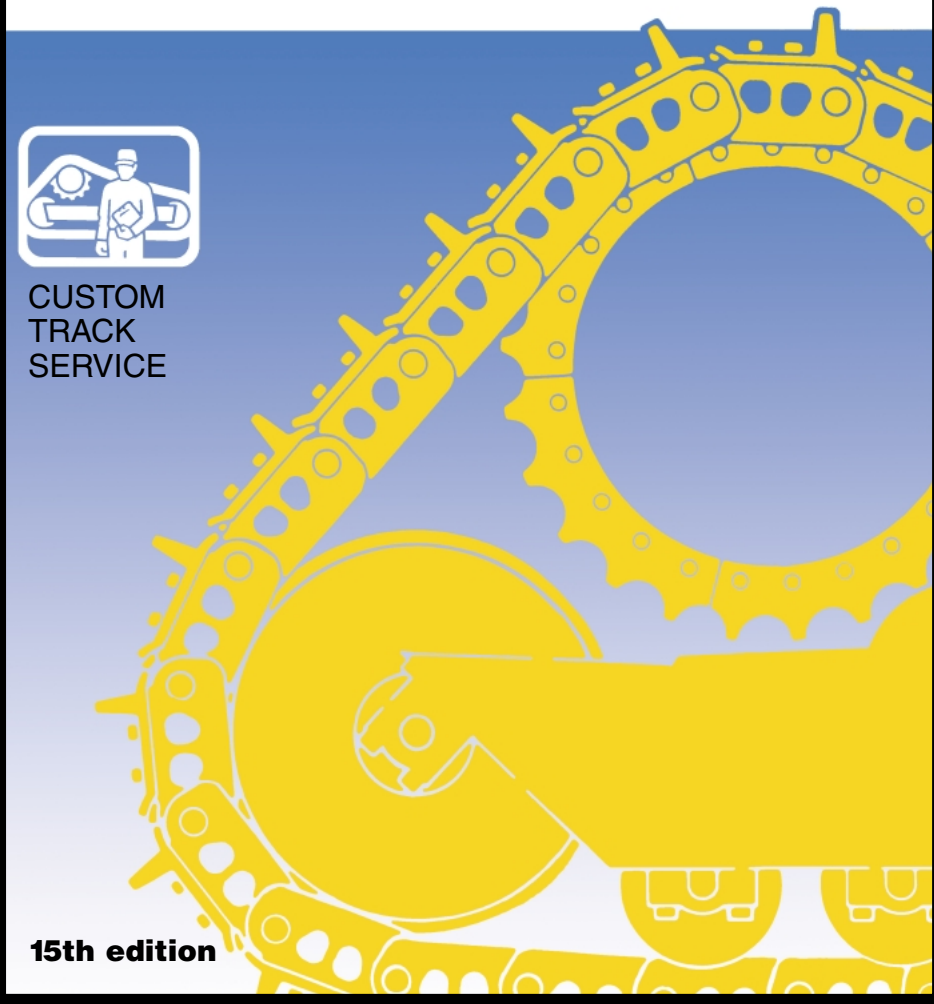
CATERPILLAR®

Custom Track Service Handbook



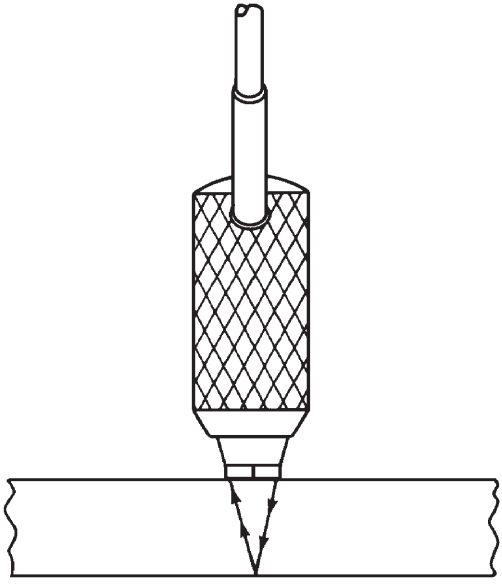
15th edition

Ultrasonic Wear Indicator

The ultrasonic wear indicator measures component thickness by sending high frequency sound waves through the material to be measured. The elapsed time between sending and receiving the sound waves allows the tool to determine thickness.

This electronic CTS tool has the following key features and benefits:

• Ultrasonic wave emitting probe	• Reduces time spent cleaning parts (especially bushings and shoes). • Eliminates measurement errors due to dirt packing around parts. • Measures bushings after turning. • Eliminates errors due to measurement technique differences among inspectors. • Measures idler center flange wear.
• Memory	• Reduces on-site measurement recording. • Stores inspections for 64 machines. • Downloads to CTS computer program for automatic percent worn and projected life calculations. • Uploads previous inspections from CTS computer program to improve speed and quality
• Language capability	• English, French, German, Portuguese, Spanish
• Earphone connector	• Allows users to hear “Coupled” beeping indicator
• Backlight feature	• Allows users to see the display in poor lighting conditions



2. To check front idler height, carefully move the machine in REVERSE until a track shoe grouser is directly below the center of the idler shaft. See Illustration 2.

3. Measure the distance (dimension X), between the bottom of the track shoe grouser in full contact with the surface and the bottom of the track shoe grouser directly below the idler shaft.

4. Repeat the procedure of aligning the track shoe grouser directly below the center of the idler shaft on the rear idler by carefully moving the machine forward. Measure dimension X for the rear idler.

5. Idler height varies from model to model and between front and rear idlers. Compare dimension X with the recommended nominal and minimum values for the front and rear idlers that correspond to your model as shown in Chart A.

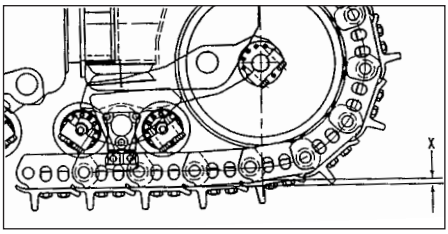


Illustration 3. Measurement points on a soft surface.

Note: In the event that a suitable hard surface is not available for checking idler height, a less accurate method may be used. See steps 6 and 7 below.

6. Carefully move the machine in REVERSE until a track shoe grouser is directly below the center of the idler shaft.

7. Stretch a length of string along the top edge of the track shoes. Dimension X is measured from the string to the point where the center line of the idler shaft intersects the top of the track shoe which is directly below it. See Illustration 3 for the location of dimension X.

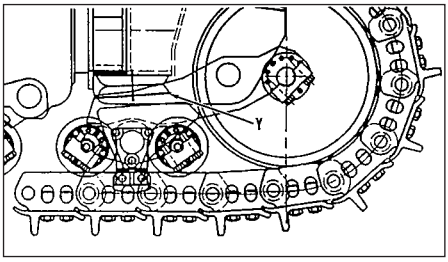


Illustration 4. Add plates at point Y.

Chart B

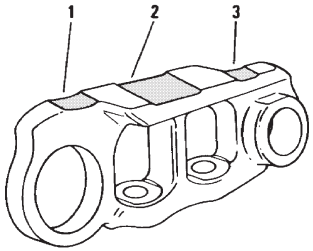
Model	Plate Part No.	Plate Thickness
D8L	9P5543	5 mm (.196 in)
D8N, D8R	7T4699	5 mm (.196 in)
D9N, D9R	7T5422	5 mm (.196 in)
D9L, D10N, D10R	9P2704	5 mm (.196 in)
D10, D11N, D11R	8P8884	5 mm (.196 in)

⚠ WARNING

Prior to adding plates under the bogie pads, raise the machine until the bogies are hanging free. Carefully support the machine. See the disassembly and assembly module in your machine's Service Manual for the correct procedure.

8. If dimension X is less than the minimum shown in Chart A, plates should be added between the lower bogie pad and the top of the major bogie assemblies at point Y. The appropriate plates and their part number are listed in Chart B. See Illustration 4 for the correct location to add plates.

The addition of one plate installed under a front or rear bogie pad increases idler height by approximately 7.50 mm (.295 in). In order to maintain uniform roller loading, equal number of plates must be installed under the intermediate bogie pads. Take care not to install more plates than are necessary to achieve the proper idler height dimension. Excessive idler height results in poor dozer control, particularly while performing finish dozing operations.



Uneven (Scalloping) Wear on Rail Top

CAUSES: No. 1 & 3: Faster wear rate due to reduced contact with rollers at narrower link overlap area (also see Face Wear on page 31).

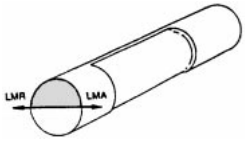
CAUSES: No. 2: Sliding wear due to reduced contact area with idler at center of link rail.

ACCELERATORS: Same as Rail (Top) Wear above, particularly tight track.

EFFECT: No. 1 & 3: Wear limit over pin boss reached prematurely.

No. 1, 2 & 3: Reduces rebuildability and causes vibration in extreme cases. Counterweighting machines will reduce wear. A 1/4" difference will cause a ride problem.

REMEDIES: Same as Rail Top Wear above. Sealed and Lubricated Track will have less wear in areas No. 1 & 3 due to no pitch extension. Better balance will reduce vibration and potential cracking in cab.

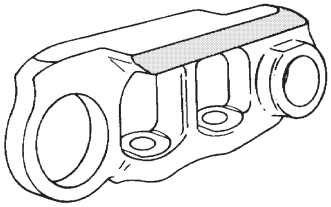


Pin Boss Side Wear

CAUSES: Sliding contact with guiding and/or roller guards plus abrasives (may be seen at either or both ends of pin — usually more severe on outboard side).

ACCELERATORS: Uneven terrain and side hill operation. Too-wide shoes, worn rolling component flange, misalignment and snaky track are main controllable variables.

REMEDIES: Eliminate or reduce controllable accelerator variables, particularly snaky track by turning pins and bushings.



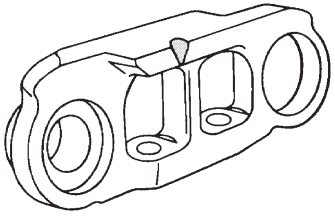
Rail Side Wear (inside and/or outside)

CAUSES: Rolling and sliding contact with roller and idler flanges.

ACCELERATED BY: Same as "Rail Top Wear" plus uneven terrain, turning, side hill operation, misalignment, too wide shoes and snakiness of unsealed or Sealed Track.

EFFECT: Reduces rail wear life to service limit and rebuildability.

REMEDIES: Reduce or eliminate controllable accelerators, particularly snaky track, tight track and too wide shoes.



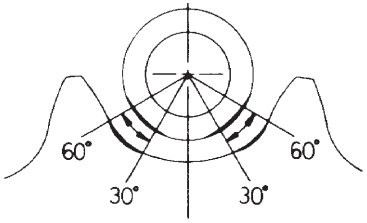
Rail Inside Gouged

CAUSES: Sprocket tooth tip interfering due to snaky track and/or misalignment of track or sprocket (see sprocket wear).

ACCELERATORS: Side hill or uneven terrain, turning, too wide shoes.

EFFECT: Reduced rebuildability of links and reusability of sprocket segments if severe.

REMEDIES: Correct controllable causes and accelerators.



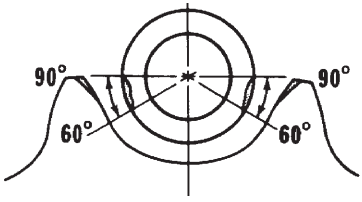
Reverse and/or Forward Drive Side (30° to 60° from vertical)

CAUSES: Same as VERTICAL POSITION except degree of packing is moderately severe.

ACCELERATORS: Same as VERTICAL POSITION but particularly tight track.

EFFECT: VERTICAL POSITION should overtake FDS or RDS as most worn position in later hours if track is properly adjusted and new segments are not installed prematurely.

REMEDIES: Eliminate controllable accelerator variables, particularly tight track. Bushing should be turned at or before service limit.



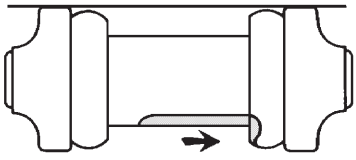
Reverse and/or Forward Drive Side Pocket Wear (60° to 90° from vertical)

CAUSES: (1) Same as VERTICAL and FDS/RDS except packing is very severe. (2) Track is too loose causing "backjamming" as reverse motion at bottom of sprocket on RDS only.

ACCELERATORS: (1) Same as "Vertical Position" and FDS/RDS (2) Same as "Vertical Position" and FDS/RDS except track tension, which needs to be increased. Uphill reverse loading of machine with too loose track is biggest accelerator.

EFFECT: (1) Vertical position should overtake either pocket as most worn position in later hours if track is properly adjusted and new segments are not installed prematurely. (2) Track may jump on sprocket if sprocket tooth tip height is worn excessively and track remained too loose.

REMEDIES: (1) Eliminate or reduce controllable accelerator variables. Turn bushing before this position reaches 120 percent regardless of the vertical position percent worn. Do not install new segments prematurely. (See discussion on use of sprocket reuse gauge.) (2) Adjust track as recommended in the individual product sections. Install new segments only if tip height is reduced significantly and there is no moderate to severe packing. Turn bushings before this position reaches 120 percent regardless of vertical position percent worn.



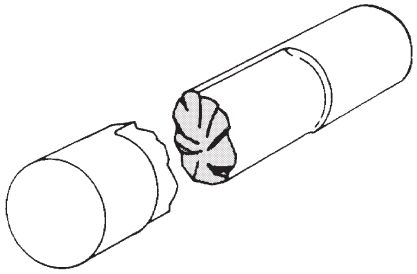
Off Center Wear

CAUSES: Misalignment of track and sprocket.

ACCELERATORS: (1) Various roller frame and sprocket alignment problems. (2) Worn rear guiding and/or final drive-guiding guards. (3) Side-hill operation.

EFFECT: Should not increase wear rate of bushing to wear limits, but may reduce bushing retention if accompanied by impact.

REMEDIES: (1) Correct alignment. (2) Replace guiding and final drive-guiding guards.



Pin Breakage

CAUSES: High static or impact loads which cause crack to start at outer surface (usually at pin wear step) and moves through entire pin at a fast rate.

Pin cracking and breaking is less severe with Sealed and Lubricated Track during absence of internal wear. However, it may be more serious once lubricant is lost and internal wear is present due to faster rate of internal wear and loss of pin strength due to reservoir hole.

ACCELERATORS: Horsepower, weight and speed of machine. Impact and terrain conditions. Amount of internal wear that reduces pin diameter. Tight track, too-wide shoe, worn rear rollers and severe packing loads caused by rocks between bushing and sprocket are main controllable variables.

EFFECT: Immediate track separation. Severe damage to other components.

REMEDIES: Eliminate or reduce controllable accelerator variables, particularly rocks which are getting into spaces between sprocket and bushings.

Sealed Track Pins & Bushing Turn and Replacement Guidelines

The following guidelines should be used in determining if and when Sealed Track pins and bushings should be turned and/or replaced. The general guidelines discussed in the section entitled "Track Management" should be understood and practiced before applying these specifics.

1. If a Sealed Track pin and bushing turn and/or replacement is required to help utilize total track link life it should be done on or before either the internal wear or external bushing service points (100 percent worn) are reached, whichever comes first.
2. If a pin and bushing replacement is required to help utilize the projected total potential link life following the turn of a previous set of pins and bushings, it should also be done on or before either the internal wear exceeds the service point (100 percent worn) or the external bushing surface is run to destruction (120 percent worn), regardless of which occurs first.
3. When in doubt, turn early for best after turn and after replacement wear and structural life performance contributing to overall best total track life and parts reusability.

Do not use these criteria to determine if and when to turn as they involve unreliable measurement techniques:

1. Sprocket wear lines or general sprocket tooth wear condition.
2. Extent of idler adjustment used to remove slack is determined by pitch extension from internal wear.
3. Waiting until other components (such as shoes) are ready for maintenance or service based on previous experience of phasing work at the same time.

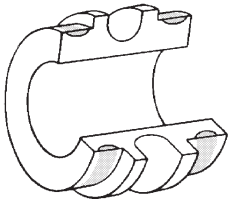
Remember, if pins and bushings are run to destruction internally prior to replacement, then the replacement set may give as little as 80 percent life of the original set.

Swapping Carrier Rollers

Carrier rollers can be swapped from front to rear and left to right to help balance their wear life in cases where conditions have caused unequal wear rates. Criteria are: greater than 1.5:1 ratio and average less than 60 percent worn.

Carrier Roller Wear Patterns

There are three principle wear patterns found on carrier rollers. In each case the effect on the links may be more critical, considering total undercarriage life, than on the carrier rollers themselves.



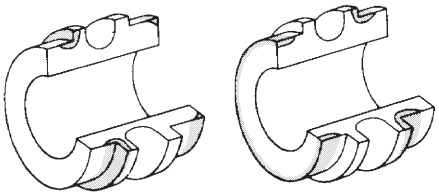
Tread Wear (Uniform)

CAUSES: (1) Rolling and sliding motion with link rail (top) surfaces. (2) Sliding contact with packing material on roller frame.

ACCELERATORS: Machine speed. Weight of track which is governed by shoe width including packing material. Track tension is primary controllable variable as tight track increases loads and too loose track causes impact between links and tread surface, particularly in forward motion.

EFFECT: Wear life of carrier roller and links. No other components affected unless service limit exceeded, then flanges may strike bushings causing unusual wear pattern and premature failure.

REMEDIES: Maintain proper track tension and reduce or eliminate other controllable accelerator variables. Rebuild or replace carrier roller shell when service limit reached.



