

Document Title: Track gearbox, description	Function Group:	Information Type: Service Information	Date: 2015/9/28
Profile: EXC, EC700B HR [GB]			

Track gearbox, description

The gearboxes of the series described in this manual are designed and built for application as track drive for crawler machines equipped with open loop hydraulic circuit.

The unit includes planetary gearbox, 3 stages, and rotating housing type.

The illustrations show the main functions and the parts of the gearbox.

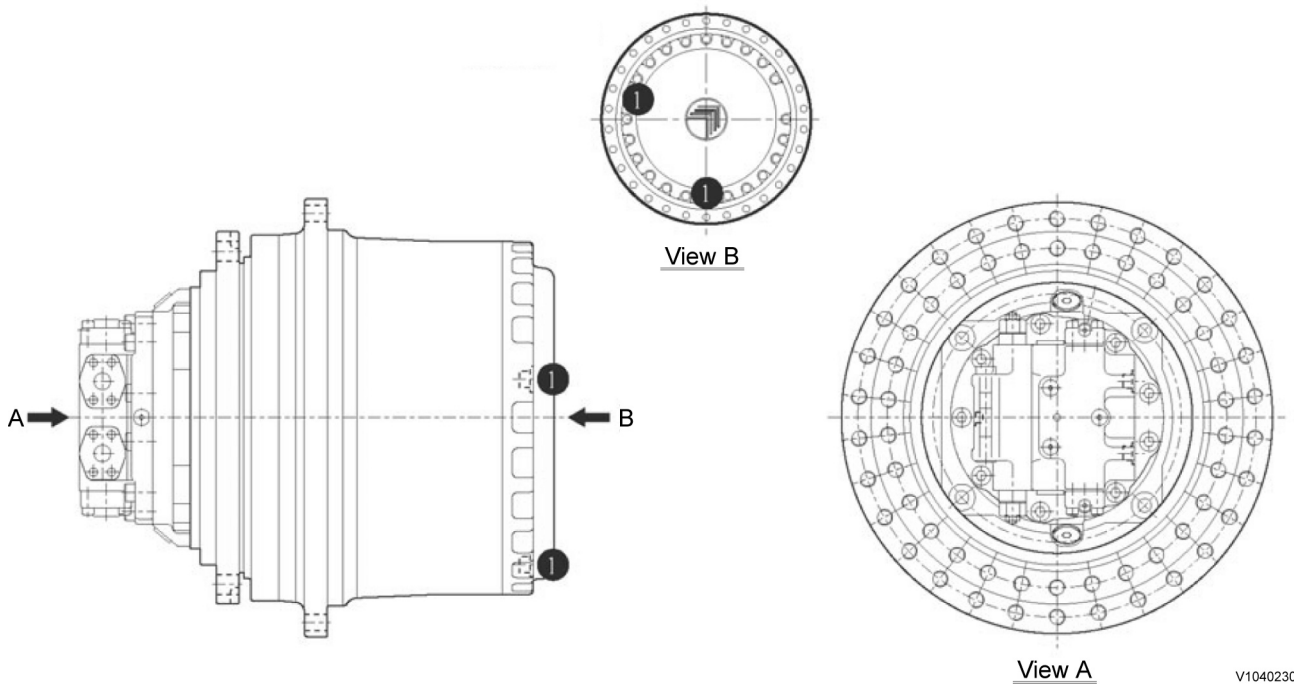
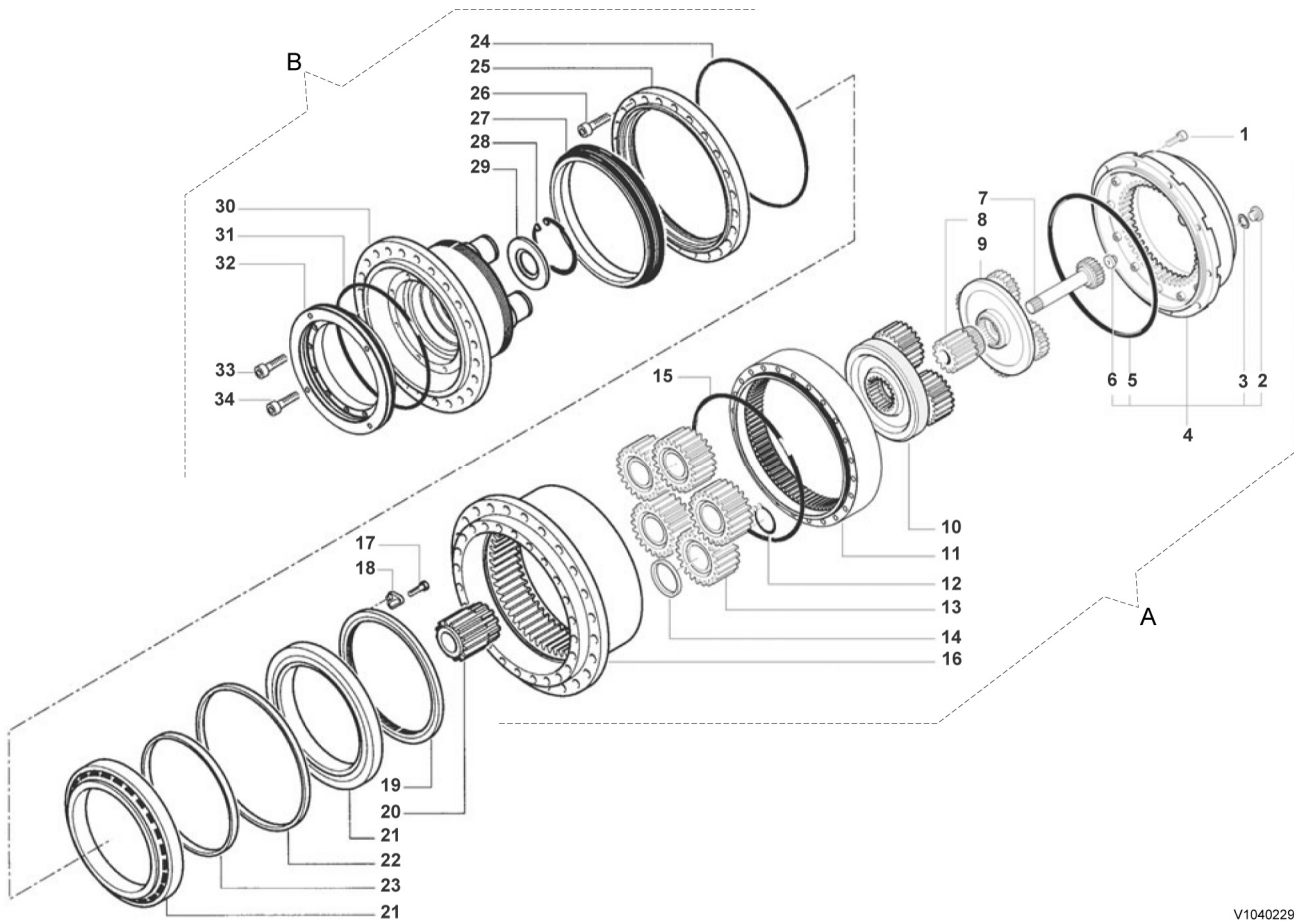


