

**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), lockwashers (7), and lockwashers (8) into the outer mid section (1). Tighten counterbore (4) to 10.0 Nm.
- Change bearing (2) into a sleeve using the heat shrinking (9). Insert bearing (2) into the tie section (3) until 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 pin (11). Tighten sleeve (10) and lockwashers (8) to 10.0 Nm.
- Outer sleeve (10) and lockwashers (8) to 10.0 Nm.

**10. Outer sleeve (10), wear sleeve (6), lockwashers (8), and lockwashers (7), and heat pin (11) assembly**  
Note: The torque of sleeve (10), wear sleeve (6), lockwashers (8), and lockwashers (7), and heat pin (11) assembly is 10.0 Nm (10.0 kgf-m).

**11. Outer sleeve (10) and lockwashers (8)**  
Note: Apply a light coat of Lubriplex® 2000 to sleeve (10) and lockwashers (8) before the assembly.

**12. Adjuster Knob (12) and sleeve (13)**  
Note: Adjust sleeve (13) to increase (10.0 Nm, 1.0 kgf-m) to increase (10.0 Nm, 1.0 kgf-m) to obtain clearance in Figure 1. Lock pin (14) (10.0 Nm) for adjusting adjustment clearance.

**To Install The Tie Cylinder Assembly Into The Tie And Outer Mid Sections**

- Unscrew sleeve (15) from sleeve assembly and take apart assembly.
- Push sleeve (15) out and unsnap cylinder (16).

**Note:** Insert cylinder sleeve (15) as illustrated in Figure 2.

- If required, clean sleeve (15) with water, 0.1% using ammonium phosphate, and then allow to dry.
- Push sleeve (15) into the tie cylinder assembly (16) so that the cylinder sleeve (15) is seated.
- Push cylinder (16) into the tie section (3) until the cylinder sleeve (15) is seated.
- Push sleeve (15) so that cylinder (16) and sleeve (15) are seated.
- If required, use a screwdriver and carefully drive the tie cylinder into the tie section (3).

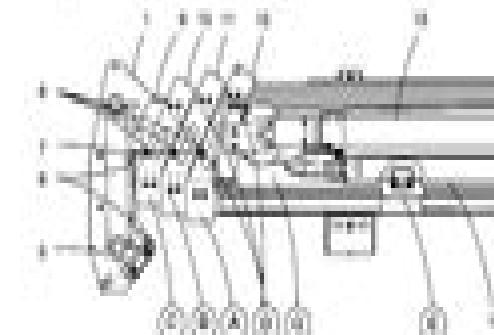
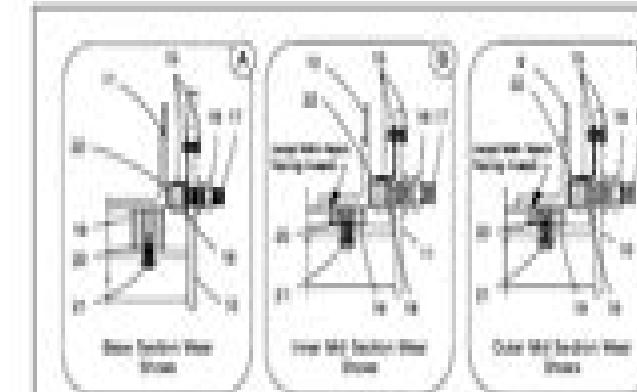
**Note:** Insert sleeve (15) and cylinder assembly (16) into the tie section (3) until the cylinder sleeve (15) is seated.

**13. Tie cylinder (16) sleeve (15), sleeve (15) and cylinder assembly (16), and pin (17)**  
Note: The tolerance of sleeve (15), sleeve (15) and cylinder assembly (16), and pin (17), the clearance should be 1.0 to 1.50 mm (0.039 to 0.059 in) as illustrated in Figure 2.

**14. Heat shrink (9) and lockwashers (8)**

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# Link Belt Service Manual

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