Uneven Flange Side Wear and Off-center Tread Wear

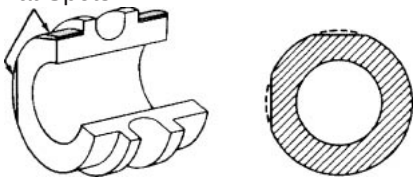
CAUSES: Rolling and sliding contact with link rail top and sides not aligned with carrier roller.

ACCELERATORS: Same as "Carrier Roller Tread Wear" plus terrain and side-hill; and misalignment of carrier rollers, sprocket and/or idler. Offset shoes will move track to outboard side.

EFFECTS: Loss of potential wear life and rebuildability of carrier roller and links.

REMEDIES: Reduce or eliminate controllable accelerators. Swap carrier roller to balance wear.

Flat Spots



Flat Spots on Tread

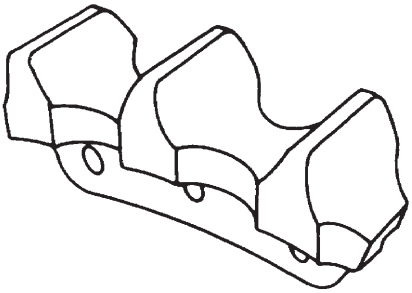
CAUSES: Sliding contact with link rail tops when carrier roller not turning.

ACCELERATORS: Same as "Even Tread Wear." Packing between roller frame and carrier roller is principle cause of seizing.

EFFECT: Reduced wear life and rebuildability of carrier rollers. Accelerated wear on links.

REMEDIES: Clean packing material away from carrier rollers.

Mud & Snow Segments and Rims



Mud/snow sprockets, rims and segments have the same tooth profile as standard segments. They provide an avenue to relieve the pocket of material through a slot cut into the tooth root. The same segment serves both Sealed and Sealed and Lubricated Track.

They should be recommended only where packing material is extrudable (see discussion on "Packing" in section entitled "Underfoot Conditions") and is always present.

In the absence of constant, extrudable type packing material, the reduced contact area in the root of the tooth will cause an accelerated "hour-glass" shaped wear pattern on the bushing in the vertical position and may result in reduced bushing wear life.

How to Properly Torque Segment Hardware

The principal cause of segment loosening, and subject loss and/or damage to other parts, is improper torque-turn tightening method.

To install segment hardware, first, lubricate the bolt threads and the washer face of the nut with 5P3931 Antiseize Compound or an equivalent lubricant.

Second, tighten all nuts on any one segment to the specified initial torque. This draws the mating parts tightly together.

Third, tighten each nut a 1/3 additional turn. This stretches the bolt properly for good segment retention.

The actual torque specifications can be found in the "Management" section of each type machine.

INSPECTION REPORT

RECOMMENDATION CHECKLIST AND TOTAL LIFE SCALES

ITEM	AT SMU or DATE
LINK ASSEMBLY:	
REPAIR DRY JOINTS	
TURN PINS & BUSHINGS	
REPLACE PINS & BUSHINGS	
TURN BUSHINGS WET	
REPLACE BUSHING/SEALS	
TURN BUSHINGS DRY	
SWAP SIDES	
REPLACE WITH NEW	
ADJUST TENSION ☐	
SHOES:	
REGROUSER	
REPLACE WITH NEW	
TYPE:_____ LENGTH:_____	
IDLERS:	
WELD TREADS	
SWAP SIDES	
SWAP FRONT/REAR	
REPLACE WITH NEW	
WELDED EXCHANGE AVAILABLE ☐	
CARRIER ROLLERS:	
RESHELL	
SWAP SIDES	
SWAP FRONT/REAR	
REPLACE WITH NEW	
EXCHANGE AVAILABLE ☐	

ITEM	POSITION	AT SMU or DATE
TRACK ROLLERS:	F 2 3 4 5 6 7 8	
WELD TREAD (✔)	☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐	
RESHELL (✔)	☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐	
SWAP-L. HAND*	— — — — — — — —	
SWAP-R. HAND*	— — — — — — — —	
SWAP-L. TO R*	— — — — — — — —	
*WRITE-IN NEW POSITIONS		
SPIN IN PLACE (✔)	☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐	
TRIM FLANGES (✔)	☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐	
REPLACE WITH NEW (✔)	☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐	
EXCHANGE AVAILABLE:	WELDED ☐ RESHELLED ☐	
SPROCKETS/SEGMENTS:		
REPLACE AT TURN ☐ REUSE AT TURN ☐ TIME		
REPLACE AT PIN/BUSHING REPLACEMENT TIME		
REPLACE AT NEW LINK ASSEMBLY TIME		
GUARDS:		
GUIDING - END ☐ CENTER ☐		
REPLACE WEAR STRIPS		
REPLACE ASSEMBLIES		
ROLLER/ROCK		
REMOVE		
REPLACE		
FINAL DRIVE/SPROCKET		
REPLACE WEAR SHOE/STRI P		
OTHER:		
ROLLER FRAME - ALIGN/STRAIGHTEN		
BOGIE PADS - REPLACE		
HYDRAULIC ADJUSTER - REPAIR		

OPTION 1					
LINKS	- - - -	- - - -	- - - -	- - - -	- - - -
BUSHINGS	- - - -	- - - -	- - - -	- - - -	- - - -
SHOES	- - - -	- - - -	- - - -	- - - -	- - - -
IDLERS					
FRONT	- - - -	- - - -	- - - -	- - - -	- - - -
REAR	- - - -	- - - -	- - - -	- - - -	- - - -
CARRIER ROLLERS	- - - -	- - - -	- - - -	- - - -	- - - -
TRACK ROLLERS	- - - -	- - - -	- - - -	- - - -	- - - -
WORST	- - - -	- - - -	- - - -	- - - -	- - - -
SWAPPED	- - - -	- - - -	- - - -	- - - -	- - - -

OPTION 2					
LINKS	- - - -	- - - -	- - - -	- - - -	- - - -
BUSHINGS	- - - -	- - - -	- - - -	- - - -	- - - -
SHOES	- - - -	- - - -	- - - -	- - - -	- - - -
IDLERS					
FRONT	- - - -	- - - -	- - - -	- - - -	- - - -
REAR	- - - -	- - - -	- - - -	- - - -	- - - -
CARRIER ROLLERS	- - - -	- - - -	- - - -	- - - -	- - - -
TRACK ROLLERS	- - - -	- - - -	- - - -	- - - -	- - - -
WORST	- - - -	- - - -	- - - -	- - - -	- - - -
SWAPPED	- - - -	- - - -	- - - -	- - - -	- - - -

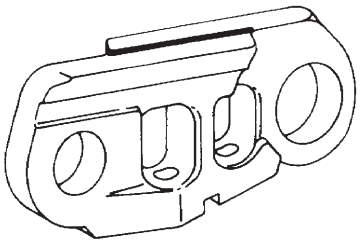
CUSTOM TRACK SERVICE

COST PER HOUR

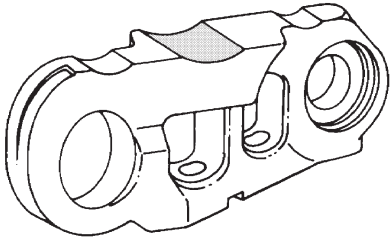
Total Cost Per Hour of New Track Groups

	(a.) 10,000	(b.) 12,000	(c.) 13,500
Cost to Replace P & B	(Twice)	(Once)	(None)
Parts	3,000	1,500	0
Labor	1,000	500	0
Cost to Turn P & B	(None)	(Twice)	(Once)
Parts		300	0
Labor		1,000	750
Cost to Replace Shoes	(Twice) 8,000	(Once) 6,000	(None)
Cost to Remove & Install Shoes	(Twice)	(Once)	(Once)
Labor	(Inc. W/P&B Rep)	(Inc. W/P&B Rep)	(Inc. W/Bush Turn)
Hardware	200	100	100
Cost to Regrouser	(None)	(None)	(In Shop) 1500
Cost of Handling & Transportation	400 (Twice)	200 (Once)	200 (Once)
Cost of Downtime	1,000 (Twice)	500 (Once)	500 (Once)
Trade in Value	N/A	N/A	-600
Exchange Value	N/A	-1600	N/A
Scrap Value	-400	N/A	N/A
Total	23,200	20,500	15,950
TOTAL Track Group Cost per hour of effective life	$\frac{23,200}{7,000\ SMU} = 3.31$	$\frac{20,500}{7,000\ SMU} = 2.93$	$\frac{15,950}{7,000\ SMU} = 2.28$

This comparison could be expanded to include respective segment, roller, carrier roller, idler and other wear part costs over the same link life or compared individually over their own respective and effective total wear lives.



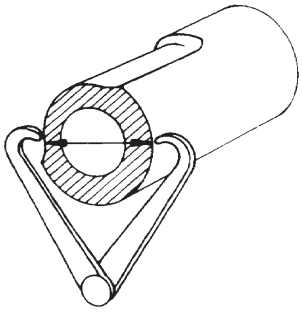
Wear Patterns — The undercarriage design of elevated sprocket machines and the absence of "snakiness" in Sealed and Lubricated Track allow it to "track" very straight. This straight tracking causes the roller to wear with a slight ridge running down the center of the tread. This ridge results from less wear occurring on the center of the roller tread as it passes over the links in their overlap area. The ridge on the roller may in turn wear a groove down the center of the link rail. This wear pattern is normal for these machines. It may occur less often on machines with non-suspended undercarriage. D9R, D10R, and D11R machines with improved alignment undercarriage also minimize or eliminate this wear pattern.



As elevated sprocket undercarriage wears, a larger scallop develops over the link strut than on oval undercarriage machines. This is because the track link goes around two idlers instead of one. This wear is not considered critical. Evaluate link wear based on wear directly over the pin area.

Split Master Links — Use the assembly procedures on page 33 for split master links. Refer to "Shoes" on the following page for bolt torque specifications.

Pins and Bushings



Elevated Sprocket Machines use Sealed and Lubricated Track. See pages 36 through 43 for details. The following points are specifically for elevated sprocket machines:

Measurement — Use the caliper or the Ultrasonic Wear Indicator to measure all three bushing contact sides: forward, reverse, and vertical. Use the most worn position to make projections. This practice is necessary because wear can occur in all three positions, depending on the degree of packing. The depth gauge should not be used before a bushing turn because it only measures vertical bushing wear. After a bushing turn, the depth gauge can be used to approximate wear based on the vertical dimension.

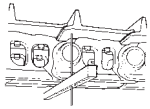
Bushing Allowable Wear — Bushing allowable wear is based on the remaining strength to resist cracks. For low sprocket machines, the choice between two allowable wears is based on high or low impact conditions because the sprocket is close to the ground and subject to impact.

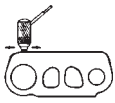
The choice between the two allowable wears for elevated sprocket machines is different because the sprocket is not subject to impact. For machines in underfoot conditions which have only fine granular materials, use the chart showing the greater allowable wear. For all other conditions use the chart with lesser allowable wear.

D4H, D5M, D5N, 561H, 561M, 561N — 6.75" (171.5 mm)

Track Links

Heavy Duty Track
Rotating Bushing Track
108-0947 & 48





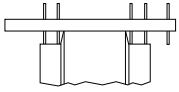
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
4.17	(106.0)	0	1.22	(31.0)
4.15	(105.5)	6	1.20	(30.5)
4.13	(105.0)	12	1.18	(30.0)
4.11	(104.5)	18	1.16	(29.5)
4.09	(104.0)	24	1.14	(29.0)
4.07	(103.5)	30	1.12	(28.4)
4.05	(103.0)	36	1.10	(27.9)
4.03	(102.5)	42	1.08	(27.4)
4.01	(102.0)	48	1.06	(26.9)
3.99	(101.5)	54	1.04	(26.4)
3.97	(101.0)	60	1.02	(25.9)
3.95	(100.5)	65	1.00	(25.4)
3.93	(100.0)	70	0.98	(24.9)
3.91	(99.5)	75	0.96	(24.4)
3.89	(99.0)	80	0.94	(23.9)
3.87	(98.5)	85	0.92	(23.4)
3.85	(98.0)	90	0.90	(22.9)
3.83	(97.5)	95	0.88	(22.4)
3.81	(97.0)	100	0.86	(21.8)
3.79	(96.5)	105	0.84	(21.3)
3.77	(96.0)	110	0.82	(20.8)
3.75	(95.5)	115	0.80	(20.3)
3.73	(94.5)	120	0.78	(19.8)

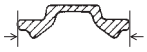
Undercarriage Code: 1108, 111, 1121, 1122, 1208, 121, 124, 125, 1251, 128, 129, 1291

D4H, D5M, D5N, 561H, 561M, 561N — 6.75" (171.5 mm)

Idlers

Original Idler





5.31" (135 mm)

Depth Gauge Inches	(mm)	% Worn
0.66	(17.0)	0
0.68	(17.5)	8
0.70	(18.0)	16
0.72	(18.5)	24
0.74	(19.0)	32
0.76	(19.5)	40
0.78	(20.0)	48
0.80	(20.5)	56
0.82	(21.0)	64
0.84	(21.5)	72
0.86	(22.0)	76
0.88	(22.5)	79
0.90	(23.0)	82
0.92	(23.5)	85
0.94	(24.0)	88
0.96	(24.5)	91
0.98	(25.0)	94
1.00	(25.5)	97
1.02	(26.0)	100
1.04	(26.5)	103
1.06	(27.0)	106
1.08	(27.5)	109
1.10	(28.0)	112
1.12	(28.5)	115
1.14	(29.0)	118
1.16	(29.5)	121

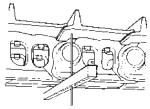
Flange width: 2.68" (68 mm)

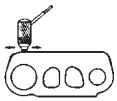
Undercarriage Code: 110, 11002, 1101, 11012, 1108, 111, 1121, 120, 12002, 1201, 12012, 1208, 121, 124, 1248, 12482, 125, 128, 1291

D5H, D6M, D6N, 517 — 7.50" (190 mm)

Track Links

Heavy Duty Track
Rotating Bushing Track
106-1625 & 26



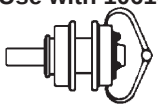


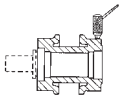
Depth Gauge			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
4.68	(119.0)	0	1.53	(38.9)
4.66	(118.5)	5	1.51	(38.4)
4.64	(118.0)	10	1.49	(37.8)
4.62	(117.5)	15	1.47	(37.3)
4.60	(117.0)	20	1.45	(36.8)
4.58	(116.5)	25	1.43	(36.3)
4.56	(116.0)	30	1.41	(35.8)
4.54	(115.5)	35	1.39	(35.3)
4.52	(115.0)	40	1.37	(34.8)
4.50	(114.5)	45	1.35	(34.3)
4.48	(114.0)	50	1.33	(33.8)
4.46	(113.5)	55	1.31	(33.3)
4.44	(113.0)	60	1.29	(32.8)
4.42	(112.5)	65	1.27	(32.3)
4.40	(112.0)	70	1.25	(31.8)
4.38	(111.5)	75	1.23	(31.2)
4.36	(110.5)	80	1.21	(30.7)
4.34	(110.0)	84	1.19	(30.2)
4.32	(109.5)	88	1.17	(29.7)
4.30	(109.0)	92	1.15	(29.2)
4.28	(108.5)	96	1.13	(28.7)
4.26	(108.0)	100	1.11	(28.2)
4.24	(107.5)	104	1.09	(27.7)
4.22	(107.0)	108	1.07	(27.2)
4.20	(106.5)	112	1.05	(26.7)
4.18	(106.0)	116	1.03	(26.2)
4.16	(105.5)	120	1.01	(25.7)

Undercarriage Code: 1338, 137, 140, 141, 1411, 144, 146, 1461, 280, 281

Carrier Rollers

Use with 1061625 & 26 Heavy Duty and Rotating Bushing Track





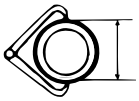
Caliper			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
6.75	(171.5)	0	1.55	(39.4)
6.71	(170.5)	3	1.53	(38.9)
6.67	(169.5)	6	1.51	(38.4)
6.63	(168.5)	9	1.49	(37.8)
6.59	(167.5)	12	1.47	(37.3)
6.55	(166.5)	15	1.45	(36.8)
6.51	(165.5)	18	1.43	(36.3)
6.47	(164.5)	21	1.41	(35.8)
6.43	(163.5)	24	1.39	(35.3)
6.39	(162.5)	27	1.37	(34.8)
6.35	(161.5)	30	1.35	(34.3)
6.31	(160.5)	33	1.33	(33.8)
6.27	(159.5)	36	1.31	(33.3)
6.23	(158.0)	39	1.29	(32.8)
6.19	(157.0)	42	1.27	(32.3)
6.15	(156.0)	45	1.25	(31.8)
6.11	(155.0)	48	1.23	(31.2)
6.07	(154.0)	51	1.21	(30.7)
6.03	(153.0)	54	1.19	(30.2)
5.99	(152.0)	57	1.17	(29.7)
5.95	(151.0)	60	1.15	(29.2)
5.91	(150.0)	63	1.13	(28.7)
5.87	(149.0)	66	1.11	(28.2)
5.83	(148.0)	69	1.09	(27.7)
5.79	(147.0)	72	1.07	(27.2)
5.75	(146.0)	74	1.05	(26.7)
5.71	(145.0)	76	1.03	(26.2)
5.67	(144.0)	78	1.01	(25.7)
5.63	(143.0)	80	0.99	(25.1)
5.59	(142.0)	82	0.97	(24.6)
5.55	(141.0)	84	0.95	(24.1)
5.51	(140.0)	86	0.93	(23.6)
5.47	(139.0)	88	0.91	(23.1)
5.43	(138.0)	90	0.89	(22.6)
5.39	(137.0)	92	0.87	(22.1)
5.35	(136.0)	94	0.85	(21.6)
5.31	(135.0)	96	0.83	(21.1)
5.27	(134.0)	98	0.81	(20.6)
5.23	(133.0)	100	0.79	(20.1)
5.19	(132.0)	102	0.77	(19.6)
5.15	(131.0)	104	0.75	(19.1)
5.11	(130.0)	106	0.73	(18.5)
5.07	(129.0)	108	0.71	(18.0)
5.03	(128.0)	110	0.69	(17.5)
4.99	(126.5)	112	0.67	(17.0)
4.95	(125.5)	114	0.65	(16.5)
4.91	(124.5)	116	0.63	(16.0)
4.87	(123.5)	118	0.61	(15.5)
4.83	(122.5)	120	0.59	(15.0)

