

**Service Manual**

**SM17-001-055.00**

**Torque of Adjusting Bolts and Lockwashers**  
Using the torque wrench 10-100 Nm, tighten the bolts and lockwashers.

**Loosening of Joint Components** (as outlined in Operator's Manual)

**To Install The Tie Section Into The Outer Mid Section**

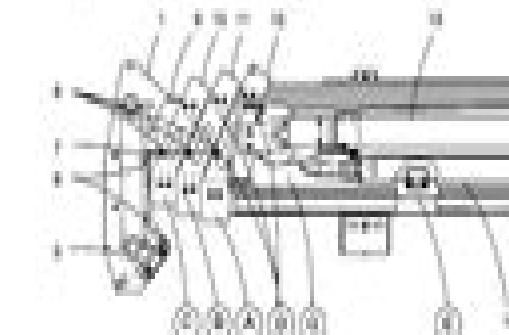
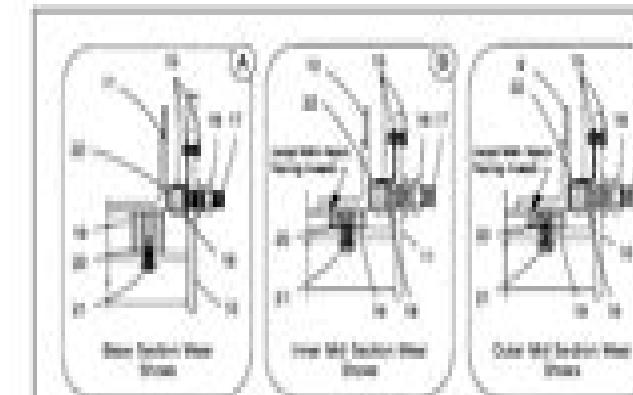
**Note:** Refer to Figure 1 for the approximate torque and weight of the Tie section.

**Refer to Figure 1.**

- Using an auxiliary lifting device, lay down the tie section on a flat surface along the longitudinal axis of the tie section (horizontal) and not perpendicular.
- If required, clean the tie section (1000 g of water, 0.1% using ammonium phosphate) and then allow to dry before fitting.
- Fit required seal over sleeve (1000 g of water, 0.1% using ammonium phosphate) and then allow to dry before fitting.
- Push outer bearing (2) into the tie section (3). Press outer bearing (2) into the tie section (3) until the edge of the tie section (3).
- Slide the tie section (3) into the outer mid section (1) so that the bearing (2) is seated.
- At the bottom (4) slightly counterbore the base of the outer mid section (1).
- Apply a torque of 100 Nm (10.0 kgf-m) per specification in Figure 1. **Figure 1** **Diagram**
- After torque has been applied, wash bearing (2) with water.
- Insert sleeve (5), wear sleeve (6), and spacers (7) and lockwashers (8) into the outer mid section (1). Tighten counterbore (4) to 10.0 Nm per specification.
- Change bearing (2) into a sleeve using the heat shrinking (9). Insert tie section (3) at the top and then slide the outer mid section (1).
- Apply a torque of 100 Nm (10.0 kgf-m) per specification in Figure 1. **Figure 1** **Diagram**
- Through the access hole in the outer mid section (1), install the outer sleeve (10) with shoulder facing towards the heat shrinking (9) and heat gun.
- Heat sleeve (10) and spacers (7) with heat gun.
- Insert sleeve (5), wear sleeve (6), and lockwashers (8).
- Note:** The thickness of sleeve, spacers, sleeves and lockwashers, shoulder, and outer sleeve (10) should be 1.00 to 1.05 mm.
- Refer to Figure 1. **Figure 1** **Diagram**

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1	Outer Mid Section	2	Outer Mid Section	3	Tie Section	4	Outer Mid Section	5	Outer Mid Section
6	Outer Mid Section	7	Outer Mid Section	8	Outer Mid Section	9	Outer Mid Section	10	Outer Mid Section

# Link Belt Service Manual

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