Figure 1
Track gearbox, structure

1. Filling, draining and level oil plugs



V1040229

Figure 2
Track gearbox, exploded view

1	Screw	10	2nd reduction assembly	19	Ring nut	28	Retaining ring
2	Oil breather plug	11	Ring gear	20	Sun gear	29	Discs retainer
3	O-ring	12	Retaining ring	21	Bearing	30	Hub
4	Cover assembly	13	Planetary assembly	22	Spacer	31	O-ring
5	O-ring	14	Spacer	23	Spacer	32	Motor adaptor
6	Pad	15	O-ring	24	O-ring	33	Screw
7	Sun gear	16	Gearbox housing	25	Cover	34	Screw
8	Sun gear	17	Screw	26	Screw	A	Reduction unit
9	1st reduction assembly	18	Back stop	27	Seal	B	Rotating housing

Document Title: Track gearbox, troubleshooting	Function Group:	Information Type: Service Information	Date: 2015/9/28
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Track gearbox, troubleshooting

Troubleshooting

Trouble	Cause	Remedy
External oil leakage from the lifetime seal	<ul style="list-style-type: none"> Lifetime damaged 	<ul style="list-style-type: none"> Replace lifetime seal
External oil leakage from the end cover	<ul style="list-style-type: none"> O-ring seal damaged 	<ul style="list-style-type: none"> Replace O-ring seals
External oil leakage from the plugs of the cover	<ul style="list-style-type: none"> Plug seal damaged Plugs or screws loose 	<ul style="list-style-type: none"> Replace plug seal Tighten the plugs/screws
Too much hydraulic noise (during the slowing down of the motor speed)	<ul style="list-style-type: none"> Hydraulic circuit malfunctioning 	<ul style="list-style-type: none"> Check the pressure to the motor ports is ≥ 0.3 MPa (3.1 kgf/cm²) (43.5 psi) (3.0 bar) Verify hydraulic circuit
Too much noise inside the track gearbox (motor)	<ul style="list-style-type: none"> Internal damage 	<ul style="list-style-type: none"> Check the gearbox
Overheating	<ul style="list-style-type: none"> Insufficient oil level Hydraulic oil too warm 	<ul style="list-style-type: none"> Check the oil level and refill if necessary Check the hydraulic circuit
Sprocket locked	<ul style="list-style-type: none"> Mechanical components damaged 	<ul style="list-style-type: none"> Replace damaged parts

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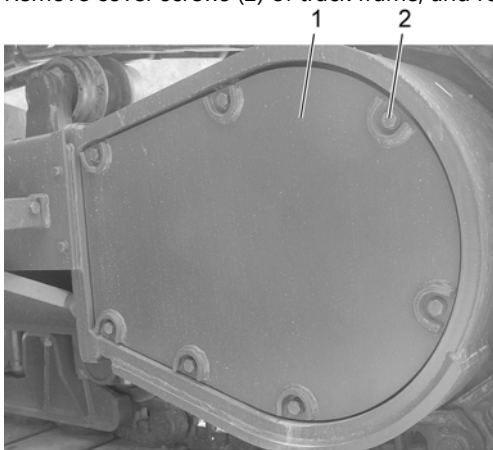
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Document Title: Track gearbox, removing	Function Group:	Information Type: Service Information	Date: 2015/9/28
Profile: EXC, EC700B HR [GB]			

Track gearbox, removing

Op nbr 431-113

1. Park the machine in the service position A. See [091 Service positions](#).
2. Remove the track chain. See [7753 Track chain assembly, removing](#).
3. Remove cover screws (2) of track frame, and remove cover (1).



V1074004

Figure 1
Removal, cover

4. Disconnect hydraulic hoses and pipe (D) at track motor (A).

NOTE!

When the engine is running, the hydraulic line is under high pressure.

Stop the engine, and remove the residual pressure inside the hydraulic line by operating the control lever smoothly for 3~4 times with the ignition switch at "ON" position. Turn the ignition key to "OFF" position.

Prepare container for collecting hydraulic oil.

NOTICE

Plug all pipes, hoses and connections when removing.

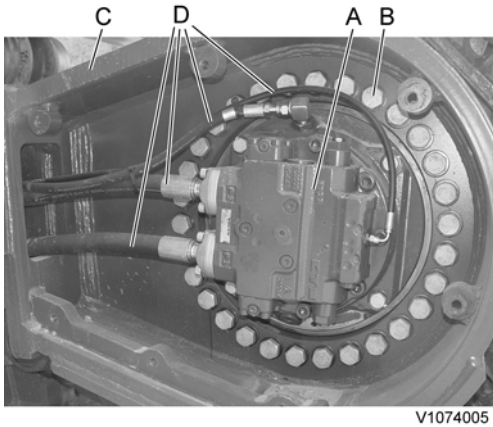


Figure 2
Removal, hydraulic hoses and screws

- Remove track gearbox mounting screws (B) from undercarriage frame (C).