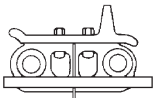
Undercarriage Code: 1338, 137, 140, 141, 1411, 144, 146, 1461, 280, 281

D6H, D6R, 527 — 8.00" (203.2 mm)

Bushings for Heavy Duty Track

Use with 8E7405 & 06 Links





Caliper		Allowable Wear Lesser	Allowable Wear Greater	Ultrasonic		Depth Gauge	
Inches	(mm)	% Worn	% Worn	Inches	(mm)	Inches	(mm)
2.86	(72.6)	0	0	0.53	(13.5)	3.52	(89.4)
2.85	(72.4)	5	4	0.52	(13.2)	3.51	(89.2)
2.84	(72.1)	10	8	0.51	(13.0)	3.50	(88.9)
2.83	(71.9)	15	12	0.50	(12.7)	3.49	(88.6)
2.82	(71.6)	20	16	0.49	(12.4)	3.48	(88.4)
2.81	(71.4)	25	20	0.48	(12.2)	3.47	(88.1)
2.80	(71.1)	30	24	0.47	(11.9)	3.46	(87.9)
2.79	(70.9)	35	28	0.46	(11.7)	3.45	(87.6)
2.78	(70.6)	40	32	0.45	(11.4)	3.44	(87.4)
2.77	(70.4)	45	36	0.44	(11.2)	3.43	(87.1)
2.76	(70.1)	50	40	0.43	(10.9)	3.42	(86.9)
2.75	(69.9)	55	44	0.42	(10.7)	3.41	(86.6)
2.74	(69.6)	60	46	0.41	(10.4)	3.40	(86.4)
2.73	(69.3)	65	48	0.40	(10.2)	3.39	(86.1)
2.72	(69.1)	70	50	0.39	(9.9)	3.38	(85.9)
2.71	(68.8)	72	52	0.38	(9.7)	3.37	(85.6)
2.70	(68.6)	74	54	0.37	(9.4)	3.36	(85.3)
2.69	(68.3)	76	56	0.36	(9.1)	3.35	(85.1)
2.68	(68.1)	78	58	0.35	(8.9)	3.34	(84.8)
2.67	(67.8)	80	60	0.34	(8.6)	3.33	(84.6)
2.66	(67.6)	82	62	0.33	(8.4)	3.32	(84.3)
2.65	(67.3)	84	64	0.32	(8.1)	3.31	(84.1)
2.64	(67.1)	86	66	0.31	(7.9)	3.30	(83.8)
2.63	(66.8)	88	68	0.30	(7.6)	3.29	(83.6)
2.62	(66.5)	90	70	0.29	(7.4)	3.28	(83.3)
2.61	(66.3)	92	72	0.28	(7.1)	3.27	(83.1)
2.60	(66.0)	94	74	0.27	(6.9)	3.26	(82.8)
2.59	(65.8)	96	76	0.26	(6.6)	3.25	(82.6)
2.58	(65.5)	98	78	0.25	(6.3)	3.24	(82.3)
2.57	(65.3)	100	80	0.24	(6.1)	3.23	(82.0)
2.56	(65.0)	102	82	0.23	(5.8)	3.22	(81.8)
2.55	(64.8)	104	84	0.22	(5.6)	3.21	(81.5)
2.54	(64.5)	106	86	0.21	(5.3)	3.20	(81.3)
2.53	(64.3)	108	88	0.20	(5.1)	3.19	(81.0)
2.52	(64.0)	110	90	0.19	(4.8)	3.18	(80.8)
2.51	(63.8)	112	92	0.18	(4.6)	3.17	(80.5)
2.50	(63.5)	114	94	0.17	(4.3)	3.16	(80.3)
2.49	(63.2)	116	96	0.16	(4.1)	3.15	(80.0)
2.48	(63.0)	118	98	0.15	(3.8)	3.14	(79.8)
2.47	(62.7)	120	100	0.14	(3.6)	3.13	(79.5)
2.46	(62.5)		102	0.13	(3.3)	3.12	(79.2)
2.45	(62.2)		104	0.12	(3.0)	3.11	(79.0)
2.44	(62.0)		106	0.11	(2.8)	3.10	(78.7)
2.43	(61.7)		108	0.10	(2.5)	3.09	(78.5)
2.42	(61.5)		110	0.09	(2.3)	3.08	(78.2)
2.41	(61.2)		112	0.08	(2.0)	3.07	(78.0)
2.40	(61.0)		114	0.07	(1.8)	3.06	(77.7)
2.39	(60.7)		116	0.06	(1.5)	3.05	(77.5)
2.38	(60.5)		118	0.05	(1.3)	3.04	(77.2)
2.37	(60.2)		120	0.04	(1.0)	3.03	(77.0)

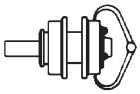
NOTE: DO NOT USE DEPTH GAUGE UNTIL BUSHINGS HAVE BEEN "TURNED."

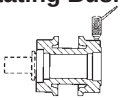
Undercarriage Code: 153, 157, 158, 1581, 163, 290, 291

D6H, D6R, 527 — 8.00" (203.2 mm)

Carrier Rollers

Use with 8E7405 & 06 or 195-6515 & 16 Heavy Duty and Rotating Bushing Track



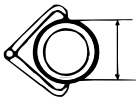


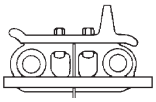
Caliper			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
7.38	(187.5)	0	1.86	(47.2)
7.34	(186.5)	4	1.84	(46.7)
7.30	(185.5)	8	1.82	(46.2)
7.26	(184.5)	12	1.80	(45.7)
7.22	(183.5)	16	1.78	(45.2)
7.18	(182.5)	20	1.76	(44.7)
7.14	(181.5)	24	1.74	(44.2)
7.10	(180.5)	28	1.72	(43.7)
7.06	(179.5)	32	1.70	(43.2)
7.02	(178.5)	36	1.68	(42.7)
6.98	(177.5)	40	1.66	(42.2)
6.94	(176.5)	44	1.64	(41.7)
6.90	(175.5)	48	1.62	(41.1)
6.86	(174.0)	52	1.60	(40.6)
6.82	(173.0)	56	1.58	(40.1)
6.78	(172.0)	60	1.56	(39.6)
6.74	(171.0)	64	1.54	(39.1)
6.70	(170.0)	68	1.52	(38.6)
6.66	(169.0)	70	1.50	(38.1)
6.62	(168.0)	72	1.48	(37.6)
6.58	(167.0)	74	1.46	(37.1)
6.54	(166.0)	76	1.44	(36.6)
6.50	(165.0)	78	1.42	(36.1)
6.46	(164.0)	80	1.40	(35.6)
6.42	(163.0)	82	1.38	(35.1)
6.38	(162.0)	84	1.36	(34.5)
6.34	(161.0)	86	1.34	(34.0)
6.30	(160.0)	88	1.32	(33.5)
6.26	(159.0)	90	1.30	(33.0)
6.22	(158.0)	92	1.28	(32.5)
6.18	(157.0)	94	1.26	(32.0)
6.14	(156.0)	96	1.24	(31.5)
6.10	(155.0)	98	1.22	(31.0)
6.06	(154.0)	100	1.20	(30.5)
6.02	(153.0)	102	1.18	(30.0)
5.98	(152.0)	104	1.16	(29.5)
5.94	(151.0)	106	1.14	(29.0)
5.90	(150.0)	108	1.12	(28.4)
5.86	(149.0)	110	1.10	(27.9)
5.82	(148.0)	112	1.08	(27.4)
5.78	(147.0)	114	1.06	(26.9)
5.74	(146.0)	116	1.04	(26.4)
5.70	(145.0)	118	1.02	(25.9)
5.66	(144.0)	120	1.00	(25.4)

Undercarriage Code: 153, 157, 158, 1581, 163, 290, 2901, 291

D7H, D7R, 572R — 8.50" (215.9 mm)

Bushings for Heavy Duty Track





Caliper Inches	(mm)	Allowable Wear Lesser % Worn	Greater % Worn	Ultrasonic Inches	(mm)	Depth Gauge Inches	(mm)
3.11	(79.0)	0	0	0.60	(15.2)	3.86	(98.0)
3.10	(78.7)	5	4	0.59	(15.0)	3.85	(97.8)
3.09	(78.5)	10	8	0.58	(14.7)	3.84	(97.5)
3.08	(78.2)	15	12	0.57	(14.5)	3.83	(97.3)
3.07	(78.0)	20	16	0.56	(14.2)	3.82	(97.0)
3.06	(77.7)	25	20	0.55	(14.0)	3.81	(96.8)
3.05	(77.5)	30	24	0.54	(13.7)	3.80	(96.5)
3.04	(77.2)	35	28	0.53	(13.5)	3.79	(96.3)
3.03	(77.0)	40	32	0.52	(13.2)	3.78	(96.0)
3.02	(76.7)	45	36	0.51	(13.0)	3.77	(95.8)
3.01	(76.5)	50	40	0.50	(12.7)	3.76	(95.5)
3.00	(76.2)	55	42	0.49	(12.4)	3.75	(95.3)
2.99	(75.9)	60	44	0.48	(12.2)	3.74	(95.0)
2.98	(75.7)	65	46	0.47	(11.9)	3.73	(94.7)
2.97	(75.4)	68	48	0.46	(11.7)	3.72	(94.5)
2.96	(75.2)	70	50	0.45	(11.4)	3.71	(94.2)
2.95	(74.9)	72	52	0.44	(11.2)	3.70	(94.0)
2.94	(74.7)	74	54	0.43	(10.9)	3.69	(93.7)
2.93	(74.4)	76	56	0.42	(10.7)	3.68	(93.5)
2.92	(74.2)	78	58	0.41	(10.4)	3.67	(93.2)
2.91	(73.9)	80	60	0.40	(10.2)	3.66	(93.0)
2.90	(73.7)	82	62	0.39	(9.9)	3.65	(92.7)
2.89	(73.4)	84	64	0.38	(9.7)	3.64	(92.5)
2.88	(73.2)	86	66	0.37	(9.4)	3.63	(92.2)
2.87	(72.9)	88	68	0.36	(9.1)	3.62	(91.9)
2.86	(72.6)	90	70	0.35	(8.9)	3.61	(91.7)
2.85	(72.4)	92	72	0.34	(8.6)	3.60	(91.4)
2.84	(72.1)	94	74	0.33	(8.4)	3.59	(91.2)
2.83	(71.9)	96	76	0.32	(8.1)	3.58	(90.9)
2.82	(71.6)	98	78	0.31	(7.9)	3.57	(90.7)
2.81	(71.4)	100	80	0.30	(7.6)	3.56	(90.4)
2.80	(71.1)	102	82	0.29	(7.4)	3.55	(90.2)
2.79	(70.9)	104	84	0.28	(7.1)	3.54	(89.9)
2.78	(70.6)	106	86	0.27	(6.9)	3.53	(89.7)
2.77	(70.4)	108	88	0.26	(6.6)	3.52	(89.4)
2.76	(70.1)	110	90	0.25	(6.3)	3.51	(89.2)
2.75	(69.9)	112	92	0.24	(6.1)	3.50	(88.9)
2.74	(69.6)	114	94	0.23	(5.8)	3.49	(88.6)
2.73	(69.3)	116	96	0.22	(5.6)	3.48	(88.4)
2.72	(69.1)	118	98	0.21	(5.3)	3.47	(88.1)
2.71	(68.8)	120	100	0.20	(5.1)	3.46	(87.9)
2.70	(68.6)		102	0.19	(4.8)	3.45	(87.6)
2.69	(68.3)		104	0.18	(4.6)	3.44	(87.4)
2.68	(68.1)		106	0.17	(4.3)	3.43	(87.1)
2.67	(67.8)		108	0.16	(4.1)	3.42	(86.9)
2.66	(67.6)		110	0.15	(3.8)	3.41	(86.6)
2.65	(67.3)		112	0.14	(3.6)	3.40	(86.4)
2.64	(67.1)		114	0.13	(3.3)	3.39	(86.1)
2.63	(66.8)		116	0.12	(3.0)	3.38	(85.9)
2.62	(66.5)		118	0.11	(2.8)	3.37	(85.6)
2.61	(66.3)		120	0.10	(2.5)	3.36	(85.3)

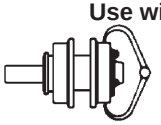
NOTE: DO NOT USE DEPTH GAUGE UNTIL BUSHINGS HAVE BEEN "TURNED."

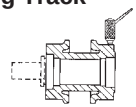
Undercarriage Code: 1642, 166, 169, 170, 1701, 173, 174, 1741

D7H, D7R, 572R — 8.50" (215.9 mm)

Carrier Rollers

Use with Heavy Duty or Rotating Bushing Track





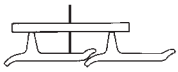
Caliper			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
7.50	(190.5)	0	1.92	(48.8)
7.46	(189.5)	4	1.90	(48.3)
7.42	(188.5)	8	1.88	(47.8)
7.38	(187.5)	12	1.86	(47.2)
7.34	(186.5)	16	1.84	(46.7)
7.30	(185.5)	20	1.82	(46.2)
7.26	(184.5)	24	1.80	(45.7)
7.22	(183.5)	28	1.78	(45.2)
7.18	(182.5)	32	1.76	(44.7)
7.14	(181.5)	36	1.74	(44.2)
7.10	(180.5)	40	1.72	(43.7)
7.06	(179.5)	44	1.70	(43.2)
7.02	(178.5)	48	1.68	(42.7)
6.98	(177.5)	50	1.66	(42.2)
6.94	(176.5)	52	1.64	(41.7)
6.90	(175.5)	54	1.62	(41.1)
6.86	(174.0)	56	1.60	(40.6)
6.82	(173.0)	58	1.58	(40.1)
6.78	(172.0)	60	1.56	(39.6)
6.74	(171.0)	62	1.54	(39.1)
6.70	(170.0)	64	1.52	(38.6)
6.66	(169.0)	66	1.50	(38.1)
6.62	(168.0)	68	1.48	(37.6)
6.58	(167.0)	70	1.46	(37.1)
6.54	(166.0)	72	1.44	(36.6)
6.50	(165.0)	74	1.42	(36.1)
6.46	(164.0)	76	1.40	(35.6)
6.42	(163.0)	78	1.38	(35.1)
6.38	(162.0)	80	1.36	(34.5)
6.34	(161.0)	82	1.34	(34.0)
6.30	(160.0)	84	1.32	(33.5)
6.26	(159.0)	86	1.30	(33.0)
6.22	(158.0)	88	1.28	(32.5)
6.18	(157.0)	90	1.26	(32.0)
6.14	(156.0)	92	1.24	(31.5)
6.10	(155.0)	94	1.22	(31.0)
6.06	(154.0)	96	1.20	(30.5)
6.02	(153.0)	98	1.18	(30.0)
5.98	(152.0)	100	1.16	(29.5)
5.94	(151.0)	102	1.14	(29.0)
5.90	(150.0)	104	1.12	(28.4)
5.86	(149.0)	106	1.10	(27.9)
5.82	(148.0)	108	1.08	(27.4)
5.78	(147.0)	110	1.06	(26.9)
5.74	(146.0)	112	1.04	(26.4)
5.70	(145.0)	114	1.02	(25.9)
5.66	(144.0)	116	1.00	(25.4)
5.62	(142.5)	118	0.98	(24.9)
5.58	(141.5)	120	0.96	(24.4)

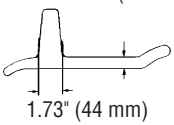
Undercarriage Code: 1642, 166, 169, 170, 1701, 173, 174, 1741

D8L, D8N, D8R, 578, 583R — 8.50" (215.9 mm)

