REQUIRED		
DESCRIPTION	Ţφ	Y I.D.	PART Nº	YTQ	1.D.	PART Nº	
SADDLE)	N/A	D1054-00	51 1	N/A	D1054.029	
TOOL MOUNT	4	565A	B1900-008	3A			
SPACER, BUSHING	2	696	B1905.02	4.			
PIN, DISASS'Y	2	735	B1902-02-	72	1129A	B1902-075	
BUSHING "	2	736	B1901-02	9			
PIN HOLDER , ASS'	Y 2	738	B1904-05	2 19	1091A	B1904-135	
PIN INSERT, "	2	7408	B1903-06	,			
BUSH HOLDER, "	2	737A	B1904-05	8.			
BUSH INSERT , "	2	739	B1903-06	02	1130	B1903-141	
GAGE PLATE "	1	56	CO439-00	3			
<u>,</u>					·		
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		n an	n felgen her falle anter af en				
SOC HD SCREW	4		36-037				
SHIM (PIN)	5		A2904-00	51			
SPRING	8		56-0146	>			
SET SCREW .	6)	36.026		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
JAM NUT	6	>	36-0262	2			
SOC HD SCREW	/ -	n v v ný v náj liti metrodník.	36-025	9			
. ITEM	QUANT.	DEBCRIPT	10N		atoring and the second second		
	CEN	California a construction of the second	ION IND	N TI S M	RIE	SINC.	
	₩ 6.4 k'	v 66 v⊊r 8,18 k	NAS KICKORI		647 & MA	Dear Ch. Als 9 Year 99	
			PEWAUKEE WIS		073		
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			SOL SE				
		999 L.P.B		*****		2732-0001	
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				SH	FET	3 of 3	

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SHEET 1 OF 2

A2733 -000E

v.	and a construction of the second		*****		
MODEL LINK ASSEMBL PIN SIZE BUSHING SIZE DESCRIPTION		1,443°¢x8.122 2.413°¢x5.214	D5H QUAD LINK 9W4185 1.443øx8.122 2.413øx5.214	9W6775 1A42\$X8.125	
SADDLE	١	D1054-027A	D1054-027	D1054-039	
TOOL MOUNT	4	510A	510A	510A	
SPACER, BUSHING	2	· N/A	N/A	696	
PIN TOOL DISASSEMBLY	2.	735	735	APSII	
BUSHING TOOL DISASSEMBLY	.2	736	736	736	
PIN HOLDER ASSEMBLY	2	1091A	AIPOI	738	
PIN INSERT ABSEMBLY	2	740B	740B	740B	
BUSHING HOLDER ASSEMBLY	2	1092A	1092A	TET	
BUSHING INSERT ASSEMBLY	2	1093	1093	1130	
SPRING	4	56-0146	56-0146	56-0146	
GAUGE PLATE		N/A	N/A	1387	
SET SCREW	4	36-0261	36-0261	36-0261	
JAM SCREW	·4	36-0262	36-0262	36-0262	
SOC HD SCREW	4	36-0259	36-0259	36-0259	
SHIM (PIN)	5	A2904.001	A2904-001	A2904-001	

CATERPILLAR 7,480 PITCH

B45 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

DESCRIPTION		REQ	UIRED	REQUIRED			
DESCRIPTION	VTP	1.D.	PART Nº	VTP	1.D.	PART Nº	
SADDLE	١	N/A	D1054-027		N/A	D1054-039	
TOOL MOUNT	4	510A	B1900-002A				
PIN, DISASS'Y	2	736	B1902-027	2	1129A	B1902-075	
BUSHING, "	5	736	B1901-029				
PIN HOLDER, ASS'Y	2	1091A	B1904-135	2	738	B1904.059	
PININSER , "	2	740B	B1.903-061				
BUSH HOLDER, "	S	1092A	B1904-136	2	737A	B1904-058	
BUSH INSERT, "	2	1093	B1903-134	.2	1130	B1903-141	
SPACER, BUSHING	2	696	B1905-024				
GAUGE PLATE	1	1387	C0439-069				
		ος (μερι-μάλμη) μεταγράτετα (μεριογράφει η ημεριογράφοι η του του ματογράφοι η του του ματογράφοι η του του μα					
SHIM (PIN)	15	536/m	A2904-001				
SPRING	4		56-0146				
SET SCREW .	4		36-0261	and a second second			
JAM NUT	4		36-0262				
SOC HD SCREW	4		36-0259				
. Item Q	UANT.	DESCRIPT	ON	ar onther of an area.	i de la companya de l		
	EN'	r II R I	ION INDI	IST	RIE	SINC.	
	r sen⊶aar ti V	wa upar 534,517 83	RAS HICKORY B		ыл-нн (ль (льм9		
			PEWAUKEE WISCO	NSIN 53	078		
TITLE	nga nganaki (1999) nga	2, ٦	+80 PITO	CH	innersyssettigeligen mas dieten versett		
Sam San		To	DOL SE	Г			
		8-6-6 93 /4-6-994/6-896-6-9496.9.		******	A	2733-000	
DRAW	N	DAM	BCALB	PPROV	2	DRAWING NUMBER	

