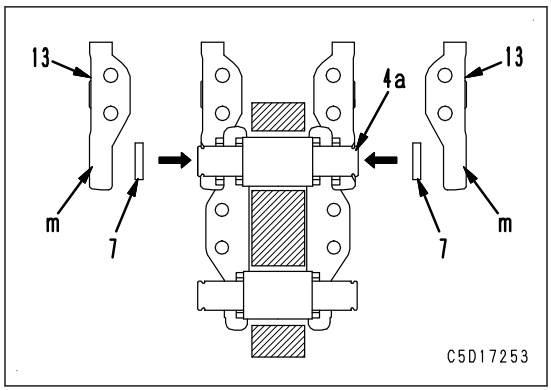
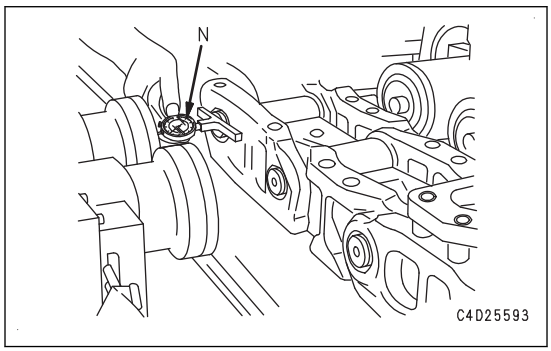
36. Set the spacers (7) on the R.H. and L.H. of the pin sub assembly (4a) at the front.
37. Direct the master link meshing surface (m) upward, and set the master links (13) on roller tread side to which the seals have already been installed to the positions indicated in the drawing below.
38. Press fit the master link (13) on the roller tread side to the pin sub assembly (4a) at the front.

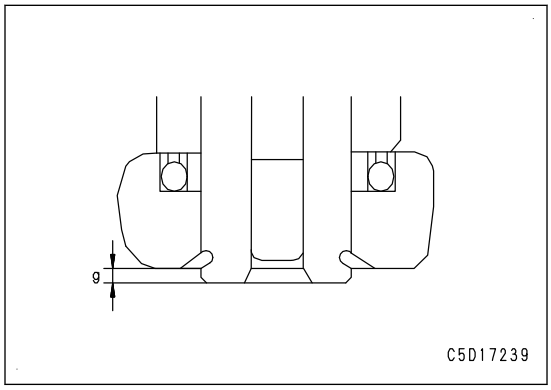
    REMARK

    - Perform centering of link pin hole and pin before press fitting.
    - Install the assemblies so that the R.H. and L.H. seals do not fall off and the seal and spacer (7) are not caught.
    - Press-fit the R.H. and L.H. pin sub assemblies (4a) simultaneously.
    - Check that the R.H. and L.H. master links are press fitted in parallel.
    - Take care that the press-fitting force of pin sub assemblies does not exceed the following value.
      Press-fitting force (D37-24): 196 kN {20 t}

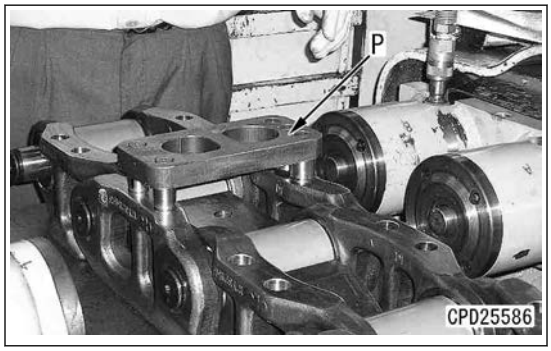
      Press-fitting force (D39-24): 235 kN {24 t}
    - Measure the pin protrusion dimension (g) by using the depth gauge (N), adjust the pin according to the following dimension, and then press fit the pin.
      Protrusion dimension (g): 4.8±0.2 mm