When the last bolt has been removed, the cover plate falls down.

- Pass a wire rope around the gearbox, and lift it. Remove the track motor as an assembly. Then, using screws in the threaded holes of the undercarriage, force out the gearbox.



The parts are heavy. Take appropriate safety cautions when handling them.

NOTE!

Lift the gearbox as close to the sprocket as possible to maintain balance.

NOTE!

The gearbox mounting screws may be used in the threaded frame holes.

NOTE!

Putting match-marks on the track frame and track gearbox will facilitate reassembly.

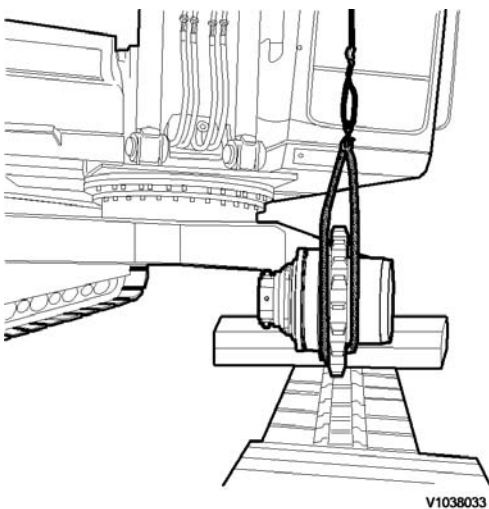


Figure 3
Removal, track gearbox

- Remove the sprocket. See Sprocket, removal.



The parts are heavy. Take appropriate safety cautions when handling them.

Document Title: Track gearbox, installing	Function Group:	Information Type: Service Information	Date: 2015/9/28
Profile: EXC, EC700B HR [GB]			

Track gearbox, installing

Op nbr 431-114

1. Install the sprocket. See Sprocket, installation.



WARNING

The parts are heavy. Take appropriate safety cautions when handling them.

2. Pass a wire rope around the track gearbox, lift and install the track gearbox to the undercarriage frame.



WARNING

The parts are heavy. Take appropriate safety cautions when handling them.

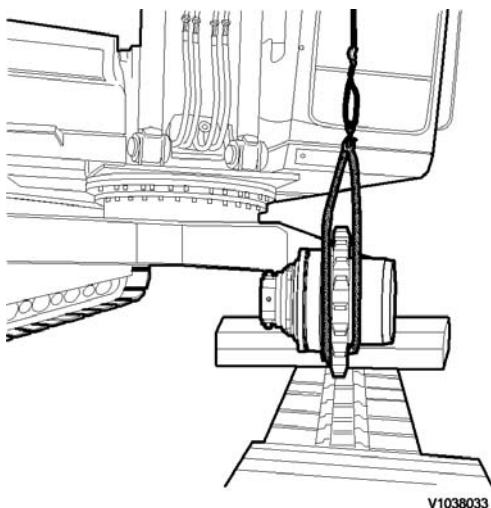
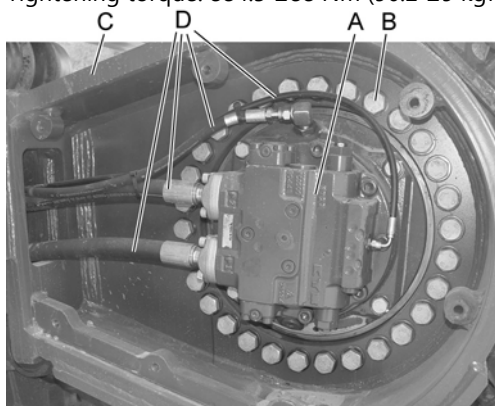


Figure 1
Installation, track gearbox

3. Apply loctite #277 to track gearbox mounting screws (B). Install track gearbox mounting screws (B) to undercarriage frame (C) and tighten them to the specified torque.
Tightening torque: 884.5 ±88 Nm (90.2 ±9 kgfm) (651 ±64 lbf ft)



V1074005

Figure 2
Tightening, screws

4. Install hydraulic hoses and pipe (D) at track motor (A).
5. Install track gearbox cover (1) and tighten cover screws (2) to the specified torque.