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SHEET ZOF 2

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 7.985 PITCH

			·······		
MODEL LINK ASSEMBL PIN SIZE BUSHING SIZE DESCRIPTION		DGC,D SEALED 3P1088 1757. Øx9.06 2.621 Øx6.365	156877.	227 EXC 5N4583 17520×9.06 2.6210×6.365	963 HI RAIL 774651 1753ØX9.06 2.621 /2746Ø X 5783
		D1054-032	DI054-032	D'054.032	D1054-032
SADDLE	١	DIOSTORE	B	B	.
TOOL MOUNT	4	677A	677A	GIIA	GITA
SPACER, BUSHING	2	723	689	689	N/A
PIN TOOL DISASSEMBLY	2	1134	1132	1134	703
BUSHING TOOL DISASSEMBLY	2	1131	1131	1131	1131
PIN HOLDER ASSEMBLY	2	.726	1139A	726	726
PIN INSERT ASSEMBLY	2	728	723	1176	1176
BUSHING HOLDER ASSEMBLY	2	725A	TZSA	725A	725A
BUSHING INSERT ASSEMBLY	2	727	1136A	727	1138B
SPRING	4	56-0146	56-0146	56-0146	56-0146
GAUGE PLATE		33	1394	33	N/A
SET SCREW	4	36-0261	36-0261	36-0261	36-0261
JAM SCREW	4	36-0262	36-0262	36-0262	36-0262
SOC HD SCREW	4	36-0259	36-0259	36-0259	36:0259
SHIM (PIN)	5	A2904-002	A2904-002	A2904-002	A2904-002

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SHEET 1 OF 5

A2734 -0000

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SHEET 2 OF 5

A2734 -000

r				
	GY 3519	3P1118 1753\$X9.06	158845 1520x11.438	2.621\$ × 6.865
	D1054-032	D1054-032	D1054-032	DI054-032 B
4	677A	6774	677A	GTA
2	N/A	N/A	775	689
2	703	703	1133	1132
2	704	1131	1131	1131
2	1143B	11414	1140A	1139A
2	728	728	1156	728
2	1096A	1096A	1096A	725A
2	1097	1383 B	1137B	1136A
4	56-0146	56-0146	56-0146	56-0146
1	N/A	N/A A	25	28
4	36-0261	36-0261	36-0261	36-0261
4	36-0262	36-0262	36-0262	36-0262
4	36-0259	36-0259	36-0259	36-0259
5	A2904-002	A2904-002	A2904-002	A2904-002
	QTV 1 4 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	Y $6Y3519$ 175370x9.06 2.7460x5.783 A $677A$ A $677A$ A $677A$ A $677A$ A $677A$ A 703 A 704 A 704	YGY 3519 1753 $p \times 9.06$ 2.746 $p \times 5.783$ 3P1118 1.753 $p \times 9.06$ 2.621/2.746 $p \times 5.783$ 1DI054-032 GTVDI054-032 X 5.7834G77AG77A2N/AN/A27037032704113121143B1141A272872821096A1096A210971383456-014656-01461N/AN/A436-026136-0262436-025936-0259	YGY 3519 (1753\$ / x9.06 2.746 / x5.783351118 (1753 / x9.06 (1753 / x9.06 2.746 / x5.783158845 (1752 / x11.438 2.621 / 2.746 / $\frac{21621}{2745}$ / $\frac{4}{27728}$ QTVX 5.783D86 SEALED 2.745ID1054-032 2.621 / 2.746 / $\frac{21621}{2745}$ D1054-032 2.745AG77AG77A G77A2N/AN/A775270370311332704113111312114381141A1140A272872811562708128115621096A1096A1096A210971383 2.60-014611378456-014656-014656-01461N/A25436-026136-026136-0261436-025936-026236-0262436-025936-025936-0259

CATERPILLAR 7.985 PITCH

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

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222222222222	677A 689 775 1132 1134 1131 11435	PART Nº DIO54-032 BI900-015A BI905-023 B1905-030 B1902-076 B1902-078 B1902-078 B1901-069 B1904-155	2 2 2 2 2	703	PART Nº B1905-026 B1902-023 B1902-077 B1901-024
4 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	677A 689 775 1132 1134 1131 11435	B1900-015A B1905-023 B1905-030 B1902-076 B1902-078 B1902-078	2 2	703	B1902-023 B1902-077
222222222222	689 775 1132 1134 1131 1143 ⁵	B1905-023 B1905-030 B1902-076 B1902-078 B1901-069	2 2	703	B1902-023 B1902-077
2 2 2 2 2 2 2 2 2 2 2 2	775 1132 1134 1131 1143 ⁵	B1905-030 B1902-076 B1902-078 B1901-069	2 2	703	B1902-023 B1902-077
2 2 2 2 2 2 2 2 2 2	1132 1134 1131 1143 ⁶	B1902-076 B1902-078 B1901-069	2	1133	B1902-077
2 2 2 2 2 2	1134 1131 11435	B1902-078 B1901-069	2	1133	B1902-077
2 2 2 2 2	1131 11435	B1901-069	{		
2 2 2	11435		2	704	BIGNI-074
2 2		B1904-155	ſ	\	UNUI UCT
2	1139A)			
	•	B1904-151	2		B1904-152
	726	B1904-055	2	1141A	B1904-153
2	1176	B1903-151			
2	728	B1903-057	2	1	B1903-145
S	725A	B1904-054	2	3	B1904-138
2	1136A	B1903-142			B1903-143
S	727	B1903-056	2	1097	81903-136
2	11388	B1903-144	2	1383	B1903-219
١	28	C0439-005	1	in the second	C0439-002
1	33	00439-010		1394	co439-0773
12		56-0146			
10		36-0261			
10		36-0262			
12		36-0259			ne esta das tiles (Daschettering in district in district i district i das des services and the
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	1997 (1999) (1997) (199			A	2734.000
	PATE	BCALS	APPROV	ED	DRAWING NUMBER
	1 12 10 10 10 12 AMT.] EN	1 28 1 33 12 10 10 10 12 MMT. DEEDCRIP ENTUR 7,9 T.	1 28 C0439.005 1 33 C0439.005 12 - 56-0146 10 - 36-0261 10 - 36-0262 12 - 36-0259 ANT. DEBCRIPTION ENTURION IND MAD HECEORY PEWAUKKE WISCO 7,985 PIT TOOL SE	1 28 CO439.005 1 1 33 CO439.005 1 12 56.0146 10 56.0261 10 36.0262 12 36.0259 AMT. DEBCRIPTION ENTURION INDUST MAD HICEORY STREET PEWAUKEE WISCONSIN SE 7.985 PITCH TOOL SET	1 28 CO439.005 1 25 1 33 CO439.005 1 1394 12 56-0146 1 1394 12 56-0261 1 1394 10 36-0262 1 10 10 36-0252 1 10 12 36-0259 1 10 AMT. DEBORNDMOM INDUSTRIE MAD HICEORY STRUET PEWAUKEE WISCONSIN \$5075 7.985 PITCH TOOL SET

