

To assemble repaired section into track chain, remove ram end assembly adapter plate (7, Fig. 18), master bushing spacer (9), and saddle bushing spacer (5).

Secure pin side plunger (22764) to disassembly adapter plate (32621). Attach pin plunger and plate assembly to press ram.

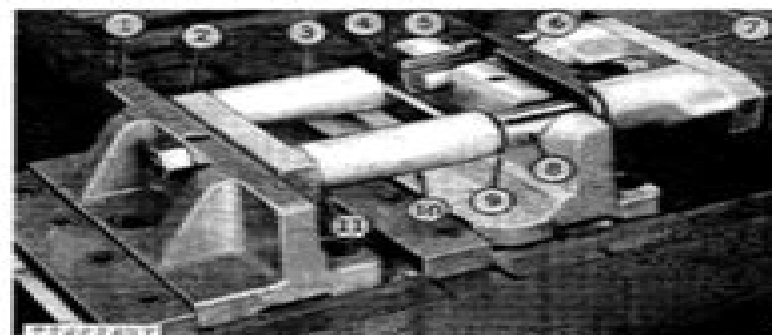
Place track chain in saddle in final assembly position. Raise link high enough to position seals and master bushing spacers into link counterbores. Lower link into alignment with master bushing and press in pin.

NOTE: Install seals with dished side opposite or outward. Install spacers with tapered side toward bushing and flat side toward washers (Fig. 19).

Continue this operation until track is assembled.

Lubricate track shoe cap screws and nuts and tighten to 120 lb-ft (163 Nm).

Lubricate rubber track shoe studs and nuts and tighten to 89 lb-ft (121 Nm).



- | | |
|--|--|
| 1—40706 Abutment | 7—35584 Ram End Assembly Adapter Plate |
| 2—24282 Rear Abutment Assembly Adapter Plate | 8—Master Bushing |
| 3—30184 Pin Side Spacing Post | 9—35529 Master Bushing Spacer |
| 4—41555 Saddle | 10—30193 Bushing Side Spacing Post |
| 5—35586 Saddle Bushing Spacer | 11—24030 Bushing Side Spacer |
| 6—Left-Hand Link | |

Fig. 18-Master Bushing Installation

INSTALLATION (Headless Master Track Pin)

Position track assembly on the crawler.

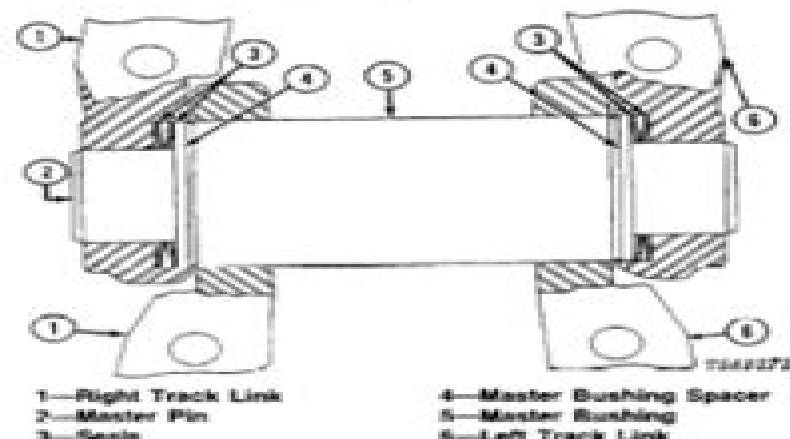


Fig. 19-Master Pin Connection Seal Placement

Refer to Fig. 19 for correct positioning of parts.

NOTE: Place the track spacers (6, Fig. 19) in the counterbores with the flat side against the seal.

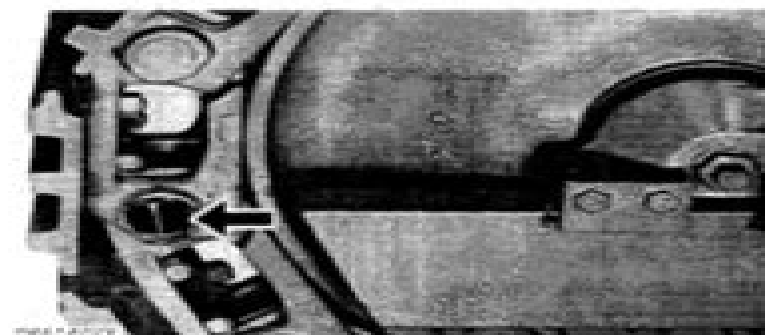


Fig. 20-Track in Alignment

Align links with track bushings (Fig. 20).

John Deere 555 Repair Manual

David Baud



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