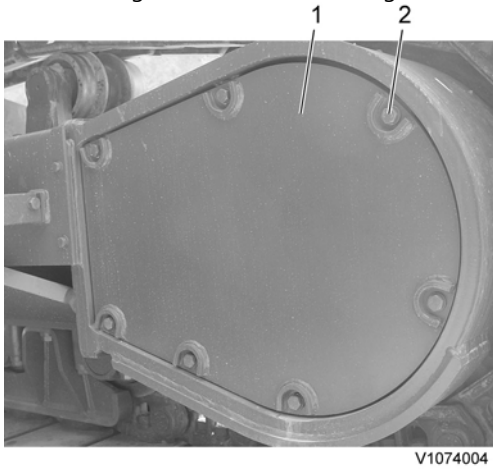


Figure 3
Installation, track gearbox cover

6. Check the gear oil level of gearbox. If necessary, replace or refill the oil.

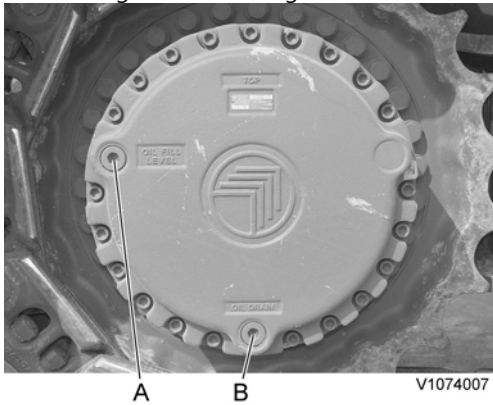


Figure 4
Checking, gearbox oil level

- A. Fill and level port (plug)
- B. Drain port (plug)

Document Title: Track gearbox, maintenance standard	Function Group:	Information Type: Service Information	Date: 2015/9/28
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Track gearbox, maintenance standard

The parts are precision finished and must be handled carefully.

Keep the parts of the planetary carrier (s) together, do not mix the bearings, gears, pins and thrust washers.

Seals

Replace the seals and O-ring, although they appear not damaged.

Part replacement criteria

1. Replace all parts that appear damaged or are not within the allowable value.
2. Replace some parts in sets, i.e. gears, bearings, pins and thrust washers.

Inspection, tightening screw

Inspection	Frequency	Action
Tightening screws	After the first 50 operating hours	Screws tightening torque check

Remove air in the track motor before operating.

1. Check that the gearbox axis is horizontal. Rotate the gearbox housing until the drain plug is on the bottom of the vertical axis of the end cover.
The gearbox is supplied with oil plugs (draining, filling and level) equipped with an hole that allows the air to bleed.
NOTE!
Remove the oil plugs with care. When the gearbox is warm, the air inside can be pressurized and this can cause their strongly expulsion towards the worker.
2. Loose with caution the plugs (2~3 rounds) counterclockwise.
3. Clean the plug to be sure that the air bleed hole is not obstructed.
4. Wait a few seconds to allow the pressurized air to bleed from the gearbox.
5. Remove the plugs and let the oil flow in a large enough container; in order to facilitate the draining must be oil still warm.
6. Wait a few minutes until all the oil is drained and then proceed to screw on the plugs.
7. Proceed with the oil fill-up following the procedures given.

NOTE!

Never mix mineral oils with synthetic oils and vice versa.

Do not dispose of the oil in the natural environment but be careful to eliminate it in compliance with the relative rules and regulations that govern locally.

Tightening torque plug. See track gearbox, description.