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	Unite			C.S.		The second se
	MODEL INK ASSEMBLY PIN SIZE BUSHING SIZE ESCRIPTION QTV		D7H 9G2423 1.878Øx9.882 2937Øx61405	77753	D&N NON PPR GY1136 1.8780×9.882 2.937/3.2140 ×6.405	235 EXC 3V4991 1.877 ØX9.88 2.812 ØX6963 3/4 BOLT
טן	SADDLE	1. 1. 1. 1. Dig(-007 D)0910-007		D1096-002	D1096-001	
	TOOL MOUNT	4	573 A	573A	5734	573A
	SPACER, BUSHING	2	N/A	N/A	NA	922
	PIN TOOL DISASSEMBLY	2	589	589	589	1123
	BUSHING TOOL DISASSEMBLY	2	588	588	588	1107
- N	PIN HOLDER ASSEMBLY	2	11060A	593	593	579
	PIN INSERT ASSEMBLY	2	591A	1177	117	577
and an and a second	BUSHING HOLDER ASSEMBLY	2	592	592	592	578
	ASSEMBLY	2	590	590	590	576A
	SPRING	4	56-0146	56-0146	56-0146	56-0146
and the second second	GAUGE PLATE	1	N/A	N/A	N/A	221
and South and the	SET SCREW	4	36-0261	36-0261	36-0261	36-0261
State of Concession, States	JAM SCREW	4	36-0262	36-0262	36-0262	36-0262
Contraction of Contractions	SOC HD SCREW	14	36-0259	36-0259	36-0259	36-0259
	SHIM (PIN)	- LU	A2904-002	A2904-002	A2904-002	2 A2954-002
2	MASTER PIN SPACER - ASSI	17	N/A	NA	1105	N/A
					4	NTOT NOC

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SHEET 2 OF 5

A2735-000

		REQ	URED	5	**************************************	REQ	UIRED	
DESCRIPTION	QTY	1.D.	PART		QTY	1.D.	PART	Nº
SHIM (PIN)	10		AZ900	4-002				
						6. 		

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				an a				
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SPRING				0146				
SET SCREW			36-0	262				
JAM NUT				0259				
SOC HD SCREV	V QUANT.					and the second secon		an a
9 6 836°0)	DESCRU		and the second	W Y (*8 7	RY KY K '	no FNI	7
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PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 8.500 PITCH

	CATENFICOAN S.=									
F	MODEL INK ASSEMBL' PIN SIZE BUSHING SIZE ESCRIPTION (3V4991, 3/4 BOUT 1.877 \$ x 9.88	3P0955 1.8770x9.88 2.8120x6963	D7E,F,G, 3P0629 1.850ØX9:882 2.812ØX6,409 571A S,A,L.T.	973 HI RAIL 9W 9167 1.878"\$X9,882 2.812" /2.937" \$ X 6,409				
D		1	D1096-001	01096-001	D1096-001	100-01				
-	SADDLE	·								
-	TOOL MOUNT	4	573A	573A	573A	573A				
	SPACER, BUSHING	2	922	580	N/A	N/A				
	PIN TOOL DISASSEMBLY	2	1123	1123	589	589				
	BUSHING TOOL	2	1107	1107	1107	1107				
£	DIN HOLDER ASSEMBLY	2	579	519	579	579				
ALL O'DAY PROVINCIAL OF	PIN INSERT ASSEMBLY	2	577	517	1178	1179				
	BUSHING HOLDER	2	578	578	578 B	578 b				
	BUSHING INSERT ASSEMBLY	2	576A	576A	1384	1384				
Constantine State	SPRING	4	56-0146	56-0146	56-0146	56-0146				
	GAUGE PLATE	1	221	28	NIA	N/A				
Sundharasanan	SET SCREW	4	36-0261	36-0261	36.0261	36-0261				
	JAM SCREW	4	36-02.62	36-0262	36-0262	36-0262				
press of the second second	SOC HD SCREW	4	36-0259	36-0259	36-0259	36-0259				
a a da se state en academica de la compositione de la compositione de la compositione de la compositione de la c	SHIMI (PIN)	E	A2904-002	A2904 00	2 A2904-00	2 42904-002				