Track Shoes

Super Extreme Service





Depth Gauge Inches	(mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	(mm)
3.70	(94.0)	0	0	4.50	(114.3)
3.60	(91.5)	5	4	4.40	(111.8)
3.50	(89.0)	10	8	4.30	(109.2)
3.40	(86.5)	15	12	4.20	(106.7)
3.30	(84.0)	20	16	4.10	(104.1)
3.20	(81.5)	25	20	4.00	(101.6)
3.10	(78.5)	30	24	3.90	(99.1)
3.00	(76.0)	35	28	3.80	(96.5)
2.90	(73.5)	40	32	3.70	(94.0)
2.80	(71.0)	45	36	3.60	(91.4)
2.70	(68.5)	50	40	3.50	(88.9)
2.60	(66.0)	55	44	3.40	(86.4)
2.50	(63.5)	60	48	3.30	(83.8)
2.40	(61.0)	64	52	3.20	(81.3)
2.30	(58.5)	68	56	3.10	(78.7)
2.20	(56.0)	72	60	3.00	(76.2)
2.10	(53.5)	76	64	2.90	(73.7)
2.00	(51.0)	80	68	2.80	(71.1)
1.90	(48.5)	84	72	2.70	(68.6)
1.80	(45.5)	88	76	2.60	(66.0)
1.70	(43.0)	92	79	2.50	(63.5)
1.60	(40.5)	96	82	2.40	(61.0)
1.50	(38.0)	100	85	2.30	(58.4)
1.40	(35.5)	104	88	2.20	(55.9)
1.30	(33.0)	108	91	2.10	(53.3)
1.20	(30.5)	112	94	2.00	(50.8)
1.10	(28.0)	116	97	1.90	(48.3)
1.00	(25.5)	120	100	1.80	(45.7)
0.90	(23.0)		103	1.70	(43.2)
0.80	(20.5)		106	1.60	(40.6)
0.70	(18.0)		109	1.50	(38.1)
0.60	(15.0)		112	1.40	(35.6)
0.50	(12.5)		115	1.30	(33.0)
0.40	(10.0)		118	1.20	(30.5)
0.30	(7.5)		121	1.10	(27.9)

Undercarriage Code: 178, 180, 182, 183, 184

D8N, D8R, 578, 583R — 8.50" (215.9 mm)

Sprockets

Do not use with D8L

Tape Measure Inches	Tape Measure (mm)	% Worn
9.40	(239.0)	0
9.35	(237.5)	7
9.30	(236.0)	14
9.25	(235.0)	21
9.20	(233.5)	28
9.15	(232.5)	35
9.10	(231.0)	40
9.05	(230.0)	45
9.00	(228.5)	50
8.95	(227.5)	55
8.90	(226.0)	60
8.85	(225.0)	65
8.80	(223.5)	70
8.75	(222.5)	75
8.70	(221.0)	80
8.65	(219.5)	85
8.60	(218.5)	90
8.55	(217.0)	95
8.50	(216.0)	100
8.45	(214.5)	105
8.40	(213.5)	110
8.35	(212.0)	115
8.30	(211.0)	120

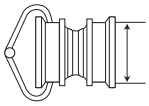
NOTE: Measure across 3 teeth

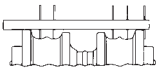
Undercarriage Code: 1785, 179, 180, 183, 184

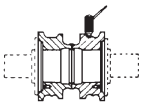
D9N, D9R — 9.45" (240 mm)

Track Rollers

Double Flange







Caliper			Depth Gauge		Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)	Inches	(mm)
9.84	(250.0)	0	0.78	(20.0)	2.54	(64.5)
9.74	(247.5)	5	0.83	(21.0)	2.49	(63.2)
9.64	(245.0)	10	0.88	(22.5)	2.44	(62.0)
9.54	(242.5)	15	0.93	(23.5)	2.39	(60.7)
9.44	(240.0)	20	0.98	(25.0)	2.34	(59.4)
9.34	(237.0)	25	1.03	(26.0)	2.29	(58.2)
9.24	(234.5)	30	1.08	(27.5)	2.24	(56.9)
9.14	(232.0)	35	1.13	(28.5)	2.19	(55.6)
9.04	(229.5)	40	1.18	(30.0)	2.14	(54.4)
8.94	(227.0)	45	1.23	(31.0)	2.09	(53.1)
8.84	(224.5)	50	1.28	(32.5)	2.04	(51.8)
8.74	(222.0)	55	1.33	(34.0)	1.99	(50.5)
8.64	(219.5)	60	1.38	(35.0)	1.94	(49.3)
8.54	(217.0)	65	1.43	(36.5)	1.89	(48.0)
8.44	(214.5)	70	1.48	(37.5)	1.84	(46.7)
8.34	(212.0)	73	1.53	(39.0)	1.79	(45.5)
8.24	(209.5)	76	1.58	(40.0)	1.74	(44.2)
8.14	(207.0)	79	1.63	(41.5)	1.69	(42.9)
8.04	(204.0)	82	1.68	(42.5)	1.64	(41.7)
7.94	(201.5)	85	1.73	(44.0)	1.59	(40.4)
7.84	(199.0)	88	1.78	(45.0)	1.54	(39.1)
7.74	(196.5)	91	1.83	(46.5)	1.49	(37.8)
7.64	(194.0)	94	1.88	(48.0)	1.44	(36.6)
7.54	(191.5)	97	1.93	(49.0)	1.39	(35.3)
7.44	(189.0)	100	1.98	(50.5)	1.34	(34.0)
7.34	(186.5)	103	2.03	(51.5)	1.29	(32.8)
7.24	(184.0)	106	2.08	(53.0)	1.24	(31.5)
7.14	(181.5)	109	2.13	(54.0)	1.19	(30.2)
7.04	(179.0)	112	2.18	(55.5)	1.14	(29.0)
6.94	(176.5)	115	2.23	(56.5)	1.09	(27.7)
6.84	(173.5)	118	2.28	(58.0)	1.04	(26.4)
6.74	(171.0)	121	2.33	(59.0)	0.99	(25.1)
6.64	(168.5)	124	2.38	(60.5)	0.94	(23.9)
6.54	(166.0)	127	2.43	(61.5)	0.89	(22.6)
6.44	(163.5)	130	2.48	(63.0)	0.84	(21.3)

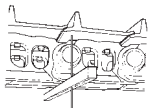
Flange diameter is 11.42" (290 mm)

Undercarriage Code: 195, 196

D10N, D10R — 10.25" (260.4 mm)

Track Links

9W5265 & 66
7T0715 & 16



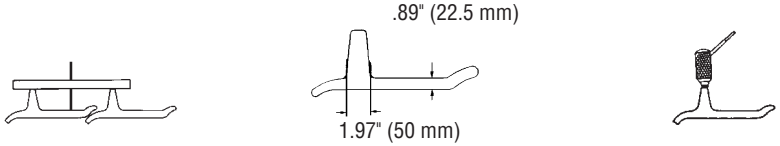
Depth Gauge Inches	Depth Gauge (mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	Ultrasonic (mm)
7.12	(181.0)	0	0	2.36	(59.9)
7.10	(180.5)	5	4	2.34	(59.4)
7.08	(180.0)	10	8	2.32	(58.9)
7.06	(179.5)	15	12	2.30	(58.4)
7.04	(179.0)	20	16	2.28	(57.9)
7.02	(178.5)	25	20	2.26	(57.4)
7.00	(178.0)	30	24	2.24	(56.9)
6.98	(177.5)	35	28	2.22	(56.4)
6.96	(177.0)	40	32	2.20	(55.9)
6.94	(176.5)	45	36	2.18	(55.4)
6.92	(176.0)	50	40	2.16	(54.9)
6.90	(175.5)	55	44	2.14	(54.4)
6.88	(175.0)	60	48	2.12	(53.8)
6.86	(174.0)	64	52	2.10	(53.3)
6.84	(173.5)	68	55	2.08	(52.8)
6.82	(173.0)	71	58	2.06	(52.3)
6.80	(172.5)	74	60	2.04	(51.8)
6.78	(172.0)	77	63	2.02	(51.3)
6.76	(171.5)	81	65	2.00	(50.8)
6.74	(171.0)	84	68	1.98	(50.3)
6.72	(170.5)	87	70	1.96	(49.8)
6.70	(170.0)	90	73	1.94	(49.3)
6.68	(169.5)	94	75	1.92	(48.8)
6.66	(169.0)	97	78	1.90	(48.3)
6.64	(168.5)	100	80	1.88	(47.8)
6.62	(168.0)	103	83	1.86	(47.2)
6.60	(167.5)	107	85	1.84	(46.7)
6.58	(167.0)	110	88	1.82	(46.2)
6.56	(166.5)	113	90	1.80	(45.7)
6.54	(166.0)	116	93	1.78	(45.2)
6.52	(165.5)	120	95	1.76	(44.7)
6.50	(165.0)		98	1.74	(44.2)
6.48	(164.5)		100	1.72	(43.7)
6.46	(164.0)		103	1.70	(43.2)
6.44	(163.5)		105	1.68	(42.7)
6.42	(163.0)		108	1.66	(42.2)
6.40	(162.5)		110	1.64	(41.7)
6.38	(162.0)		113	1.62	(41.1)
6.36	(161.5)		115	1.60	(40.6)
6.34	(161.0)		118	1.58	(40.1)
6.32	(160.5)		120	1.56	(39.6)

Undercarriage Code: 208, 209

D10 — 10.25" (260.4 mm)

Track Shoes

Extreme Service

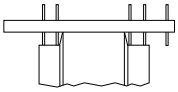


Depth Gauge Inches	Depth Gauge (mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	Ultrasonic (mm)
4.00	(101.5)	0	0	4.85	(123.2)
3.90	(99.0)	4	4	4.75	(120.7)
3.80	(96.5)	8	8	4.65	(118.1)
3.70	(94.0)	12	12	4.55	(115.6)
3.60	(91.5)	16	16	4.45	(113.0)
3.50	(89.0)	20	20	4.35	(110.5)
3.40	(86.5)	24	24	4.25	(108.0)
3.30	(84.0)	28	28	4.15	(105.4)
3.20	(81.5)	32	32	4.05	(102.9)
3.10	(78.5)	36	36	3.95	(100.3)
3.00	(76.0)	40	40	3.85	(97.8)
2.90	(73.5)	44	43	3.75	(95.3)
2.80	(71.0)	48	46	3.65	(92.7)
2.70	(68.5)	52	49	3.55	(90.2)
2.60	(66.0)	56	52	3.45	(87.6)
2.50	(63.5)	60	55	3.35	(85.1)
2.40	(61.0)	64	58	3.25	(82.6)
2.30	(58.5)	68	61	3.15	(80.0)
2.20	(56.0)	72	64	3.05	(77.5)
2.10	(53.5)	76	67	2.95	(74.9)
2.00	(51.0)	80	70	2.85	(72.4)
1.90	(48.5)	84	73	2.75	(69.9)
1.80	(45.5)	88	76	2.65	(67.3)
1.70	(43.0)	92	79	2.55	(64.8)
1.60	(40.5)	96	82	2.45	(62.2)
1.50	(38.0)	100	85	2.35	(59.7)
1.40	(35.5)	104	88	2.25	(57.2)
1.30	(33.0)	108	91	2.15	(54.6)
1.20	(30.5)	112	94	2.05	(52.1)
1.10	(28.0)	116	97	1.95	(49.5)
1.00	(25.5)	120	100	1.85	(47.0)
0.90	(23.0)		103	1.75	(44.5)
0.80	(20.5)		106	1.65	(41.9)
0.70	(18.0)		109	1.55	(39.4)
0.60	(15.0)		112	1.45	(36.8)
0.50	(12.5)		115	1.35	(34.3)
0.40	(10.0)		118	1.25	(31.8)
0.30	(7.5)		121	1.15	(29.2)

Undercarriage Code: 207

D11N, D11R — 12.50" (317.5 mm)

Idlers



Depth Gauge Inches	(mm)	% Worn
0.78	(20.0)	0
0.80	(20.5)	4
0.82	(21.0)	8
0.84	(21.5)	12
0.86	(22.0)	16
0.88	(22.5)	20
0.90	(23.0)	24
0.92	(23.5)	28
0.94	(24.0)	32
0.96	(24.5)	36
0.98	(25.0)	40
1.00	(25.5)	44
1.02	(26.0)	48
1.04	(26.5)	52
1.06	(27.0)	56
1.08	(27.5)	60
1.10	(28.0)	64
1.12	(28.5)	68
1.14	(29.0)	72
1.16	(29.5)	74
1.18	(30.0)	76
1.20	(30.5)	78
1.22	(31.0)	80
1.24	(31.5)	82
1.26	(32.0)	84
1.28	(32.5)	86
1.30	(33.0)	88
1.32	(33.5)	90
1.34	(34.0)	92
1.36	(34.5)	94
1.38	(35.0)	96
1.40	(35.5)	98
1.42	(36.0)	100
1.44	(36.5)	102
1.46	(37.0)	104
1.48	(37.5)	106
1.50	(38.0)	108
1.52	(38.5)	110
1.54	(39.0)	112
1.56	(39.5)	114
1.58	(40.0)	116
1.60	(40.5)	118
1.62	(41.0)	120

Flange width: 5.87" (149 mm)

Undercarriage Code: 220, 2203, 221, 2213

Computer CTS Codes (cont'd)

	Model	Undercarriage Code	Description
Track-Type Loaders	931	C301	6S8343-44 Links
	931	C302	6Y0935-36 Links - Small Stepped Bushings (50 mm)
	931	C3021	6Y0935-36 Links - Large Stepped Bushings (54 mm)
	933	C303	6Y0935-36 Links - Small Stepped Bushings (50 mm)
	933	C3031	6Y0935-36 Links - Large Stepped Bushings (54 mm)
	935	C305	6S8343-44 Links
	935	C306	6Y0935-36 Links - Small Stepped Bushings (50 mm)
	935	C3061	6Y0935-36 Links - Large Stepped Bushings (54 mm)
	939	C307	SALT - 6Y9261-2 Links - Rollers with Retainer
	939	C3071	SALT - 6Y9261-2 Links - Rollers with End Collars
	939	C3072	Rotating Bushing Track - 1080947-8 Links - Rollers with End Collars
	939	C3073	Rotating Bushing Track - 1080947-8 Links - Tall Flange Double Flange Rollers
	941	C311	5K Links
	941	C313	9K & 7K Links
	951	C330	6.75 inch (171.5 mm) Pitch
	951	C331	6.91 inch (175.5 mm) Pitch - 1P & 3P Links - Conventional Undercarriage
	951	C332	6.91 inch (175.5 mm) Pitch - 7T Links - Extended Life Undercarriage
	955	C350	6.91 inch (175.5 mm) Pitch
	955	C351	8.00 inch (203.2 mm) Pitch - 3P Links - Small Bushings
	955	C3511	8.00 inch (203.2 mm) Pitch - 3P Links - Large Bushings
	955	C353	8.00 inch (203.2 mm) Pitch - 7T Links - Extended Life Undercarriage
	977	C381	8.50 inch (215.9 mm) Pitch - 8S Links - Conventional Undercarriage
	977	C383	8.50 inch (215.9 mm) Pitch - 7T Links - Extended Life Undercarriage
	983	C390	All

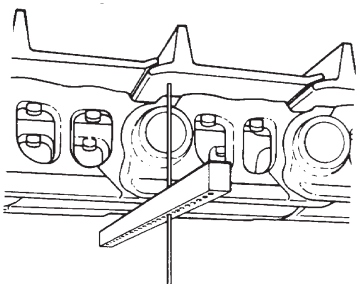
Variables That Affect Wear Life

See pages 11 through 25 for details on the effects of:

Components

Links

See pages 28 through 35 for detailed link information.

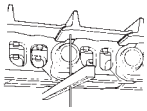


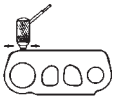
Measurement — Measure the track link over the centerline of the pin and bushing bores. See page 28 for details.