Document Title: Track gearbox, precautions for operation	Function Group:	Information Type: Service Information	Date: 2015/9/28
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Track gearbox, precautions for operation

Installation

Op nbr 00000

1. Check that the mating mount surfaces are clean.

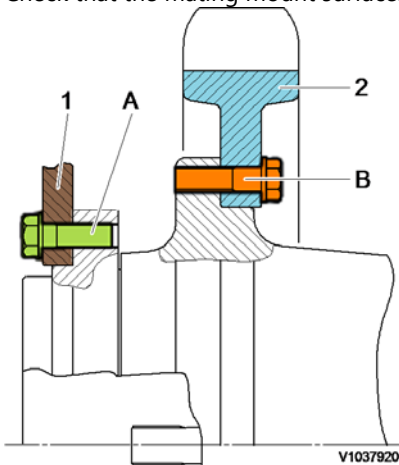


Figure 1
Installation, track gearbox

- A. Track frame mounted screw
 - B. Sprocket mounted screw
1. Track frame
 2. Sprocket

2. Check that the motor is positioned correctly in the frame.
3. If the gearbox to frame fit is tight, draw the assembly into the frame evenly with the mounting screws.
4. Tighten the screws in a crisscross pattern in several stages to the specified torque.
5. Apply these same precautions when mounting the sprocket.

Tightening torque, unit: N m (kgf m) (lbf ft)

	Quantity	Thread size	Tightening torque
Reduction screw (A)	30	M24	990 (101) (733)
Sprocket screw (B)	30	M24	720 (533) (73.4)

NOTE!

The screws must be 10.9 strength classification or above.

Lubrication oil

The gearbox is lubricated by oil splash in oil bath, the suggested oil type is SAE 80W/90 or SAE 85W/140 corresponding to: MIL-L-2105C API GL5

During the running the oil must not always exceed the temperature of 85 ~ 90 °C (185 ~ 194 °F) (intermittent)

Oil filling

NOTE!

The gearbox is supplied without oil. It has filling, draining and oil level plugs.

Before putting the gearbox into operation, it is necessary to fill it with oil.

- Check that the gearbox axis is horizontal. Rotate the gearbox housing until the drain plug (B) is on the bottom on the vertical axis of the end cover.

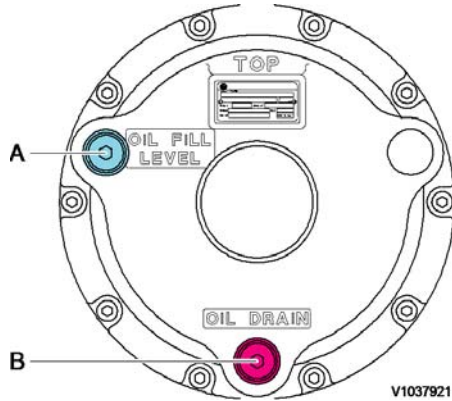


Figure 2
Position, oil fill and drain port

- A. Fill and level port (plug)
- B. Drain port (plug)

- Unscrew the fill and level oil plug (A).
- Fill from the hole until the lubricant oil flows out.
- Start the track drive after having filled the housing of the motor with hydraulic oil up to drain hole.
- Bleed air from every part of the hydraulic and add oil in the tank if necessary.
- Tighten the fill and level oil plug (A) and then run the gearbox. After a few minutes, stop and check the oil level.
- If necessary, refill with lubricant oil.

Approximate oil capacity: 20 liters ± 10% (5.3 US gal ± 10%)

Gear oil check

- Oil level check: every 250 operating hours

Gear oil replacement

- First (initial) oil replacement: at 500 operating hours
- Subsequent oil replacement: every 2000 operating hours

NOTE!

Regardless of the operating hours the gear oil must be replaced at least once a year.

NOTE!

Do not mix different types, classifications or brands of oil!

NOTE!

Drain the gear oil while it is still warm to flush out any contaminants.

Gear oil replacement procedure

- Rotate the gearbox until the drain plug and the fill plug are on the vertical axis.