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SHEET 1 OF 5

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SHIEET 3 OF 5

A2735-000E

CALCAL CAR 0.000									
MODEL LINK ASSEMIBI PIN SIZE BUSHING SIZE		977 (Former) 1.877Øx9.88 2.812Øx69.63	776037 1.877¢ X9.88	D7 PRO 9W8842 1.878Øx9.882 2.812/2.937Ø X 6.4.09	977 PRO 9W8812 1.878\$x9.882 2.812/2.937\$ X6,409				
		D1096-001	D1096-001	D1096-001	D1096-001				
SADDLE	1.	DI016-001	01010-001	n an construction of the construction of the construction of the second second second second second second second					
TOOL MOUNT	4	573A	573A	573 A	573A				
SPACER, BUSHING	2	580	- 580	N/A	NA				
DIN TOOL DISASSEMBLY	2	1123	1123	589	589				
BUSHING TOOL DISASSEMBLY	2	1107	1107	1107	1107				
PIN HOLDER ASSEMBLY	2	579	679	579	579				
PIN INSERT ASSEMBLY	2'	577	517	ארוו	1179				
BUSHING HOLDER ASSEMBLY	2	518	578	578	578				
BUSHING INSERT ASSEMBLY	2	576A	576A	1384	1384				
SPRING	4	56-0146	56-0146	56-0146	56-0146				
GAUGE PLATE	1	28	28	NA	N/A				
SET SCREW	4	36-0261	36-0261	36-0261	36-0261				
JAM SCREW	4	36-0262	36-0262	36-0262	36-0262				
SOC HD SCREW	4	36-0259	36-0259	36-0259	36-0259				
SHIM (PIN)	5	A2904-002	A2964-002	A2904-002	2 12904-002				
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CATERPILLAR 8.500 PITCH

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

URION INDUSTRIE

SHEET	4	OF	5
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		1		1 1	1
MODEL LINK ASSEMB PIN SIZE BUSHING SIZE		235 EXC 7T9827,7/8BUT 1.8779×9,88 2.8129×6963			
	QTV				
SADDLE	١	D1096-001	•		
TOOL MOUNT	4	573A			-
SPACER, BUSHING	2	922		and the second	
PIN TOOL DISASSEMBLY	2	1123		and and the second s	
BUSHING TOOL DISASSEMIBLY	2	1107			
PIN HOLDER ASSEMBLY	2	579			
PIN INSERT ASSEMBLY	2	517			
BUSHING HOLDER ASSEMBLY	2	578			
BUSHING INSERT ASSEMBLY	2	576A			
SPRING	4	56-0146			
GAUGE PLATE	١	1453			
SET SCREW	4	36-0261			
JAM SCREW	4	36-0262			
SOC HO SCREW	14	36-0259		1 and	
SHIM (PIN)	5	A2904-00	2		
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111(03)		SUFFT	4 OF 5	¢	2735-000

CATERPILLAR 8,500 PITCH

845 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

URION INDUSTRIE



SHEET 1 OF 4

A2736-0000

					T
MODEL LINK ASSEMBLY PIN SIZE BUSHING SIZE DESCRIPTION QTV		D8H,K SEALED 850398 2.003"ØX11.438 2.996/3.038Ø X7.941	9W8938 2.002 Øx11.437	D9L S.A.L.T. 671185 2.003°Ø×11.437 3.228/3.346 Ø x 7.355"	8K4753 2.003ØX11.138
SADDLE		D1096-003	D1096-003	D1096-009	D1096-003
TOOL MOUNT	4	552A	562A	552A	552A
SPACER, BUSHING	2	716	N/A	N/A	1198
PIN TOOL DISASSEMBLY	2	1117	546	546	1117
BUSHING TOOL DISASSEMBLY	2	1118	645	645	1118
PIN HOLDER ASSEMBLY	2	848	848	848	848
PIN INSERT ASSEMBLY	2	850	1180A	875B	850
BUSHING HOLDER ASSEMBLY	2	APIII	111 A	BIZA	1119A
BUSHING INSERT ASSEMBLY	2	874A	547A	1390	874A
SPRING	4	56-0146	56-0146	56-0146	56-0146
GAUGE PLATE	ł	34	N/A	- RYA	34
SET SCREW	4	36-0261	36-0261	36-0261	36-0261
JAM SCREW	4	36-0262	36-0262	36-0262	36-0262
SOC HD SCREW	4	36-0259	36-0259	36-0259	36-0259
SHIM (PIN)	5	A2904-003	A2904-003	A2904-003	A2904-003
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CATERPILLAR 9.000 PITCH