D3, 931, 933, 935, D4B, D4C — 6.125" (155.6 mm)

Track Links

6S3143 & 44





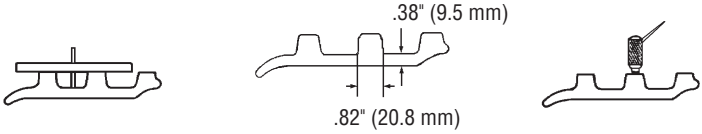
Depth Gauge			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
3.18	(81.0)	0	0.86	(21.8)
3.16	(80.5)	8	0.84	(21.3)
3.14	(80.0)	16	0.82	(20.8)
3.12	(79.0)	24	0.80	(20.3)
3.10	(78.5)	32	0.78	(19.8)
3.08	(78.0)	40	0.76	(19.3)
3.06	(77.5)	48	0.74	(18.8)
3.04	(77.0)	56	0.72	(18.3)
3.02	(76.5)	64	0.70	(17.8)
3.00	(76.0)	72	0.68	(17.3)
2.98	(75.5)	80	0.66	(16.8)
2.96	(75.0)	88	0.64	(16.3)
2.94	(74.5)	94	0.62	(15.7)
2.92	(74.0)	100	0.60	(15.2)
2.90	(73.5)	106	0.58	(14.7)
2.88	(73.0)	112	0.56	(14.2)
2.86	(72.5)	118	0.54	(13.7)
2.84	(72.0)	124	0.52	(13.2)

Undercarriage Code: 100

D3, 931, 933, 935, D4B, D4C — 6.125" (155.6 mm)

Track Shoes

Triple Grouser

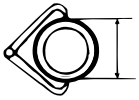


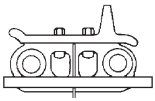
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
0.60	(15.0)	0	1.00	(25.4)
0.55	(14.0)	15	0.95	(24.1)
0.50	(12.5)	30	0.90	(22.9)
0.45	(11.5)	44	0.85	(21.6)
0.40	(10.0)	58	0.80	(20.3)
0.35	(9.0)	72	0.75	(19.1)
0.30	(7.5)	86	0.70	(17.8)
0.25	(6.5)	100	0.65	(16.5)
0.20	(5.0)	114	0.60	(15.2)
0.15	(4.0)	128	0.55	(14.0)

Undercarriage Code: 101, 102, 1021, 119, 1191, 301, 302, 3021, 303, 3031, 305, 306, 3061

D4, 941 — 6.75" (171.5 mm)

Bushings for Sealed & Lubricated Track



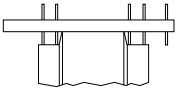


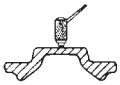
Caliper		Allowable Wear Lesser	Allowable Wear Greater	Ultrasonic		Depth Gauge	
Inches	(mm)	% Worn	% Worn	Inches	(mm)	Inches	(mm)
2.24	(56.9)	0	0	0.44	(11.2)	2.81	(71.4)
2.23	(56.6)	6	5	0.43	(10.9)	2.80	(71.1)
2.22	(56.4)	12	10	0.42	(10.7)	2.79	(70.9)
2.21	(56.1)	18	15	0.41	(10.4)	2.78	(70.6)
2.20	(55.9)	24	20	0.40	(10.2)	2.77	(70.4)
2.19	(55.6)	30	25	0.39	(9.9)	2.76	(70.1)
2.18	(55.4)	36	30	0.38	(9.7)	2.75	(69.9)
2.17	(55.1)	42	35	0.37	(9.4)	2.74	(69.6)
2.16	(54.9)	48	40	0.36	(9.1)	2.73	(69.3)
2.15	(54.6)	54	45	0.35	(8.9)	2.72	(69.1)
2.14	(54.4)	60	50	0.34	(8.6)	2.71	(68.8)
2.13	(54.1)	64	55	0.33	(8.4)	2.70	(68.6)
2.12	(53.8)	67	58	0.32	(8.1)	2.69	(68.3)
2.11	(53.6)	70	60	0.31	(7.9)	2.68	(68.1)
2.10	(53.3)	73	62	0.30	(7.6)	2.67	(67.8)
2.09	(53.1)	76	64	0.29	(7.4)	2.66	(67.6)
2.08	(52.8)	79	66	0.28	(7.1)	2.65	(67.3)
2.07	(52.6)	82	68	0.27	(6.9)	2.64	(67.1)
2.06	(52.3)	85	70	0.26	(6.6)	2.63	(66.8)
2.05	(52.1)	88	72	0.25	(6.4)	2.62	(66.5)
2.04	(51.8)	91	74	0.24	(6.1)	2.61	(66.3)
2.03	(51.6)	94	76	0.23	(5.8)	2.60	(66.0)
2.02	(51.3)	97	78	0.22	(5.6)	2.59	(65.8)
2.01	(51.1)	100	80	0.21	(5.3)	2.58	(65.5)
2.00	(50.8)	103	82	0.20	(5.1)	2.57	(65.3)
1.99	(50.5)	106	84	0.19	(4.8)	2.56	(65.0)
1.98	(50.3)	109	86	0.18	(4.6)	2.55	(64.8)
1.97	(50.0)	112	88	0.17	(4.3)	2.54	(64.5)
1.96	(49.8)	115	90	0.16	(4.1)	2.53	(64.3)
1.95	(49.5)	118	92	0.15	(3.8)	2.52	(64.0)
1.94	(49.3)	121	94	0.14	(3.6)	2.51	(63.8)
1.93	(49.0)		96	0.13	(3.3)	2.50	(63.5)
1.92	(48.8)		98	0.12	(3.0)	2.49	(63.2)
1.91	(48.5)		100	0.11	(2.8)	2.48	(63.0)
1.90	(48.3)		102	0.10	(2.5)	2.47	(62.7)
1.89	(48.0)		104	0.09	(2.3)	2.46	(62.5)
1.88	(47.8)		106	0.08	(2.0)	2.45	(62.2)
1.87	(47.5)		108	0.07	(1.8)	2.44	(62.0)
1.86	(47.2)		110	0.06	(1.5)	2.43	(61.7)
1.85	(47.0)		112	0.05	(1.3)	2.42	(61.5)
1.84	(46.7)		114	0.04	(1.0)	2.41	(61.2)
1.83	(46.5)		116	0.03	(0.8)	2.40	(61.0)
1.82	(46.2)		118	0.02	(0.5)	2.39	(60.7)
1.81	(46.0)		120	0.01	(0.3)	2.38	(60.5)

Undercarriage Code: 118, 313

D4, 941 — 6.75" (171.5 mm)

Idlers





Depth Gauge Inches	(mm)	% Worn
0.66	(17.0)	0
0.68	(17.5)	12
0.70	(18.0)	24
0.72	(18.5)	36
0.74	(19.0)	48
0.76	(19.5)	60
0.78	(20.0)	72
0.80	(20.5)	82
0.82	(21.0)	85
0.84	(21.5)	88
0.86	(22.0)	91
0.88	(22.5)	94
0.90	(23.0)	97
0.92	(23.5)	100
0.94	(24.0)	103
0.96	(24.5)	106
0.98	(25.0)	109
1.00	(25.5)	112
1.02	(26.0)	115
1.04	(26.5)	118
1.06	(27.0)	121

Flange width: 2.69" (68.3 mm)

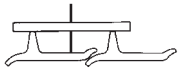
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.28	(7.1)	0.00	(0.0)
0.26	(6.6)	0.02	(0.5)
0.24	(6.1)	0.04	(1.0)
0.22	(5.6)	0.06	(1.5)
0.20	(5.1)	0.08	(2.0)
0.18	(4.6)	0.10	(2.5)
0.16	(4.1)	0.12	(3.0)
0.14	(3.6)	0.14	(3.5)
0.12	(3.0)	0.16	(4.0)
0.10	(2.5)	0.18	(4.5)
0.08	(2.0)	0.20	(5.0)
0.06	(1.5)	0.22	(5.5)
0.04	(1.0)	0.24	(6.0)
0.02	(0.5)	0.26	(6.5)
0.00	(0.0)	0.28	(7.0)

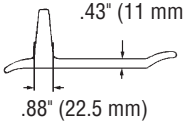
NOTE: Ultrasonic measurement is to determine flange wear only.

Undercarriage Code: 116, 118, 311, 313

Track Shoes

Moderate Service





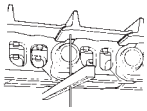
Depth Gauge Inches	(mm)	% Worn	Ultrasonic Inches	(mm)
1.85	(47.0)	0	2.30	(58.4)
1.80	(45.5)	5	2.25	(57.2)
1.75	(44.5)	10	2.20	(55.9)
1.70	(43.0)	15	2.15	(54.6)
1.65	(42.0)	20	2.10	(53.3)
1.60	(40.5)	25	2.05	(52.1)
1.55	(39.5)	30	2.00	(50.8)
1.50	(38.0)	35	1.95	(49.5)
1.45	(37.0)	40	1.90	(48.3)
1.40	(35.5)	45	1.85	(47.0)
1.35	(34.5)	50	1.80	(45.7)
1.30	(33.0)	55	1.75	(44.5)
1.25	(32.0)	60	1.70	(43.2)
1.20	(30.5)	64	1.65	(41.9)
1.15	(29.0)	68	1.60	(40.6)
1.10	(28.0)	72	1.55	(39.4)
1.05	(26.5)	76	1.50	(38.1)
1.00	(25.5)	80	1.45	(36.8)
0.95	(24.0)	84	1.40	(35.6)
0.90	(23.0)	88	1.35	(34.3)
0.85	(21.5)	92	1.30	(33.0)
0.80	(20.5)	96	1.25	(31.8)
0.75	(19.0)	100	1.20	(30.5)
0.70	(18.0)	104	1.15	(29.2)
0.65	(16.5)	108	1.10	(27.9)
0.60	(15.0)	112	1.05	(26.7)
0.55	(14.0)	116	1.00	(25.4)
0.50	(12.5)	120	0.95	(24.1)

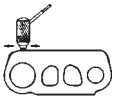
Undercarriage Code: 134, 13402, 135, 13502, 1351, 1352, 1353, 13532, 1354, 1355, 307, 3071, 3072, 3073

D5, 955, 951, 561 — 6.91" (175.5 mm)

Track Links

7T4539 & 40





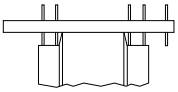
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
4.29	(109.0)	0	1.45	(36.8)
4.27	(108.5)	5	1.43	(36.3)
4.25	(108.0)	10	1.41	(35.8)
4.23	(107.5)	15	1.39	(35.3)
4.21	(107.0)	20	1.37	(34.8)
4.19	(106.5)	25	1.35	(34.3)
4.17	(106.0)	30	1.33	(33.8)
4.15	(105.5)	35	1.31	(33.3)
4.13	(105.0)	40	1.29	(32.8)
4.11	(104.5)	45	1.27	(32.3)
4.09	(104.0)	50	1.25	(31.8)
4.07	(103.5)	55	1.23	(31.2)
4.05	(103.0)	60	1.21	(30.7)
4.03	(102.5)	65	1.19	(30.2)
4.01	(102.0)	70	1.17	(29.7)
3.99	(101.5)	75	1.15	(29.2)
3.97	(101.0)	80	1.13	(28.7)
3.95	(100.5)	84	1.11	(28.2)
3.93	(100.0)	88	1.09	(27.7)
3.91	(99.5)	92	1.07	(27.2)
3.89	(99.0)	96	1.05	(26.7)
3.87	(98.5)	100	1.03	(26.2)
3.85	(98.0)	104	1.01	(25.7)
3.83	(97.5)	108	0.99	(25.1)
3.81	(97.0)	112	0.97	(24.6)
3.79	(96.5)	116	0.95	(24.1)
3.77	(96.0)	120	0.93	(23.6)

Undercarriage Code: 105, 131, 332

D5, 955, 951, 561 — 6.91" (175.5 mm)

Idlers

(Has no side plate indentations)



Depth Gauge Inches	(mm)	% Worn
0.78	(20.0)	0
0.80	(20.5)	12
0.82	(21.0)	24
0.84	(21.5)	36
0.86	(22.0)	48
0.88	(22.5)	60
0.90	(23.0)	72
0.92	(23.5)	82
0.94	(24.0)	85
0.96	(24.5)	88
0.98	(25.0)	91
1.00	(25.5)	94
1.02	(26.0)	97
1.04	(26.5)	100
1.06	(27.0)	103
1.08	(27.5)	106
1.10	(28.0)	109
1.12	(28.5)	112
1.14	(29.0)	115
1.16	(29.5)	118
1.18	(30.0)	121

Flange width: 3.31" (34 mm)

Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.36	(9.1)	0.00	(0.0)
0.34	(8.6)	0.02	(0.5)
0.32	(8.1)	0.04	(1.0)
0.30	(7.6)	0.06	(1.5)
0.28	(7.1)	0.08	(2.0)
0.26	(6.6)	0.10	(2.5)
0.24	(6.1)	0.12	(3.0)
0.22	(5.6)	0.14	(3.5)
0.20	(5.1)	0.16	(4.0)
0.18	(4.6)	0.18	(4.5)
0.16	(4.1)	0.20	(5.0)
0.14	(3.6)	0.22	(5.5)
0.12	(3.0)	0.24	(6.0)
0.10	(2.5)	0.26	(6.5)
0.08	(2.0)	0.28	(7.0)
0.06	(1.5)	0.30	(7.5)
0.04	(1.0)	0.32	(8.0)
0.02	(0.5)	0.34	(8.5)

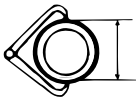
NOTE: Ultrasonic measurement is to determine flange wear only.

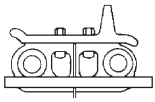
Undercarriage Code: 104, 130, 331, 350

D6, 955 — 8.00" (203.2 mm)

Bushings for Rotating Bushing Track

Use with 8E Links





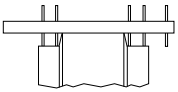
Caliper			Ultrasonic		Depth Gauge	
Inches	(mm)	% Worn	Inches	(mm)	Inches	(mm)
2.86	(72.6)	0	0.55	(14.0)	3.56	(90.4)
2.84	(72.1)	4	0.54	(13.7)	3.55	(90.2)
2.82	(71.6)	8	0.53	(13.5)	3.54	(89.9)
2.80	(71.1)	12	0.52	(13.2)	3.53	(89.7)
2.78	(70.6)	16	0.51	(13.0)	3.52	(89.4)
2.76	(70.1)	20	0.50	(12.7)	3.51	(89.2)
2.74	(69.6)	24	0.49	(12.4)	3.50	(88.9)
2.72	(69.1)	28	0.48	(12.2)	3.49	(88.6)
2.70	(68.6)	32	0.47	(11.9)	3.48	(88.4)
2.68	(68.1)	36	0.46	(11.7)	3.47	(88.1)
2.66	(67.6)	38	0.45	(11.4)	3.46	(87.9)
2.64	(67.1)	40	0.44	(11.2)	3.45	(87.6)
2.62	(66.5)	42	0.43	(10.9)	3.44	(87.4)
2.60	(66.0)	44	0.42	(10.7)	3.43	(87.1)
2.58	(65.5)	46	0.41	(10.4)	3.42	(86.9)
2.56	(65.0)	48	0.40	(10.2)	3.41	(86.6)
2.54	(64.5)	50	0.39	(9.9)	3.40	(86.4)
2.52	(64.0)	52	0.38	(9.7)	3.39	(86.1)
2.50	(63.5)	54	0.37	(9.4)	3.38	(85.9)
2.48	(63.0)	56	0.36	(9.1)	3.37	(85.6)
2.46	(62.5)	58	0.35	(8.9)	3.36	(85.3)
2.44	(62.0)	60	0.34	(8.6)	3.35	(85.1)
2.42	(61.5)	62	0.33	(8.4)	3.34	(84.8)
2.40	(61.0)	64	0.32	(8.1)	3.33	(84.6)
2.38	(60.5)	66	0.31	(7.9)	3.32	(84.3)
2.36	(59.9)	68	0.30	(7.6)	3.31	(84.1)
2.34	(59.4)	70	0.29	(7.4)	3.30	(83.8)
2.32	(58.9)	72	0.28	(7.1)	3.29	(83.6)
2.30	(58.4)	74	0.27	(6.9)	3.28	(83.3)
2.28	(57.9)	76	0.26	(6.6)	3.27	(83.1)
2.26	(57.4)	78	0.25	(6.3)	3.26	(82.8)
2.24	(56.9)	80	0.24	(6.1)	3.25	(82.6)
2.22	(56.4)	82	0.23	(5.8)	3.24	(82.3)
2.20	(55.9)	84	0.22	(5.6)	3.23	(82.0)
2.18	(55.4)	86	0.21	(5.3)	3.22	(81.8)
2.16	(54.9)	88	0.20	(5.1)	3.21	(81.5)
2.14	(54.4)	90	0.19	(4.8)	3.20	(81.3)
2.12	(53.8)	92	0.18	(4.6)	3.19	(81.0)
2.10	(53.3)	94	0.17	(4.3)	3.18	(80.8)
2.08	(52.8)	96	0.16	(4.1)	3.17	(80.5)
2.06	(52.3)	98	0.15	(3.8)	3.16	(80.3)
2.04	(51.8)	100	0.14	(3.6)	3.15	(80.0)
2.02	(51.3)	102	0.13	(3.3)	3.14	(79.8)
2.00	(50.8)	104	0.12	(3.0)	3.13	(79.5)
1.98	(50.3)	106	0.11	(2.8)	3.12	(79.2)
1.96	(49.8)	108	0.10	(2.5)	3.11	(79.0)
1.94	(49.3)	110	0.09	(2.3)	3.10	(78.7)
1.92	(48.8)	112	0.08	(2.0)	3.09	(78.5)
1.90	(48.3)	114	0.07	(1.8)	3.08	(78.2)
1.88	(47.8)	116	0.06	(1.5)	3.07	(78.0)
1.86	(47.2)	118	0.05	(1.3)	3.06	(77.7)
1.84	(46.7)	120	0.04	(1.0)	3.05	(77.5)

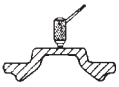
Undercarriage Code: 1551

D6, 955 — 8.00" (203.2 mm)

Idlers

Extended Life Idlers
(Has circular side plate indentations)





Depth Gauge Inches	(mm)	% Worn
0.78	(20.0)	0
0.80	(20.5)	6
0.82	(21.0)	12
0.84	(21.5)	18
0.86	(22.0)	24
0.88	(22.5)	30
0.90	(23.0)	36
0.92	(23.5)	42
0.94	(24.0)	48
0.96	(24.5)	54
0.98	(25.0)	60
1.00	(25.5)	66
1.02	(26.0)	72
1.04	(26.5)	76
1.06	(27.0)	78
1.08	(27.5)	80
1.10	(28.0)	82
1.12	(28.5)	84
1.14	(29.0)	86
1.16	(29.5)	88
1.18	(30.0)	90
1.20	(30.5)	92
1.22	(31.0)	94
1.24	(31.5)	96
1.26	(32.0)	98
1.28	(32.5)	100
1.30	(33.0)	102
1.32	(33.5)	104
1.34	(34.0)	106
1.36	(34.5)	108
1.38	(35.0)	110
1.40	(35.5)	112
1.42	(36.0)	114
1.44	(36.5)	116
1.46	(37.0)	118
1.48	(37.5)	120

Flange width: 3.74" (95 mm)

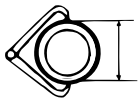
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.49	(12.4)	0.00	(0.0)
0.47	(11.9)	0.02	(0.5)
0.45	(11.4)	0.04	(1.0)
0.43	(10.9)	0.06	(1.5)
0.41	(10.4)	0.08	(2.0)
0.39	(9.9)	0.10	(2.5)
0.37	(9.4)	0.12	(3.0)
0.35	(8.9)	0.14	(3.5)
0.33	(8.4)	0.16	(4.0)
0.31	(7.9)	0.18	(4.5)
0.29	(7.4)	0.20	(5.0)
0.27	(6.9)	0.22	(5.5)
0.25	(6.3)	0.24	(6.0)
0.23	(5.8)	0.26	(6.5)
0.21	(5.3)	0.28	(7.0)
0.19	(4.8)	0.30	(7.5)
0.17	(4.3)	0.32	(8.0)
0.15	(3.8)	0.34	(8.5)
0.13	(3.3)	0.36	(9.0)
0.11	(2.8)	0.38	(9.5)
0.09	(2.3)	0.40	(10.0)
0.07	(1.8)	0.42	(10.5)
0.05	(1.3)	0.44	(11.0)
0.03	(0.8)	0.46	(11.5)
0.01	(0.3)	0.48	(12.0)

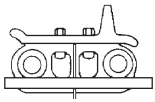
NOTE: Ultrasonic measurement is to determine flange wear only.