- Remove the 2 plugs in the end cover and drain the oil into a suitable container.
- Ensure that the O-ring on each plug is not damaged, then install the plugs and torque to specification.
- Refill the gearbox through the fill port until oil exits from the level check port.

Operating checks

- Check the oil level prior to operating the track function.
- Check for oil leakage on the gearbox assembly.
- Check for loose mounting screws.
- Check for abnormal sound or vibration while rotating.
- Check for any abnormal temperature increase after operating for a short time.

WARNING

The temperature of the case is high just after running. Use a thermometer to measure. Do not touch directly by hand to prevent a burn injury.

NOTE!

The temperature of the case must be lower than 90 °C (194 °F), during continuous operation.

Document Title: Track gearbox, replacing cover	Function Group:	Information Type: Service Information	Date: 2015/9/28
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Track gearbox, replacing cover

Op nbr 431-117

1. Park the machine in the service position.
Rotate the track gearbox until the drain plug (B) and level plug (A) are on the vertical axis.

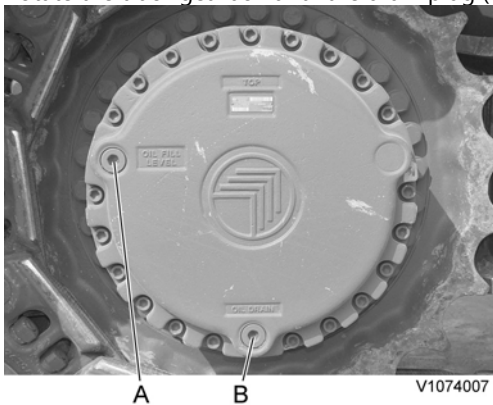


Figure 1
Service position

2. Remove the 2 plugs the cover and drain the oil into a suitable container.

NOTE!

Prepare container for collecting track gearbox oil: 13 litres (3.44 US gal), see Operator's manual.

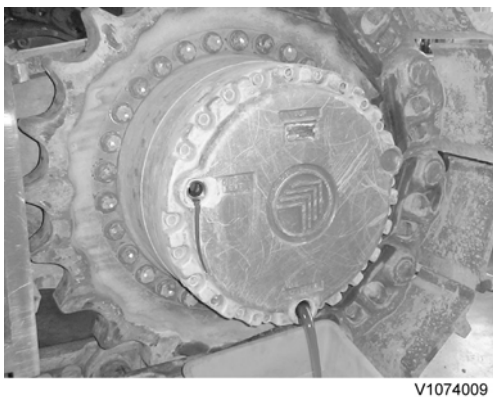


Figure 2
Drain, track gearbox oil

3. Remove track gearbox cover mounting screws (C).

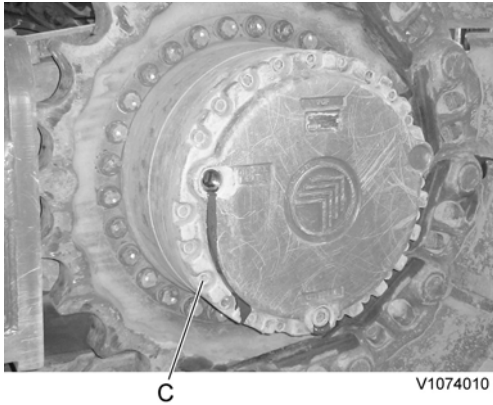


Figure 3
Removal, track gearbox mounting screws

4. Hold the track gearbox cover (D) with hoist (E).
Remove track gearbox cover (D) from track gearbox.



The parts are heavy. Take appropriate safety cautions when handling them.