B45 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

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A2736-0000

MODEL LINK ASSEMBI PIN SIZE BUSHING SIZE DESCRIPTION		850398 2.003``Øx11.438 2.996/3.038 Ø	9W8938 2.002 Øx11.437 2.996 /3.163Ø	2.003 Øx11.437	2455 814753 2.003øx11.138 2.996/3.038ø x 7.941				
			D1096-003	D109(0-009	D1096-003				
SADDLE	्रह	D1046-003	01040-003		131010-003				
TOOL MOUNT	4	552A	552A	552A	552 A				
SPACER, BUSHING	2	716	N/A	N/A	1198				
PIN TOOL DISASSEMBLY	2	- 1117	546	546	1117				
BUSHING TOOL DISASSEMBLY	2	8111	545	645	1118				
PIN HOLDER ASSEMBLY	2	848	848	848	848				
PIN INSERT ASSEMBLY	2	850	1180A	875B	850				
BUSHING HOLDER ASSEMBLY	2	APIII	111 AP	872Å	11194				
BUSHING INSERT ASSEMBLY	2	874A	547A	1390	874A				
SPRING	4	56-0146	56-0146	56-0146	56-0146				
GAUGE PLATE	1	34	N/A	- MYA	34				
SET SCREW	4	36-0261	36-0261	36-0261	36-0261				
JAM SCREW	4	36-0262	36-0262	36-0262	36-0262				
SOC HD SCREW	4	36-0259	36-0259	36-0259	36-0259				
SHIM (PIN)	5	A2904-003	A2904-003	A2904-003	A2904-003				

CATERPILLAR 9.000 PITCH

LIVERION INDUSTRIES INC. 845 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CENTURION INDUSTRIES INL. 845 HICKORY STREET

PEWAUKEE, WISCONSIN 53072 USA (414)691-4150 CATERPILLAR 9.000 PITCH (PPR)

MODEL LINK ASSEMB PIN SIZE BUSHING SIZE DESCRIPTION		2.003×10.768 3.228/3.346		0	
SADDLE	1.	D1096-009	<u></u>	ny tao a la guerra de la constante de la consta La	
TOOL MOUNT R.H.	١	C1000-003			en ander en En ander en a
TOOL MOUNT L.H.	ŀ	C1001-003			
PIN TOOL DISASSEMBLY	2	932			
BUSHING TOOL DISASSEMBLY	2	933			
PIN HOLDER ASSEMBLY	2	-935 V			
PIN INSERT NOMINAL	١	937		ang s atang s a sa	
PIN INSERT OTHER SIDE	١	938 🗸			
BUSHING HOLDER ASSEMBLY	2	1153 *			
BUSHING INSERT ASSEMBLY	2	1151	R		
SPRING	4	56-0150			
SET SCREW	4	36-0261		,.	
JAM NUT	4	36-0262			

SHEET 2 OF 4 _____ A2736-000

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DESCRIPTION		REQ	UIRED		pa an an a 1 an an a 1 an	JIRED		
DESCRIPTION	YTP	I.D.	PART Nº	VTQ	1.D.	PART Nº		
SADDLE				١	N/A	D1096-003		
SADDLE	1	N/A	D1096.009					
TOOL MOUNT	1	N/A	01000-003		N/A	C1001-003		
TOOL MOUNT	4	552A	B1900-006A					
SPACER, BUSHING	2	716	B1905-025	2	1198	B1905-065		
PIN, DISASS'Y	2	1117	B1902.071	2:	546	B1902-006		
BUSHING, "	2	545	B1901-006	2	1118	B1901-072		
PIN HOLDER, ASSY	2	848	B1904-087					
PIN INSERT , "	2	850	81903-086	2	875B	B1903-088		
PIN INSERT, "	2	1180A	B1903-155					
BUSH HOLDER , "	2	872A	B1904-088	2	1119A	B1904-146		
BUSH INSERT , "	S	5471	B1903-014					
BUSH INSERT,	2	874A	B1903-087	2	1390	B1903-221		
PIN - DISASS'Y	2	932	B2054-006]				
BUSHING "	5	933	B2055-005					
PIN HOLDER, ASSY	2	935	B2057-010					
GAGE PLATE	1	34	C0439-011					
SPRING	12		56-0146					
SET SCREW .	12	(elegantostania)	36-0261					
JAM NUT	12		36-0262					
SOC HD SCREW	8		36-0259			antari mandra anta antara antari a cana antari m		
ITEM Q	ANT.	DESCRIPT	108					
C	EN	TURI	ION IND	UST	RIE	SINC.		
			145 HICKORY E					
PEWAUKEE. WISCONSIN 59079								
TITLE								
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		C	EN'	TUR	ION IND	UST	RIE	S INC.	•
	•	ITEM QU	JAMT.	DESCRIPT	ION	*** ***			
	SOC HD SC	REW	1 ND -		36-0259				
	JAM NUT				36-0262				
	SET SCREN	North and		27 - 27 - 29 - 29 - 29 - 29 - 29 - 29 -	36-0261			e e	, ,
	SPRING	ninen og sen en e			56-0146	4		56-01	5
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	SHIM (PIN)		10		A2904-003				
4	BUSH INSERT	<u>ار ا</u>	2	1151	C1166-007	·			
	BUSH HOLDER		2	1153	C1165-002				
ł	PIN INSERT	- Asŝy	1:	937	C1166-008	١	938	CII66-0	00
	DESCRIPT	TION	VTP	1.D.	PART Nº	VTQ	1.D.	PART	
	1. • · · · · · · · · · · · · · · · · · ·			REQ	URED		REQ	UIRED	