D7, 977, 571, 572 — 8.50" (215.9 mm)

Bushings for Sealed & Lubricated Track

Extended Life Bushings
Use with current 7T Links





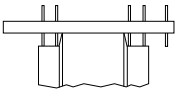
Caliper		Allowable Wear Lesser	Allowable Wear Greater	Ultrasonic		Depth Gauge	
Inches	(mm)	% Worn	% Worn	Inches	(mm)	Inches	(mm)
3.04	(77.2)	0	0	0.56	(14.2)	3.69	(93.7)
3.03	(77.0)	6	5	0.55	(14.0)	3.68	(93.5)
3.02	(76.7)	12	10	0.54	(13.7)	3.67	(93.2)
3.01	(76.5)	18	15	0.53	(13.5)	3.66	(93.0)
3.00	(76.2)	24	20	0.52	(13.2)	3.65	(92.7)
2.99	(75.9)	30	25	0.51	(13.0)	3.64	(92.5)
2.98	(75.7)	36	30	0.50	(12.7)	3.63	(92.2)
2.97	(75.4)	42	35	0.49	(12.4)	3.62	(91.9)
2.96	(75.2)	48	40	0.48	(12.2)	3.61	(91.7)
2.95	(74.9)	54	45	0.47	(11.9)	3.60	(91.4)
2.94	(74.7)	58	50	0.46	(11.7)	3.59	(91.2)
2.93	(74.4)	61	54	0.45	(11.4)	3.58	(90.9)
2.92	(74.2)	64	56	0.44	(11.2)	3.57	(90.7)
2.91	(73.9)	67	58	0.43	(10.9)	3.56	(90.4)
2.90	(73.7)	70	60	0.42	(10.7)	3.55	(90.2)
2.89	(73.4)	73	62	0.41	(10.4)	3.54	(89.9)
2.88	(73.2)	76	64	0.40	(10.2)	3.53	(89.7)
2.87	(72.9)	79	66	0.39	(9.9)	3.52	(89.4)
2.86	(72.6)	82	68	0.38	(9.7)	3.51	(89.2)
2.85	(72.4)	85	70	0.37	(9.4)	3.50	(88.9)
2.84	(72.1)	88	72	0.36	(9.1)	3.49	(88.6)
2.83	(71.9)	91	74	0.35	(8.9)	3.48	(88.4)
2.82	(71.6)	94	76	0.34	(8.6)	3.47	(88.1)
2.81	(71.4)	97	78	0.33	(8.4)	3.46	(87.9)
2.80	(71.1)	100	80	0.32	(8.1)	3.45	(87.6)
2.79	(70.9)	103	82	0.31	(7.9)	3.44	(87.4)
2.78	(70.6)	106	84	0.30	(7.6)	3.43	(87.1)
2.77	(70.4)	109	86	0.29	(7.4)	3.42	(86.9)
2.76	(70.1)	112	88	0.28	(7.1)	3.41	(86.6)
2.75	(69.9)	115	90	0.27	(6.9)	3.40	(86.4)
2.74	(69.6)	118	92	0.26	(6.6)	3.39	(86.1)
2.73	(69.3)	121	94	0.25	(6.3)	3.38	(85.9)
2.72	(69.1)		96	0.24	(6.1)	3.37	(85.6)
2.71	(68.8)		98	0.23	(5.8)	3.36	(85.3)
2.70	(68.6)		100	0.22	(5.6)	3.35	(85.1)
2.69	(68.3)		102	0.21	(5.3)	3.34	(84.8)
2.68	(68.1)		104	0.20	(5.1)	3.33	(84.6)
2.67	(67.8)		106	0.19	(4.8)	3.32	(84.3)
2.66	(67.6)		108	0.18	(4.6)	3.31	(84.1)
2.65	(67.3)		110	0.17	(4.3)	3.30	(83.8)
2.64	(67.1)		112	0.16	(4.1)	3.29	(83.6)
2.63	(66.8)		114	0.15	(3.8)	3.28	(83.3)
2.62	(66.5)		116	0.14	(3.6)	3.27	(83.1)
2.61	(66.3)		118	0.13	(3.3)	3.26	(82.8)
2.60	(66.0)		120	0.12	(3.0)	3.25	(82.6)

Undercarriage Code: 165, 383

D7, 977, 571, 572 — 8.50" (215.9 mm)

Idlers

Extended Life Idlers
(Has circular side plate indentations)



Depth Gauge Inches	(mm)	% Worn
0.78	(20.0)	0
0.80	(20.5)	6
0.82	(21.0)	12
0.84	(21.5)	18
0.86	(22.0)	24
0.88	(22.5)	30
0.90	(23.0)	36
0.92	(23.5)	42
0.94	(24.0)	48
0.96	(24.5)	54
0.98	(25.0)	60
1.00	(25.5)	66
1.02	(26.0)	72
1.04	(26.5)	76
1.06	(27.0)	78
1.08	(27.5)	80
1.10	(28.0)	82
1.12	(28.5)	84
1.14	(29.0)	86
1.16	(29.5)	88
1.18	(30.0)	90
1.20	(30.5)	92
1.22	(31.0)	94
1.24	(31.5)	96
1.26	(32.0)	98
1.28	(32.5)	100
1.30	(33.0)	102
1.32	(33.5)	104
1.34	(34.0)	106
1.36	(34.5)	108
1.38	(35.0)	110
1.40	(35.5)	112
1.42	(36.0)	114
1.44	(36.5)	116
1.46	(37.0)	118
1.48	(37.5)	120

Flange width: 4.02" (102 mm)

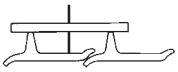
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.48	(12.2)	0.00	(0.0)
0.46	(11.7)	0.02	(0.5)
0.44	(11.2)	0.04	(1.0)
0.42	(10.7)	0.06	(1.5)
0.40	(10.2)	0.08	(2.0)
0.38	(9.7)	0.10	(2.5)
0.36	(9.1)	0.12	(3.0)
0.34	(8.6)	0.14	(3.5)
0.32	(8.1)	0.16	(4.0)
0.30	(7.6)	0.18	(4.5)
0.28	(7.1)	0.20	(5.0)
0.26	(6.6)	0.22	(5.5)
0.24	(6.1)	0.24	(6.0)
0.22	(5.6)	0.26	(6.5)
0.20	(5.1)	0.28	(7.0)
0.18	(4.6)	0.30	(7.5)
0.16	(4.1)	0.32	(8.0)
0.14	(3.6)	0.34	(8.5)
0.12	(3.0)	0.36	(9.0)
0.10	(2.5)	0.38	(9.5)
0.08	(2.0)	0.40	(10.0)
0.06	(1.5)	0.42	(10.5)
0.04	(1.0)	0.44	(11.0)
0.02	(0.5)	0.46	(11.5)

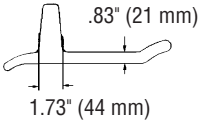
NOTE: Ultrasonic measurement is to determine flange wear only.

D8, 983 — 9.00" (228.6 mm)

Track Shoes

Super Extreme Service



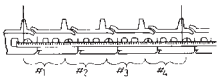


Depth Gauge Inches	Depth Gauge (mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	Ultrasonic (mm)
3.70	(94.0)	0	0	4.50	(114.3)
3.60	(91.5)	5	4	4.40	(111.8)
3.50	(89.0)	10	8	4.30	(109.2)
3.40	(86.5)	15	12	4.20	(106.7)
3.30	(84.0)	20	16	4.10	(104.1)
3.20	(81.5)	25	20	4.00	(101.6)
3.10	(78.5)	30	24	3.90	(99.1)
3.00	(76.0)	35	28	3.80	(96.5)
2.90	(73.5)	40	32	3.70	(94.0)
2.80	(71.0)	45	36	3.60	(91.4)
2.70	(68.5)	50	40	3.50	(88.9)
2.60	(66.0)	55	44	3.40	(86.4)
2.50	(63.5)	60	48	3.30	(83.8)
2.40	(61.0)	64	52	3.20	(81.3)
2.30	(58.5)	68	56	3.10	(78.7)
2.20	(56.0)	72	60	3.00	(76.2)
2.10	(53.5)	76	64	2.90	(73.7)
2.00	(51.0)	80	68	2.80	(71.1)
1.90	(48.5)	84	72	2.70	(68.6)
1.80	(45.5)	88	76	2.60	(66.0)
1.70	(43.0)	92	79	2.50	(63.5)
1.60	(40.5)	96	82	2.40	(61.0)
1.50	(38.0)	100	85	2.30	(58.4)
1.40	(35.5)	104	88	2.20	(55.9)
1.30	(33.0)	108	91	2.10	(53.3)
1.20	(30.5)	112	94	2.00	(50.8)
1.10	(28.0)	116	97	1.90	(48.3)
1.00	(25.5)	120	100	1.80	(45.7)
0.90	(23.0)		103	1.70	(43.2)
0.80	(20.5)		106	1.60	(40.6)
0.70	(18.0)		109	1.50	(38.1)
0.60	(15.0)		112	1.40	(35.6)
0.50	(12.5)		115	1.30	(33.0)
0.40	(10.0)		118	1.20	(30.5)
0.30	(7.5)		121	1.10	(27.9)

Undercarriage Code: 175, 390

Pins and Bushings for Sealed Track

Internal Wear

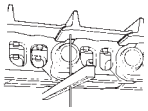


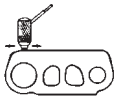
Inches	(mm)	% Worn
41.05	(1042.5)	0
41.10	(1044.0)	10
41.15	(1045.0)	20
41.20	(1046.5)	30
41.25	(1048.0)	40
41.30	(1049.0)	50
41.35	(1050.5)	60
41.40	(1051.5)	70
41.45	(1053.0)	80
41.50	(1054.0)	90
41.55	(1055.5)	100
41.60	(1056.5)	105
41.65	(1058.0)	110
41.70	(1059.0)	115
41.75	(1060.5)	120

D5B — 6.91" (175.5 mm)

Track Links

175-8248 & 49



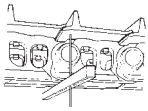


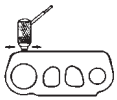
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
4.06	(103.0)	0	1.22	(31.0)
4.04	(102.5)	6	1.20	(30.5)
4.02	(102.0)	12	1.18	(30.0)
4.00	(101.5)	18	1.16	(29.5)
3.98	(101.0)	24	1.14	(29.0)
3.96	(100.5)	30	1.12	(28.4)
3.94	(100.0)	36	1.10	(27.9)
3.92	(99.5)	42	1.08	(27.4)
3.90	(99.0)	48	1.06	(26.9)
3.88	(98.5)	54	1.04	(26.4)
3.86	(98.0)	60	1.02	(25.9)
3.84	(97.5)	66	1.00	(25.4)
3.82	(97.0)	72	0.98	(24.9)
3.80	(96.5)	76	0.96	(24.4)
3.78	(96.0)	80	0.94	(23.9)
3.76	(95.5)	84	0.92	(23.4)
3.74	(95.0)	88	0.90	(22.9)
3.72	(94.5)	92	0.88	(22.4)
3.70	(94.0)	96	0.86	(21.8)
3.68	(93.5)	100	0.84	(21.3)
3.66	(93.0)	104	0.82	(20.8)
3.64	(92.5)	108	0.80	(20.3)
3.62	(92.0)	112	0.78	(19.8)
3.60	(91.5)	116	0.76	(19.3)
3.58	(91.0)	120	0.74	(18.8)

Undercarriage Code: 1315

Track Links

175-8256 & 57





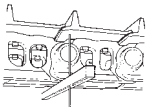
Depth Gauge			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
5.03	(128.0)	0	1.67	(42.4)
5.01	(127.5)	4	1.65	(41.9)
4.99	(126.5)	8	1.63	(41.4)
4.97	(126.0)	12	1.61	(40.9)
4.95	(125.5)	16	1.59	(40.4)
4.93	(125.0)	20	1.57	(39.9)
4.91	(124.5)	24	1.55	(39.4)
4.89	(124.0)	28	1.53	(38.9)
4.87	(123.5)	32	1.51	(38.4)
4.85	(123.0)	36	1.49	(37.8)
4.83	(122.5)	40	1.47	(37.3)
4.81	(122.0)	44	1.45	(36.8)
4.79	(121.5)	48	1.43	(36.3)
4.77	(121.0)	52	1.41	(35.8)
4.75	(120.5)	56	1.39	(35.3)
4.73	(120.0)	60	1.37	(34.8)
4.71	(119.5)	64	1.35	(34.3)
4.69	(119.0)	68	1.33	(33.8)
4.67	(118.5)	72	1.31	(33.3)
4.65	(118.0)	76	1.29	(32.8)
4.63	(117.5)	80	1.27	(32.3)
4.61	(117.0)	84	1.25	(31.8)
4.59	(116.5)	88	1.23	(31.2)
4.57	(116.0)	92	1.21	(30.7)
4.55	(115.5)	96	1.19	(30.2)
4.53	(115.0)	100	1.17	(29.7)
4.51	(114.5)	103	1.15	(29.2)
4.49	(114.0)	106	1.13	(28.7)
4.47	(113.5)	109	1.11	(28.2)
4.45	(113.0)	112	1.09	(27.7)
4.43	(112.5)	115	1.07	(27.2)
4.41	(112.0)	118	1.05	(26.7)
4.39	(111.5)	121	1.03	(26.2)

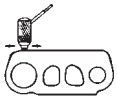
Undercarriage Code: 1545

D7 — 8.50" (215.9 mm)

Track Links

188-5251 & 52



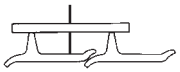


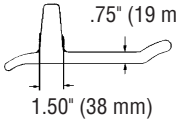
Depth Gauge			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
4.94	(125.5)	0	1.35	(34.3)
4.92	(125.0)	5	1.33	(33.8)
4.90	(124.5)	10	1.31	(33.3)
4.88	(124.0)	15	1.29	(32.8)
4.86	(123.5)	20	1.27	(32.3)
4.84	(123.0)	25	1.25	(31.8)
4.82	(122.5)	30	1.23	(31.2)
4.80	(122.0)	35	1.21	(30.7)
4.78	(121.5)	40	1.19	(30.2)
4.76	(121.0)	44	1.17	(29.7)
4.74	(120.5)	48	1.15	(29.2)
4.72	(120.0)	52	1.13	(28.7)
4.70	(119.5)	56	1.11	(28.2)
4.68	(119.0)	60	1.09	(27.7)
4.66	(118.5)	64	1.07	(27.2)
4.64	(118.0)	68	1.05	(26.7)
4.62	(117.5)	72	1.03	(26.2)
4.60	(117.0)	76	1.01	(25.7)
4.58	(116.5)	80	0.99	(25.1)
4.56	(116.0)	84	0.97	(24.6)
4.54	(115.5)	88	0.95	(24.1)
4.52	(115.0)	92	0.93	(23.6)
4.50	(114.5)	96	0.91	(23.1)
4.48	(114.0)	100	0.89	(22.6)
4.46	(113.5)	104	0.87	(22.1)
4.44	(113.0)	108	0.85	(21.6)
4.42	(112.5)	112	0.83	(21.1)
4.40	(112.0)	116	0.81	(20.6)
4.38	(111.5)	120	0.79	(20.1)

Undercarriage Code: 1655

Track Shoes

Extreme Service





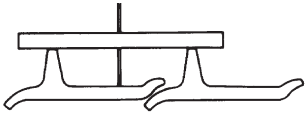
Depth Gauge Inches	Depth Gauge (mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	Ultrasonic (mm)
3.10	(78.5)	0	0	3.80	(96.5)
3.00	(76.0)	7	5	3.70	(94.0)
2.90	(73.5)	14	10	3.60	(91.4)
2.80	(71.0)	21	15	3.50	(88.9)
2.70	(68.5)	28	20	3.40	(86.4)
2.60	(66.0)	35	25	3.30	(83.8)
2.50	(63.5)	42	30	3.20	(81.3)
2.40	(61.0)	49	35	3.10	(78.7)
2.30	(58.5)	56	40	3.00	(76.2)
2.20	(56.0)	63	45	2.90	(73.7)
2.10	(53.5)	70	50	2.80	(71.1)
2.00	(51.0)	77	55	2.70	(68.6)
1.90	(48.5)	84	60	2.60	(66.0)
1.80	(45.5)	91	65	2.50	(63.5)
1.70	(43.0)	94	70	2.40	(61.0)
1.60	(40.5)	97	75	2.30	(58.4)
1.50	(38.0)	100	80	2.20	(55.9)
1.40	(35.5)	103	84	2.10	(53.3)
1.30	(33.0)	106	88	2.00	(50.8)
1.20	(30.5)	109	92	1.90	(48.3)
1.10	(28.0)	112	96	1.80	(45.7)
1.00	(25.5)	115	100	1.70	(43.2)
0.90	(23.0)	118	104	1.60	(40.6)
0.80	(20.5)	121	108	1.50	(38.1)
0.70	(18.0)		112	1.40	(35.6)
0.60	(15.0)		116	1.30	(33.0)
0.50	(12.5)		120	1.20	(30.5)

Undercarriage Code: 1755

COMPONENTS

Shoes

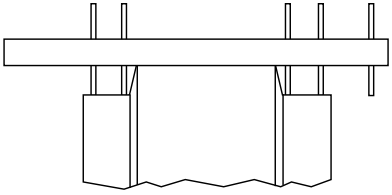
See pages 51 through 55 for detailed shoe information.