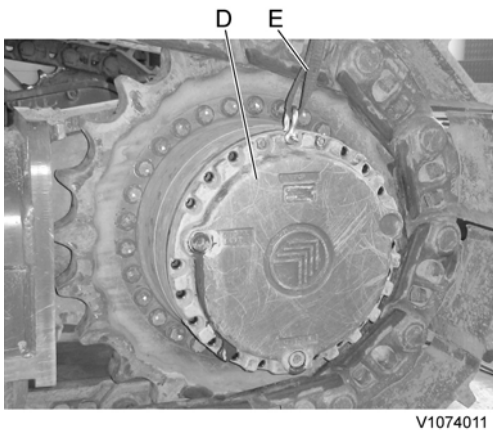


Figure 4
Removal, track gearbox cover

5. Install the new track gearbox cover to the track gearbox.
NOTE!
Do not reuse removed O-ring (F).

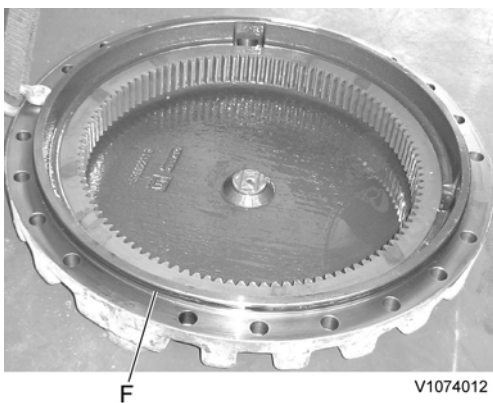


Figure 5
Exchange, O-ring

6. Install drain plug (B) and tighten it to the specified torque.

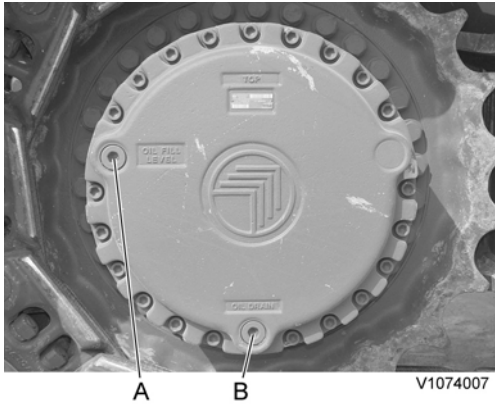


Figure 6
Installation, drain plug

7. Fill the oil through the level port until oil exits from the level check port.
8. Install the level check plug and tighten it to the specified torque.



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Track gearbox, disassembly

Precautions

- Thoroughly clean the gearbox assembly prior to disassembly.
- Select a clean work area.
- Match mark attached components to indicate proper positioning during reassembly.
- Take care not to mix parts of sub assemblies i.e. planetary bearings, gears and thrust washers.
- Thoroughly clean all parts and the inside of the casings.
- Inspect and analyze all failures.
- Determine the root cause!

See [4311 Track gearbox, description](#).

Disassembly

1. Turn the gearbox upside down, unscrew and remove the 2 plugs (2) from the end cover (4).



V1040310

Figure 1
Removal, plug

2. Unscrew and remove the 21 screws (1) from the cover (4).



V1040311

Figure 2
Removal, screw

3. By using a tackle remove the end cover (4).



V1040312

Figure 3
Removal, cover

4. Remove the O-ring (5) from the end cover (4).



V1040313

Figure 4
Removal, O-ring

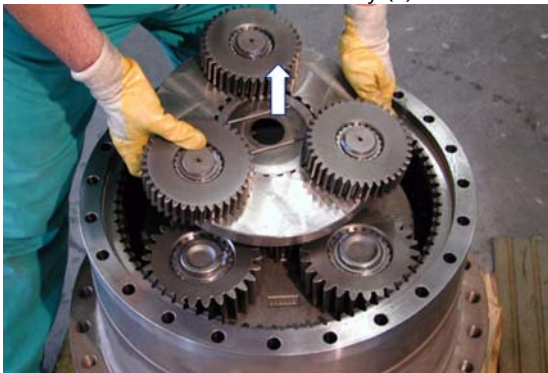
5. Remove the 1st stage sun gear (7).



V1040314

Figure 5
Removal, 1st stage sun gear

6. Remove the 1st reduction assembly (9).



V1040315

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