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1 A	DESCRIP	IUN	VTQ	1.D.	PART Nº	YTQ	1.D.	PART Nº
	PIN INSERT	- Assy	1	937	C1166-008	$= \int_{-\infty}^{\infty} \int_{-\infty}^{\infty} dx dx$	938	000-22110
	BUSH HOLDER	11	2	1153	C1165-002		-	
Î	BUSH INSERT	۰ _۱ ۱	2	1151	C1166-007	· .		
	SHIM (PIN)		10		A2904-003			
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	an a	an a gal aga an			an a	-	<u></u>	
	GORINIC					4		56-0150
	SPRING / SET SCREI	. / .			36-0146			130 0100
	JAM NUT				36-0262	ARCA		
	SOC HD SC	REW	- - 		36-0259	-		
		ward of the second s	ANT.				n a fan fan fan fan fan fan fan fan fan	
			the second second second	DESCRIPT	a na antina any signa baga ing siya mang na pang siya na ang siya ang siya ang siya ang siya ang siya ang siya	1 (1 76)	NN K K N	a NNA
9			EN	I.OKI	ION IND		KIL	S INC.
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MODEL LINK ASSEMBI PIN SIZE BUSHING SIZE		D9N NON PPR GY1130 2,003"\$x10,984 3,163"/3,346" x7,257"			
DESCRIPTION	QTV				
SADDLE	\	D1096-007	· · ·		
TOOL MOUNT	4	1126A			
SPACER, BUSHING	2	N/A			
PIN TOOL DISASSEMBLY	2	1110			
BUSHING TOOL DISASSEMBLY	2	1148			
PIN HOLDER ASSEMBLY	2	ΝΝΑ			
PIN INSERT ASSEMBLY	2	1059			
BUSHING HOLDER ASSEMBLY	2	1149			
BUSHING INSERT ASSEMBLY	2	1057A			
SPRING	4	56-0146			
GAUGE PLATE	ł	N/A	/~		
SET SCREW	4	36-0261	Server and de and an an and a state and an	ο τη που που τη του που τη του που τη του του τη του του τη τ Το που τη του τη του Το που τη του τη του Το που τη του	
JAM SCREW	[.] 4	36-0262			
SOC HD SCREW	4	36.0259	· · · · · · · · · · · · · · · · · · ·		
MASTER PIN Spacer	2	AZ783-003			
SPACER (PIN)	ъ	A2904-003			
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CATERPILLAR 9.448 PITCH

B45 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

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	TTTLE 9.448 PITCH								
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	C	ENT	TURI	ON INDU	ST	RIE	SINC.		
•	ITEM QU	NNT.	DESCROT	ON			n san an a		
Soc HD SC		A		36-0259			- En film fan fan fan fan Distant yn fan de fan		
JAM NUT	r yes all a state of the state	4		36-0262	· .				
SET SCREN	N .	4		36-0261					
SPRING		4	*****	56-0146					
SHIM (PI	N)	0		A2904-003					
	alan gallan da kara ng Lagdo ang kang kang kang kang kang kang kang						· · · · · · · · · · · · · · · · · · ·		
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	n an Color and a construction of the second of the				94 - 19 - 19 - 19 - 19 - 19 - 19 - 19 - 1				
<u></u>	1977-1977-1977-1971-1979-1971-1971-1971			•					
MASTER PIN S	PACER	2		A2783-003					
BUSH INSER		2	11057A	B2056-017			1939		
BUSH HOLDER	en de la companya de	2	t terretor and the second secon	B1904-156	•		1937		
PIN INSERT		2		B2056-018					
PIN HOLDER,			11114						
BUSHING, "	n christen an	2		81901-068			1936		
PIN, DISASS	514	2	1110	B1902-070	2		1935		
TOOL MOUN	TL	4		B1900-027A			C-1000-004		
SADDLE		1	N/A	D1096-007	1		1096-007		
DESCRIP	TION	VTP	1.D.	PART Nº	QTY	1.0.	PART Nº		
mre cours	TIAN	REQUIRED				REQUIRED			

IURION INDUSTRIE .C. BAS HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 10.250 PITCH