Measurement — Use the depth gauge or the Ultrasonic Wear Indicator to measure shoes.

Idlers

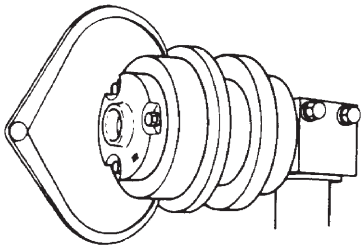
See pages 56 through 58 for detailed idler information.



Measurement — Use the depth gauge and the Ultrasonic Wear Indicator to measure idlers.

Carrier Rollers

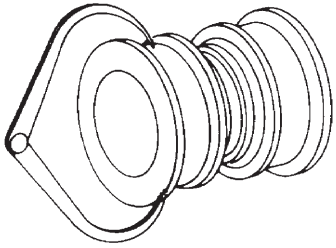
See pages 59 through 60 for detailed carrier roller information.

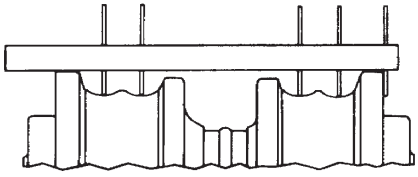


Measurement — Use the caliper or the Ultrasonic Wear Indicator to measure carrier rollers.

Track Rollers

See pages 61 through 65 for detailed track roller information. The following points are specifically for hydrostatic loaders.





Measurement — Track rollers can be measured with either a depth gauge, a caliper or the Ultrasonic Wear Indicator.

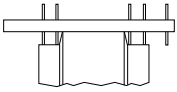
Shoe & Master Link Bolt Torques

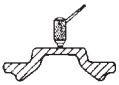
Model	Bolt Size	Torque*	Additional Turn Regular Shoe	Additional Turn Master Link Master Shoe
943 953	5/8"	120 ± 30 ft. lb. 170 ± 40 Nm	+1/3 turn	+1/2 turn
963 973	3/4"	220 ± 40 ft. lb. 300 ± 50 Nm	+1/3 turn	+1/2 turn
973	7/8"	250 ± 50 ft. lb. 340 ± 70 Nm	+1/3 turn	+1/2 turn

*Use the assembly and torque turn tightening procedures on pages 33 and 55.

943 — 6.75" (171.5 mm)

Idlers





Depth Gauge Inches	(mm)	% Worn
0.66	(17.0)	0
0.68	(17.5)	8
0.70	(18.0)	16
0.72	(18.5)	24
0.74	(19.0)	32
0.76	(19.5)	40
0.78	(20.0)	48
0.80	(20.5)	56
0.82	(21.0)	64
0.84	(21.5)	72
0.86	(22.0)	76
0.88	(22.5)	79
0.90	(23.0)	82
0.92	(23.5)	85
0.94	(24.0)	88
0.96	(24.5)	91
0.98	(25.0)	94
1.00	(25.5)	97
1.02	(26.0)	100
1.04	(26.5)	103
1.06	(27.0)	106
1.08	(27.5)	109
1.10	(28.0)	112
1.12	(28.5)	115
1.14	(29.0)	118
1.16	(29.5)	121

Flange width: 2.70" (68.5 mm)

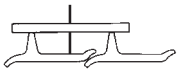
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.36	(9.1)	0.00	(0.0)
0.34	(8.6)	0.02	(0.5)
0.32	(8.1)	0.04	(1.0)
0.30	(7.6)	0.06	(1.5)
0.28	(7.1)	0.08	(2.0)
0.26	(6.6)	0.10	(2.5)
0.24	(6.1)	0.12	(3.0)
0.22	(5.6)	0.14	(3.5)
0.20	(5.1)	0.16	(4.0)
0.18	(4.6)	0.18	(4.5)
0.16	(4.1)	0.20	(5.0)
0.14	(3.6)	0.22	(5.5)
0.12	(3.0)	0.24	(6.0)
0.10	(2.5)	0.26	(6.5)
0.08	(2.0)	0.28	(7.0)
0.06	(1.5)	0.30	(7.5)
0.04	(1.0)	0.32	(8.0)
0.02	(0.5)	0.34	(8.5)

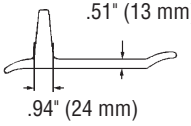
NOTE: Ultrasonic measurement is to determine flange wear only.

953 — 6.91" (175.5 mm), 7.50" (190.5 mm)

Track Shoes

Moderate Service



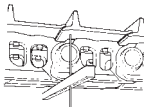


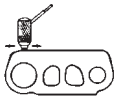
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
2.25	(57.0)	0	2.75	(69.9)
2.20	(56.0)	4	2.70	(68.6)
2.15	(54.5)	8	2.65	(67.3)
2.10	(53.5)	12	2.60	(66.0)
2.05	(52.0)	16	2.55	(64.8)
2.00	(51.0)	20	2.50	(63.5)
1.95	(49.5)	24	2.45	(62.2)
1.90	(48.5)	28	2.40	(61.0)
1.85	(47.0)	32	2.35	(59.7)
1.80	(45.5)	36	2.30	(58.4)
1.75	(44.5)	40	2.25	(57.2)
1.70	(43.0)	44	2.20	(55.9)
1.65	(42.0)	48	2.15	(54.6)
1.60	(40.5)	52	2.10	(53.3)
1.55	(39.5)	56	2.05	(52.1)
1.50	(38.0)	60	2.00	(50.8)
1.45	(37.0)	64	1.95	(49.5)
1.40	(35.5)	67	1.90	(48.3)
1.35	(34.5)	70	1.85	(47.0)
1.30	(33.0)	73	1.80	(45.7)
1.25	(32.0)	76	1.75	(44.5)
1.20	(30.5)	79	1.70	(43.2)
1.15	(29.0)	82	1.65	(41.9)
1.10	(28.0)	85	1.60	(40.6)
1.05	(26.5)	88	1.55	(39.4)
1.00	(25.5)	91	1.50	(38.1)
0.95	(24.0)	94	1.45	(36.8)
0.90	(23.0)	97	1.40	(35.6)
0.85	(21.5)	100	1.35	(34.3)
0.80	(20.5)	103	1.30	(33.0)
0.75	(19.0)	106	1.25	(31.8)
0.70	(18.0)	109	1.20	(30.5)
0.65	(16.5)	112	1.15	(29.2)
0.60	(15.0)	115	1.10	(27.9)
0.55	(14.0)	118	1.05	(26.7)
0.50	(12.5)	121	1.00	(25.4)

Undercarriage Code: 343, 344

Track Links

7T4645 & 46

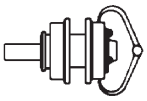


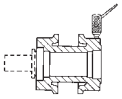


Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
5.03	(128.0)	0	1.67	(42.4)
5.01	(127.5)	4	1.65	(41.9)
4.99	(126.5)	8	1.63	(41.4)
4.97	(126.0)	12	1.61	(40.9)
4.95	(125.5)	16	1.59	(40.4)
4.93	(125.0)	20	1.57	(39.9)
4.91	(124.5)	24	1.55	(39.4)
4.89	(124.0)	28	1.53	(38.9)
4.87	(123.5)	32	1.51	(38.4)
4.85	(123.0)	36	1.49	(37.8)
4.83	(122.5)	40	1.47	(37.3)
4.81	(122.0)	44	1.45	(36.8)
4.79	(121.5)	48	1.43	(36.3)
4.77	(121.0)	52	1.41	(35.8)
4.75	(120.5)	56	1.39	(35.3)
4.73	(120.0)	60	1.37	(34.8)
4.71	(119.5)	64	1.35	(34.3)
4.69	(119.0)	68	1.33	(33.8)
4.67	(118.5)	72	1.31	(33.3)
4.65	(118.0)	76	1.29	(32.8)
4.63	(117.5)	80	1.27	(32.3)
4.61	(117.0)	84	1.25	(31.8)
4.59	(116.5)	88	1.23	(31.2)
4.57	(116.0)	92	1.21	(30.7)
4.55	(115.5)	96	1.19	(30.2)
4.53	(115.0)	100	1.17	(29.7)
4.51	(114.5)	103	1.15	(29.2)
4.49	(114.0)	106	1.13	(28.7)
4.47	(113.5)	109	1.11	(28.2)
4.45	(113.0)	112	1.09	(27.7)
4.43	(112.5)	115	1.07	(27.2)
4.41	(112.0)	118	1.05	(26.7)
4.39	(111.5)	121	1.03	(26.2)

Undercarriage Code: 364

Carrier Rollers





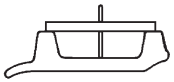
Caliper Inches	Caliper (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
7.38	(187.5)	0	1.86	(47.2)
7.34	(186.5)	4	1.84	(46.7)
7.30	(185.5)	8	1.82	(46.2)
7.26	(184.5)	12	1.80	(45.7)
7.22	(183.5)	16	1.78	(45.2)
7.18	(182.5)	20	1.76	(44.7)
7.14	(181.5)	24	1.74	(44.2)
7.10	(180.5)	28	1.72	(43.7)
7.06	(179.5)	32	1.70	(43.2)
7.02	(178.5)	36	1.68	(42.7)
6.98	(177.5)	40	1.66	(42.2)
6.94	(176.5)	44	1.64	(41.7)
6.90	(175.5)	48	1.62	(41.1)
6.86	(174.0)	52	1.60	(40.6)
6.82	(173.0)	56	1.58	(40.1)
6.78	(172.0)	60	1.56	(39.6)
6.74	(171.0)	64	1.54	(39.1)
6.70	(170.0)	68	1.52	(38.6)
6.66	(169.0)	70	1.50	(38.1)
6.62	(168.0)	72	1.48	(37.6)
6.58	(167.0)	74	1.46	(37.1)
6.54	(166.0)	76	1.44	(36.6)
6.50	(165.0)	78	1.42	(36.1)
6.46	(164.0)	80	1.40	(35.6)
6.42	(163.0)	82	1.38	(35.1)
6.38	(162.0)	84	1.36	(34.5)
6.34	(161.0)	86	1.34	(34.0)
6.30	(160.0)	88	1.32	(33.5)
6.26	(159.0)	90	1.30	(33.0)
6.22	(158.0)	92	1.28	(32.5)
6.18	(157.0)	94	1.26	(32.0)
6.14	(156.0)	96	1.24	(31.5)
6.10	(155.0)	98	1.22	(31.0)
6.06	(154.0)	100	1.20	(30.5)
6.02	(153.0)	102	1.18	(30.0)
5.98	(152.0)	104	1.16	(29.5)
5.94	(151.0)	106	1.14	(29.0)
5.90	(150.0)	108	1.12	(28.4)
5.86	(149.0)	110	1.10	(27.9)
5.82	(148.0)	112	1.08	(27.4)
5.78	(147.0)	114	1.06	(26.9)
5.74	(146.0)	116	1.04	(26.4)
5.70	(145.0)	118	1.02	(25.9)
5.66	(144.0)	120	1.00	(25.4)

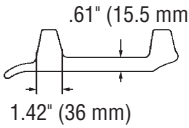
Undercarriage Code: 364, 365

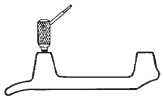
973 — 8.50" (215.9 mm)

Track Shoes

Double Grouser







Depth Gauge Inches	(mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	(mm)
1.95	(49.5)	0	0	2.55	(64.8)
1.90	(48.5)	5	4	2.50	(63.5)
1.85	(47.0)	10	8	2.45	(62.2)
1.80	(45.5)	15	12	2.40	(61.0)
1.75	(44.5)	20	16	2.35	(59.7)
1.70	(43.0)	24	20	2.30	(58.4)
1.65	(42.0)	28	24	2.25	(57.2)
1.60	(40.5)	32	28	2.20	(55.9)
1.55	(39.5)	36	32	2.15	(54.6)
1.50	(38.0)	40	36	2.10	(53.3)
1.45	(37.0)	44	40	2.05	(52.1)
1.40	(35.5)	48	44	2.00	(50.8)
1.35	(34.5)	52	48	1.95	(49.5)
1.30	(33.0)	56	52	1.90	(48.3)
1.25	(32.0)	60	55	1.85	(47.0)
1.20	(30.5)	64	58	1.80	(45.7)
1.15	(29.0)	68	61	1.75	(44.5)
1.10	(28.0)	72	64	1.70	(43.2)
1.05	(26.5)	76	67	1.65	(41.9)
1.00	(25.5)	80	70	1.60	(40.6)
0.95	(24.0)	84	73	1.55	(39.4)
0.90	(23.0)	88	76	1.50	(38.1)
0.85	(21.5)	92	79	1.45	(36.8)
0.80	(20.5)	96	82	1.40	(35.6)
0.75	(19.0)	100	85	1.35	(34.3)
0.70	(18.0)	104	88	1.30	(33.0)
0.65	(16.5)	108	91	1.25	(31.8)
0.60	(15.0)	112	94	1.20	(30.5)
0.55	(14.0)	116	97	1.15	(29.2)
0.50	(12.5)	120	100	1.10	(27.9)
0.45	(11.5)		103	1.05	(26.7)
0.40	(10.0)		106	1.00	(25.4)
0.35	(9.0)		109	0.95	(24.1)
0.30	(7.5)		112	0.90	(22.9)
0.25	(6.5)		115	0.85	(21.6)
0.20	(5.0)		118	0.80	(20.3)
0.15	(4.0)		121	0.75	(19.1)

Undercarriage Code: 373, 374, 375

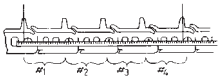
Undercarriage Identification

The easiest way to identify track is to read the part number forged into the link. The following list cross-references link part numbers to the correct percent worn chart pages.

Model	Pitch	Link Part Number	Wear Chart Pages
307, 308	5.31"	136-2404 & 10	498-507
	6.06"	093-1969 & 70 3A9614 & 15	
311, 312, 313, 314	6.75"	4I7475 & 76	508-514
315, 317, 318, 320, 322, 320 FM	7.50"	9W3137 & 38 106-1625 & 26	516-529
320S, 322 FM, 325, 325 FM	8.00"	6Y1607 & 08 8E7405 & 06	530-542
330	8.50"	6Y2589 & 90	544-555
330 FM, 345	8.50"	150-4748 & 49 130-5333 & 34 209-6383 & 84	556-564
350	9.00"	8E6091 & 92	566-573
365, 375, 385, 5080, 5090	10.25"	142-1803 & 04 6Y6721 & 22	574-583
5110	10.25"	9W5933 & 34	584-591
5130	12.50"	6I8643 & 44 6T8049 & 50	592-600
5230	14.90"	185-9377 & 78	602-606
205, 211, 213	6.75"	9K6628 & 29	608-615
215	6.75"	9K6628 & 29	616-628
225, 219, 215S.A., FB221, FB217, DL221	7.50"	7T4043 & 44 3P7153 & 54	630-644
225	6.75"	9K6628 & 29	646-655
227, 229, 231, 225S.A., LL225	8.00"	3P1112 & 13	656-665
235, LL235	8.50"	8E8641 & 42 130-5333 & 34 8S2589 & 90 7T9823 & 24	666-682
235	8.00"	3P1112 & 13	684-691
245	10.25"	9S1927 & 28	692-701
245	9.00"	8K4754 & 56 9G6083 & 84	702-709
E70B	5.31"	093-1969 & 70	710-718
E110B, E120B	6.75"	4I7475 & 76	720-726
E140	6.75"	093-1978 & 77	728-734
E180, EL180	6.91"	095-7130 093-1979	736-742
E200B, EL200B	7.50"	9W3137 & 38	744-750
EL240B, E240B, EL240, E240	7.50"	9W3137 & 38 0965252 & 58	752-759
E300B, EL300B, EL300	8.00"	096-0263 & 64	760-767
E300	7.50"	096-5252 & 58	768-775
E450	8.50"	096-9944 & 46	776-782
E650	9.00"	093-1984 & 85	784-790

Pins and Bushings for Sealed Track

Internal Wear
5.31" (135 mm) Pitch

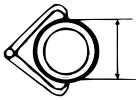


Inches	(mm)	% Worn
21.25	(540.0)	0
21.30	(541.2)	10
21.35	(542.3)	20
21.40	(543.6)	30
21.45	(544.8)	40
21.50	(546.1)	50
21.55	(547.3)	60
21.60	(548.6)	70
21.65	(549.9)	80
21.70	(551.2)	90
21.75	(552.4)	100
21.80	(553.7)	105
21.85	(555.0)	110
21.90	(556.2)	115
21.95	(557.5)	120

311, 312, 313, 314 — 6.75" (171.5 mm)