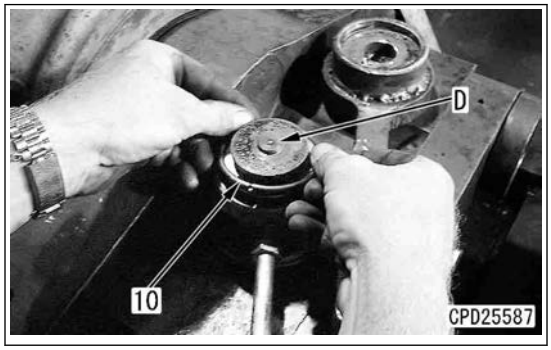




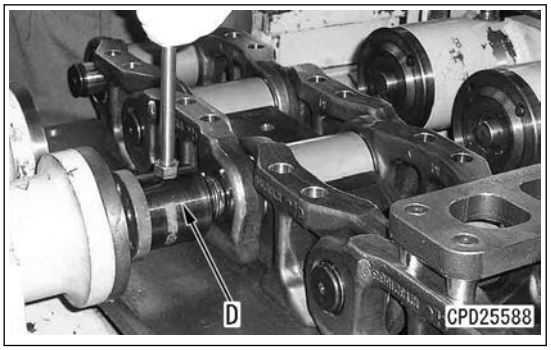


39. Check that the distance between the shoe bolt holes is within the standard value range by using the shoe bolt hole pitch gauge (P).
    - When the distance exceeds the specified value:
      Disassemble the assembly, check for any abnormality, and then assemble them again.
    - When the distance is within the specified value range:
      Wear of the spacer or bushing end surface may exceed the allowable limit. Disassemble the assembly and replace the parts with new ones.
40. Set the wedge ring (10) to the push tool assembly (D).





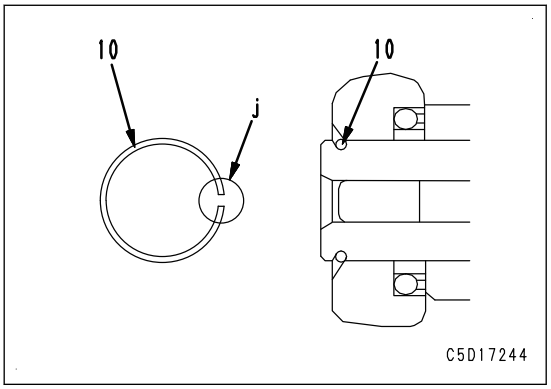
41. Perform positioning of the push tool assembly (D) (smaller plug) and pin, and push in the wedge ring (10) until it fits in the pin groove.



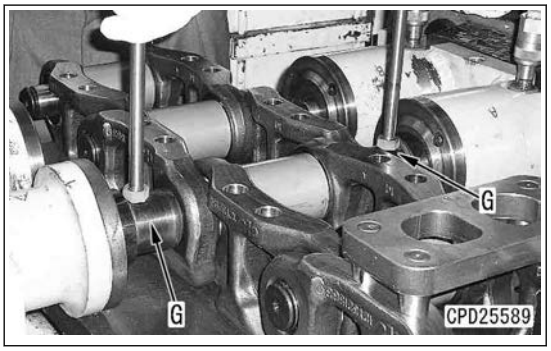
REMARK

- Install the wedge ring (10) with opening (j) facing shoe mounting side of the link.
- When the wedge ring (10) fits in the pin groove, you can hear the sound.

42. By using the push tool assembly (E) (larger plug side), install the wedge ring on the opposite side according to the same procedure. (See “SPECIAL TOOLS LIST”.)



43. Press fit the R.H. and L.H. wedge rings simultaneously by using the push tool assemblies (D) and (E).

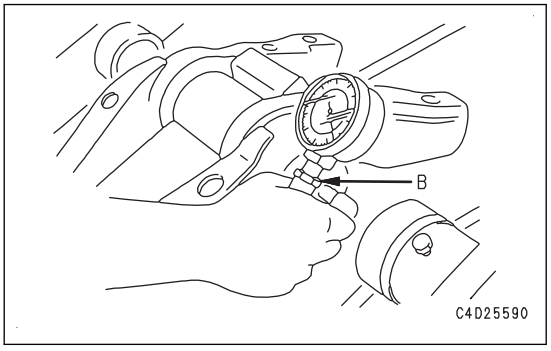


REMARK

Take care that the press-fitting force of the wedge ring does not exceed the following value.
Press-fitting force (D37-24): 85 to 117 kN {8.7 to 12 t}

Press-fitting force (D39-24): 96 to 174 kN {9.8 to 17.8 t}

44. Remove the air from inside of the pin for each link assembly by using the checker (B), and check the sealing performance.



REMARK

- Hold the space inside the pin at 91 to 95 kPa {680 to 710 mmHg} of vacuum for 5 seconds, and check that the pressure does not change.
- If the pressure is changed, disassemble the link to check the seal. If no failure is found, reassemble it.