<u>``</u>		·		4 A 1	1
PIN SIZE BUSHING SIZ	E	9W8320 2.2530×1225 3.371/3.4960	85 1731 2.2530×12.25 3.3710×8.856	3.371 Øx7.866	
SADDLE		D1092.004	D1092-004	D1092-004	
TOOL MOUNT	4	557A	557A	557A	
SPACER, BUSHING	2	N/A	883	883	
PIN TOOL DISASSEMBLY	2	906	910	910	
BUSHING TOOL	2	907	907	907	
	2	909	909	909	·
PIN INSERT Assembly	2	1181	880	1181	
BUSHING HOLDER ASSEMBLY	2	908	908	908	
SUSHING INSERT ASSEMBLY	2	879	882	882	
SPRING	4	56-0146	56-0146	56-0146	
GAUGE PLATE		N/A	35	924	
SET SCREW	4	36-0261	36-0261	36-0261	
JAM SCREW	·4*	36-0262	36-0262	36-0262	
DOC HD SCREW	4	36-0259	36-0259	36-0259	
SHIM (PIN)	5	A2904-003	A2904-003	A2904-003	
				بر چرب چرب	
	LINK ASSEMB PIN SIZE BUSHING SIZ DESCRIPTION SADDLE TOOL MOUNT SPACER, BUSHING PIN TOOL DISASSEMBLY BUSHING TOOL DISASSEMBLY PIN HOLDER ASSEMBLY PIN INSERT ASSEMBLY BUSHING HOLDER ASSEMBLY SUSHING INSERT ASSEMBLY SUSHING INSERT ASSEMBLY SUSHING INSERT ASSEMBLY SUSHING INSERT ASSEMBLY SUSHING INSERT	LINK ASSEMBLY PIN SIZE BUSHING SIZE DESCRIPTION QTV SADDLE 1 TOOL MOUNT 4 SPACER, BUSHING 2 PIN TOOL DISASSEMBLY 2 BUSHING TOOL 2 DISASSEMBLY 2 BUSHING TOOL 2 PIN HOLDER 2 ASSEMBLY 2 PIN INSERT 2 ASSEMBLY 2 SUSHING HOLDER 2 SUSHING INSERT 2 SPRING 4 GAUGE PLATE 1 SET SCREW 4 JAM SCREW 4	LINK ASSEMBLY PIN SIZE BUSHING SIZE BUSHING SIZE SADDLE TOOL MOUNT QTV SADDLE TOOL MOUNT 4 SF7A SPACER, BUSHING 2 N/A PIN TOOL DISASSEMBLY 2 PIN HOLDER ASSEMBLY 2 PIN HOLDER ASSEMBLY 2 PIN INSERT 2 ASSEMBLY 2 SPRING 4 SPRING 4 SET SCREW 4 36-0267 SOC HD SCREW 4 36-0259	LINK ASSEMBLY PIN SIZE BUSHING SIZE BUSHING SIZE DESCRIPTION QTV SADDLE 1 DI092.004 DI092.004 TOOL MOUNT 4 S57A 557A SPACER, BUSHING 2 N/A 883 PIN TOOL DISASSEMBLY 2 906 910 DUSHING TOOL 2 906 910 DUSHING TOOL 2 907 907 PIN HOLDER ASSEMBLY 2 909 909 PIN INSERT 2 1181 880 BUSHING HOLDER 2 908 908 SUSHING HOLDER 2 908 908 SUSHING INSERT 2 879 882 SPRING 4 56-0146 56-0146 GAUGE PLATE 1 N/A 35 SET SCREW 4 36-0267 36-0267 DATE SCREW 4 36-0267 36-0267 DISASCREW 4 36-0259 36-0259	LINK ASSEMBLY PIN SIZE BUSHING SIZE BUSHING SIZE SADDLE 1 DI092.004 DI090 DI092.004 DI092.004 DI092.004 DI092.004 DI092.0

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SHEET 1 OF 4

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B45 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

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A2738-000B

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MODEL LINK ASSEMBI PIN SIZE BUSHING SIZE	23) 34 1 ₁₂₁₆ 24	D9G,H S.A.L.T. 9W8320 2.253Øx12.25 3.371 /3.496Ø	85 1731 2.2539x12.25 3.371 9x8.856	245 EXC 997108 2.253øx11.259 3.371øx7.866	
DESCRIPTION	QTY	8.270	594 SEALED		
SADDLE	١	D1092.004	D1092-004	D1092-004	
TOOL MOUNT	4	557A	557A	557A	
SPACER, BUSHING	2	N/A	883	883	
PIN TOOL DISASSEMBLY	2	906	910	910	an an Araba An Araba An Araba an Araba
BUSHING TOOL DISASSEMBLY	2	907	907	907	
PIN HOLDER Assembly	2	909	909	909	
PIN INSERT Assembly	S	1181	880	1181	
BUSHING HOLDER ASSEMBLY	2	908	908	908	
BUSHING INSERT ASSEMBLY	2	879	882	882	
SPRING	4	56-0146	56-0146	56-0146	
GAUGE PLATE	ł	N/A	35	924	
SET SCREW	4	36-0261	36-0261	36-0261	
JAM SCREW	' 4‴	36-0262	36-0262	36-0262	
SOC HD SCREW	4	36-0259	36-0259	36-0259	
SHIM (PIN)	5	A2904-003	A2904-003	A 2904-003	

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SHEET 1 OF 4

CATERPILLAR 10.250 . PITCH (PPR) (NON PPR)										
MODEL LINK ASSEMB PIN SIZE BUSHING SIZE DESCRIPTION		2.253 ØX 12.25 3.809 ØX8.270	DIO PPR 9W6086 2.253°ØX11974 3.809°ØX 8.27°	GY2059 2.253¢x11.974	5 64 / 19 1					
SADDLE	١	D1092-003	D1092-003	01092-003	D1092-003					
TOOL MOUNT R.H.	l	c1000-002	200-0001	C1000-002	C1000-002					
TOOL MOUNT L.H.		200-10012	C1001-00Z	C1001-002	C1001-002					
PIN. TOOL DISASSEMBLY	2	858	864	864	858					
BUSHING TOOL DISABSEMBLY	2	859	859	1061	1061					
PIN HOLDER ASSEMBLY	2	1174A	866A	866A	1155					
PIN INSERT NOMINAL		N/A	869	869	N/A					
PIN INSERT OTHER SIDE	1	N/A	868	808	N/A					
BUSHING HOLDER ASSEMBLY	2	865A	865A	1154	1154					
BUSHING INSERT ASSEMBLY	2	કંગ	867	1064	1064					
SPRING	4	56-0150	56,0150	56-0150	56-0150					
SET SCREW	4	36-0261	36-0261	36-0261	36-0261					
JAM NUT	4	36-0262	36-0262	36-0262	36-0262					
MASTER PIN . SPACER ASSY	2	1158	N/A ·	N/A	1157					
PIN INSERT ASSEMBLY	2	1114	N/A	N /A.∙	\\\4					
SHIM (PIN)	5	A2904-003	N/A	N/A	A2904-003					
106028		SHEET	2 OF 4	A2	-738-000					

CLINTURION INDUSTRIES INC. 845 HICKORY STREET

PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150

		REO	UIRED	,		RIEM	UIRED	
DESCRIPTION		I.D.	PART		γTQ	1.0.	PARTI	
SADDLE	VT.P	N/A	D1092-0		Ì	N/A	D1092-00	
TOOL MOUNT.	4	557A		·····				
TOOL MOUNT	<u> </u>	N/A	C1000-0		1	N/A	C1001-00	
SPACER, BUSHING	2	883			- -			
PIN, DISASS'Y	2	858	B2054-		S	864	B2054-0	
PIN, "	2	906	B1902 - C	543		910	B1902-04	
BUSHING "	2	859	g Dentrol dentrol dentrol and dentrol dentrol dentrol de la company de la company de la company de la company de	a	2	907	B1901-04	
BUSHING "	2	1061	B2055-	007	1.8736 - 189 - 199 - 1	4 · · · · · · · · · · · · · · · · · · ·		
PIN HOLDER, ASSY	2	909	B1904-0	597	2	866A	B2057-00	
PIN INSERT "	2	880	B2056	.009	2	1114	C1166-0	
PIN'INSERT "	١	868	C1166-0	200	<u> </u>	869	C1166-00	
BUSH HOLDER "	2	908	B1904-0	296	2	865A	82057-0	
BUSH HOLDER "	2	1154	C1165-0	60	2	1174A	B2057-0	
BUSH INSERT "	2	1879	B2056-	008	2	588	B2056-0	
BUSH INSERT "	2	1064	C1166-	010	9.545		annan nagrua foi dhin Lipennan nagar ingen a bartaga na si an su an s	
BUSH INSERT "	2	867	C1166-0	001				
PIN HOLDER "	2	1155	C1165-0	04		an mil the second s	anning and an anning and a	
GAGE PLATE	1.	35	C0439-0	>12	1	924	C0439-05	
Spring	12	4719-1-1070-5-0407-7-10	56-014	46	16	**************************************	56-015	
SET SCREW .	12		36-02	61	frilfting for sing same specific head		/gen/life()	
JAM NUT	12		36-020	62				
SOC HD SCREW	8		36.02	59				
TEM QU	ANT.	DERCRIPTI	ON					
C.	R N T	P.II R I	ONIN	T D TI	g m	RIES	BINC.	
	CENTURION INDUSTRIES							
	PEWAURER. WISCONSIL 59072							
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JAM NUT	W :			36-026					
SPRING			••••••••••••••••••••••••••••••••••••••	56-0140				F	
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SHIM (PIN	7)	10		A2904-00	03				
PIN INSERT		2	1181	B1903-15					
SPACER-SPL	· · · · · · · · · · · · · · · · · · ·	2	1157			2	1158	A2783	-002
an a	-	QTY	I.D.	PART N	<u>°</u>	QTY	1.D.	PAR	T Nº
DESCRIP	TION	·····	135-4	PUIRED		· · · · ·	KEPI	JIREI	\supset

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DIIN PPR MODEL LINK ASSEMBLY GY1128 2.626\$ × 13.812 PIN SIZE 4.195/4.3300 BUSHING SIZE DESCRIPTION QTV × 9,343 D1092-005 SADDLE ١ TOOL MOUNT C1000-005 1 R.H. TOOL MOUNT C1001-005 1 L.H. PIN TOOL B2057-005 2 DISASSEMBLY BUSHING TOOL 926 2 DISASSEMIBLY PIN HOLDER 928 2 ASSEMBLY PIN INSERT 930 \ NOMINAL PIN INSERT 931 1 OTHER SIDE BUSHING HOLDER 2 1152 ASSEMBLY BUSHING INSERT 1150 2 ASSEMBLY 56-0150 Д. SPRING SET SCREW 36-0261 Ą 36-0262 JAM NUT Д 7 A2871 SPACER, ANVIL A2739 -000 SHEET 1 OF 2

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845 HICKORY STREET PEWAUKEE, WISCONSIN 53072 USA (414) 691-4150 CATERPILLAR 12.500 PITCH (PPR)

CLINTURION INDUSTRIES INC.

DESCRIPTION		REG	UIRED	REQUIRED						
	QTY	1.D.	PART Nº	VTP	1.0.	PART	No			
SADDLE		N/A	D1092-005							
TOOL MOUNT		N/A	C1000-005	1	N/A	C1001-00	5			
PIN, DISASSY	2	925	B2054-005							
BUSHING, "	2	926	82055-004							
PIN HOLDER, ASS	Y 2	928	B2061-003							
PIN INSERT "	ļ	930	CI166-005	1	931	C1166-0	006			
BUSH HOLDER "	S	1152	C1165-001				******			
BUSH INSERT "	2	1150	C1166-004	•						
ANVIL SPACER	2	N/A	A2871		a (hang) kan mangan saka da da panan digi ka (ng na pangan saka)	1				
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SPRING	N/A		56-0146	4	aguaites	56-015	0			
SET SCREW .	4-		36-0261							
JAM NUT	4		36-0262	The Database of Light Clark						
SOC HD SCREW	A/N		36-0259							
. Item (G	WANT.	XBCRPTI	011							
	CENTURION INDUSTRIES INC.									
	e uniter (* 1 (2	MICKORY BIRET								
	PEWAUKER. WISCONSIN 69071									
TITLE	TITLE 12.500 PITCH									
	TOOL SET									
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DRAW	M	Data	BCALS A	PROVE	4	A WING NUM	1			
SHEET Z OF Z										

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