Bushings for Sealed Track

External Wear



Caliper			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
1.99	(50.5)	0	0.32	(8.1)
1.98	(50.3)	8	0.31	(7.9)
1.97	(50.0)	16	0.30	(7.6)
1.96	(49.8)	24	0.29	(7.4)
1.95	(49.5)	32	0.28	(7.1)
1.94	(49.3)	40	0.27	(6.9)
1.93	(49.0)	48	0.26	(6.6)
1.92	(48.8)	56	0.25	(6.3)
1.91	(48.5)	64	0.24	(6.1)
1.90	(48.3)	72	0.23	(5.8)
1.89	(48.0)	76	0.22	(5.6)
1.88	(47.8)	80	0.21	(5.3)
1.87	(47.5)	84	0.20	(5.1)
1.86	(47.2)	88	0.19	(4.8)
1.85	(47.0)	92	0.18	(4.6)
1.84	(46.7)	96	0.17	(4.3)
1.83	(46.5)	100	0.16	(4.1)
1.82	(46.2)	104	0.15	(3.8)
1.81	(46.0)	108	0.14	(3.6)
1.80	(45.7)	112	0.13	(3.3)
1.79	(45.5)	116	0.12	(3.0)
1.78	(45.2)	120	0.11	(2.8)

Bushings for Sealed Track

External Wear
Grease Lubricated Track
Only use for 320 FM

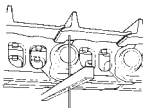
Caliper		Allowable Wear		Ultrasonic	
		Lesser	Greater		
Inches	(mm)	% Worn	% Worn	Inches	(mm)
2.56	(65.0)	0	0	0.51	(13.0)
2.55	(64.8)	5	4	0.50	(12.7)
2.54	(64.5)	10	8	0.49	(12.4)
2.53	(64.3)	15	12	0.48	(12.2)
2.52	(64.0)	20	16	0.47	(11.9)
2.51	(63.8)	25	20	0.46	(11.7)
2.50	(63.5)	30	24	0.45	(11.4)
2.49	(63.2)	35	28	0.44	(11.2)
2.48	(63.0)	40	32	0.43	(10.9)
2.47	(62.7)	45	36	0.42	(10.7)
2.46	(62.5)	50	40	0.41	(10.4)
2.45	(62.2)	55	44	0.40	(10.2)
2.44	(62.0)	60	46	0.39	(9.9)
2.43	(61.7)	65	48	0.38	(9.7)
2.42	(61.5)	70	50	0.37	(9.4)
2.41	(61.2)	72	52	0.36	(9.1)
2.40	(61.0)	74	54	0.35	(8.9)
2.39	(60.7)	76	56	0.34	(8.6)
2.38	(60.5)	78	58	0.33	(8.4)
2.37	(60.2)	80	60	0.32	(8.1)
2.36	(59.9)	82	62	0.31	(7.9)
2.35	(59.7)	84	64	0.30	(7.6)
2.34	(59.4)	86	66	0.29	(7.4)
2.33	(59.2)	88	68	0.28	(7.1)
2.32	(58.9)	90	70	0.27	(6.9)
2.31	(58.7)	92	72	0.26	(6.6)
2.30	(58.4)	94	74	0.25	(6.3)
2.29	(58.2)	96	76	0.24	(6.1)
2.28	(57.9)	98	78	0.23	(5.8)
2.27	(57.7)	100	80	0.22	(5.6)
2.26	(57.4)	102	82	0.21	(5.3)
2.25	(57.2)	104	84	0.20	(5.1)
2.24	(56.9)	106	86	0.19	(4.8)
2.23	(56.6)	108	88	0.18	(4.6)
2.22	(56.4)	110	90	0.17	(4.3)
2.21	(56.1)	112	92	0.16	(4.1)
2.20	(55.9)	114	94	0.15	(3.8)
2.19	(55.6)	116	96	0.14	(3.6)
2.18	(55.4)	118	98	0.13	(3.3)
2.17	(55.1)	120	100	0.12	(3.0)
2.16	(54.9)		102	0.11	(2.8)
2.15	(54.6)		104	0.10	(2.5)
2.14	(54.4)		106	0.09	(2.3)
2.13	(54.1)		108	0.08	(2.0)
2.12	(53.8)		110	0.07	(1.8)
2.11	(53.6)		112	0.06	(1.5)
2.10	(53.3)		114	0.05	(1.3)
2.09	(53.1)		116	0.04	(1.0)
2.08	(52.8)		118	0.03	(0.8)
2.07	(52.6)		120	0.02	(0.5)

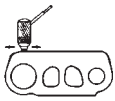
Undercarriage Code: 567

320S, 322 FM, 325 — 8.00" (203.2 mm)

Track Links

6Y1607 & 08
Not for use on 325 FM



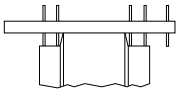


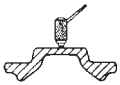
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
4.52	(115.0)	0	1.26	(32.0)
4.50	(114.5)	8	1.24	(31.5)
4.48	(114.0)	16	1.22	(31.0)
4.46	(113.5)	24	1.20	(30.5)
4.44	(113.0)	32	1.18	(30.0)
4.42	(112.5)	40	1.16	(29.5)
4.40	(112.0)	45	1.14	(29.0)
4.38	(111.5)	50	1.12	(28.4)
4.36	(110.5)	55	1.10	(27.9)
4.34	(110.0)	60	1.08	(27.4)
4.32	(109.5)	65	1.06	(26.9)
4.30	(109.0)	70	1.04	(26.4)
4.28	(108.5)	75	1.02	(25.9)
4.26	(108.0)	80	1.00	(25.4)
4.24	(107.5)	85	0.98	(24.9)
4.22	(107.0)	90	0.96	(24.4)
4.20	(106.5)	95	0.94	(23.9)
4.18	(106.0)	100	0.92	(23.4)
4.16	(105.5)	105	0.90	(22.9)
4.14	(105.0)	110	0.88	(22.4)
4.12	(104.5)	115	0.86	(21.8)
4.10	(104.0)	120	0.84	(21.3)

Undercarriage Code: 568, 5681, 579, 5791, 591, 5911

320 S, 322 FM, 325 — 8.00" (203.2 mm)

Idlers





Depth Gauge Inches	(mm)	% Worn	Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.78	(20.0)	0	0.49	(12.4)	0.00	(0.0)
0.80	(20.5)	12	0.47	(11.9)	0.02	(0.5)
0.82	(21.0)	24	0.45	(11.4)	0.04	(1.0)
0.84	(21.5)	36	0.43	(10.9)	0.06	(1.5)
0.86	(22.0)	44	0.41	(10.4)	0.08	(2.0)
0.88	(22.5)	48	0.39	(9.9)	0.10	(2.5)
0.90	(23.0)	52	0.37	(9.4)	0.12	(3.0)
0.92	(23.5)	56	0.35	(8.9)	0.14	(3.5)
0.94	(24.0)	60	0.33	(8.4)	0.16	(4.0)
0.96	(24.5)	64	0.31	(7.9)	0.18	(4.5)
0.98	(25.0)	68	0.29	(7.4)	0.20	(5.0)
1.00	(25.5)	72	0.27	(6.9)	0.22	(5.5)
1.02	(26.0)	76	0.25	(6.3)	0.24	(6.0)
1.04	(26.5)	80	0.23	(5.8)	0.26	(6.5)
1.06	(27.0)	84	0.21	(5.3)	0.28	(7.0)
1.08	(27.5)	88	0.19	(4.8)	0.30	(7.5)
1.10	(28.0)	92	0.17	(4.3)	0.32	(8.0)
1.12	(28.5)	96	0.15	(3.8)	0.34	(8.5)
1.14	(29.0)	100	0.13	(3.3)	0.36	(9.0)
1.16	(29.5)	104	0.11	(2.8)	0.38	(9.5)
1.18	(30.0)	108	0.09	(2.3)	0.40	(10.0)
1.20	(30.5)	112	0.07	(1.8)	0.42	(10.5)
1.22	(31.0)	116	0.05	(1.3)	0.44	(11.0)
1.24	(31.5)	120	0.03	(0.8)	0.46	(11.5)

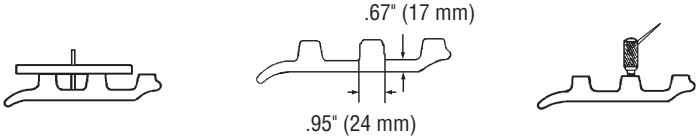
Flange width: 3.74" (95 mm)

Undercarriage Code: 568, 5681, 579, 5791, 591, 5911, 592

330 — 8.50" (215.9 mm)

Track Shoes

Extreme Service Triple Grouser



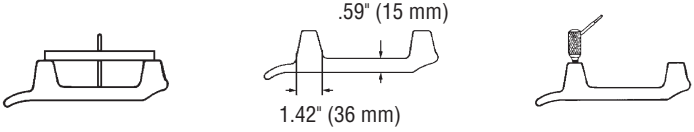
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
1.35	(34.5)	0	1.95	(49.5)
1.30	(33.0)	6	1.90	(48.2)
1.25	(32.0)	12	1.85	(47.0)
1.20	(30.5)	18	1.80	(45.7)
1.15	(29.0)	24	1.75	(44.4)
1.10	(28.0)	30	1.70	(43.2)
1.05	(26.5)	36	1.65	(41.9)
1.00	(25.5)	42	1.60	(40.6)
0.95	(24.0)	48	1.55	(39.3)
0.90	(23.0)	54	1.50	(38.1)
0.85	(21.5)	60	1.45	(36.8)
0.80	(20.5)	66	1.40	(35.5)
0.75	(19.0)	72	1.35	(34.3)
0.70	(18.0)	78	1.30	(33.0)
0.65	(16.5)	84	1.25	(31.7)
0.60	(15.0)	90	1.20	(30.5)
0.55	(14.0)	95	1.15	(29.2)
0.50	(12.5)	100	1.10	(27.9)
0.45	(11.5)	105	1.05	(26.6)
0.40	(10.0)	110	1.00	(25.4)
0.35	(9.0)	115	0.95	(24.1)
0.30	(7.5)	120	0.90	(22.8)

Undercarriage Code: 609, 6091

330 FM, 345 — 8.50" (215.9 mm)

Track Shoes

Double Grouser



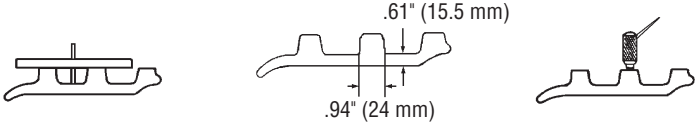
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
1.95	(49.5)	0	2.54	(64.5)
1.85	(47.0)	10	2.44	(62.0)
1.75	(44.5)	20	2.34	(59.4)
1.65	(42.0)	30	2.24	(56.9)
1.55	(39.5)	40	2.14	(54.3)
1.45	(37.0)	50	2.04	(51.8)
1.35	(34.0)	60	1.94	(49.3)
1.25	(31.5)	70	1.84	(46.7)
1.15	(29.0)	80	1.74	(44.2)
1.05	(26.5)	85	1.64	(41.6)
0.95	(24.0)	90	1.54	(39.1)
0.85	(21.5)	95	1.44	(36.6)
0.75	(19.0)	100	1.34	(34.0)
0.65	(16.5)	105	1.24	(31.5)
0.55	(14.0)	110	1.14	(28.9)
0.45	(11.5)	115	1.04	(26.4)
0.35	(9.0)	120	0.94	(23.9)

Undercarriage Code: 610, 6101, 620, 6201

350 — 9.00" (228.6 mm)

Track Shoes

Triple Grouser

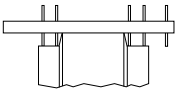


Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
1.35	(34.5)	0	1.95	(49.5)
1.30	(33.0)	6	1.90	(48.2)
1.25	(32.0)	12	1.85	(47.0)
1.20	(30.5)	18	1.80	(45.7)
1.15	(29.0)	24	1.75	(44.4)
1.10	(28.0)	30	1.70	(43.2)
1.05	(26.5)	36	1.65	(41.9)
1.00	(25.5)	42	1.60	(40.6)
0.95	(24.0)	48	1.55	(39.3)
0.90	(23.0)	54	1.50	(38.1)
0.85	(21.5)	60	1.45	(36.8)
0.80	(20.5)	66	1.40	(35.5)
0.75	(19.0)	72	1.35	(34.3)
0.70	(18.0)	78	1.30	(33.0)
0.65	(16.5)	84	1.25	(31.7)
0.60	(15.0)	90	1.20	(30.5)
0.55	(14.0)	95	1.15	(29.2)
0.50	(12.5)	100	1.10	(27.9)
0.45	(11.5)	105	1.05	(26.6)
0.40	(10.0)	110	1.00	(25.4)
0.35	(9.0)	115	0.95	(24.1)
0.30	(7.5)	120	0.90	(22.8)

Undercarriage Code: 626

365, 375, 385, 5080, 5090 — 10.25" (260.4 mm)

Idlers



Depth Gauge Inches	(mm)	% Worn
0.88	(22.5)	0
0.90	(23.0)	7
0.92	(23.5)	14
0.94	(24.0)	21
0.96	(24.5)	28
0.98	(25.0)	35
1.00	(25.5)	42
1.02	(26.0)	49
1.04	(26.5)	52
1.06	(27.0)	55
1.08	(27.5)	58
1.10	(28.0)	61
1.12	(28.5)	64
1.14	(29.0)	67
1.16	(29.5)	70
1.18	(30.0)	73
1.20	(30.5)	76
1.22	(31.0)	79
1.24	(31.5)	82
1.26	(32.0)	85
1.28	(32.5)	88
1.30	(33.0)	91
1.32	(33.5)	94
1.34	(34.0)	97
1.36	(34.5)	100
1.38	(35.0)	103
1.40	(35.5)	106
1.42	(36.0)	109
1.44	(36.5)	112
1.46	(37.0)	115
1.48	(37.5)	118
1.50	(38.0)	121

Flange width: 5.09" (129.3 mm)

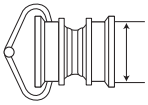
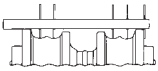
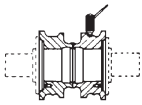
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.48	(12.2)	0.00	(0.0)
0.46	(11.7)	0.02	(0.5)
0.44	(11.2)	0.04	(1.0)
0.42	(10.7)	0.06	(1.5)
0.40	(10.2)	0.08	(2.0)
0.38	(9.7)	0.10	(2.5)
0.36	(9.1)	0.12	(3.0)
0.34	(8.6)	0.14	(3.5)
0.32	(8.1)	0.16	(4.0)
0.30	(7.6)	0.18	(4.5)
0.28	(7.1)	0.20	(5.0)
0.26	(6.6)	0.22	(5.5)
0.24	(6.1)	0.24	(6.0)
0.22	(5.6)	0.26	(6.5)
0.20	(5.1)	0.28	(7.0)
0.18	(4.6)	0.30	(7.5)
0.16	(4.1)	0.32	(8.0)
0.14	(3.6)	0.34	(8.5)
0.12	(3.0)	0.36	(9.0)
0.10	(2.5)	0.38	(9.5)
0.08	(2.0)	0.40	(10.0)
0.06	(1.5)	0.42	(10.5)
0.04	(1.0)	0.44	(11.0)
0.02	(0.5)	0.46	(11.5)

NOTE: Ultrasonic measurement is to determine flange wear only. Use ultrasonic only on fabricated idlers.

Undercarriage Code: 635, 641, 650, 660, 662

5110 — 10.25" (260.4 mm)

Track Rollers

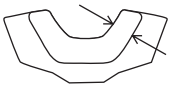




Caliper Inches	Caliper (mm)	% Worn	Depth Gauge Inches	Depth Gauge (mm)	Ultrasonic Inches	Ultrasonic (mm)
11.22	(285.0)	0	1.18	(30.0)	3.06	(77.7)
11.18	(284.0)	6	1.20	(30.5)	3.04	(77.2)
11.14	(283.0)	12	1.22	(31.0)	3.02	(76.7)
11.10	(282.0)	18	1.24	(31.5)	3.00	(76.2)
11.06	(281.0)	24	1.26	(32.0)	2.98	(75.7)
11.02	(280.0)	30	1.28	(32.5)	2.96	(75.2)
10.98	(279.0)	36	1.30	(33.0)	2.94	(74.7)
10.94	(278.0)	42	1.32	(33.5)	2.92	(74.2)
10.90	(277.0)	46	1.34	(34.0)	2.90	(73.7)
10.86	(276.0)	49	1.36	(34.5)	2.88	(73.2)
10.82	(275.0)	52	1.38	(35.0)	2.86	(72.6)
10.78	(274.0)	55	1.40	(35.5)	2.84	(72.1)
10.74	(273.0)	58	1.42	(36.0)	2.82	(71.6)
10.70	(272.0)	61	1.44	(36.5)	2.80	(71.1)
10.66	(271.0)	64	1.46	(37.0)	2.78	(70.6)
10.62	(269.5)	67	1.48	(37.5)	2.76	(70.1)
10.58	(268.5)	70	1.50	(38.0)	2.74	(69.6)
10.54	(267.5)	73	1.52	(38.5)	2.72	(69.1)
10.50	(266.5)	76	1.54	(39.0)	2.70	(68.6)
10.46	(265.5)	79	1.56	(39.5)	2.68	(68.1)
10.42	(264.5)	82	1.58	(40.0)	2.66	(67.6)
10.38	(263.5)	85	1.60	(40.5)	2.64	(67.1)
10.34	(262.5)	88	1.62	(41.0)	2.62	(66.5)
10.30	(261.5)	91	1.64	(41.5)	2.60	(66.0)
10.26	(260.5)	94	1.66	(42.0)	2.58	(65.5)
10.22	(259.5)	97	1.68	(42.5)	2.56	(65.0)
10.18	(258.5)	100	1.70	(43.0)	2.54	(64.5)
10.14	(257.5)	103	1.72	(43.5)	2.52	(64.0)
10.10	(256.5)	106	1.74	(44.0)	2.50	(63.5)
10.06	(255.5)	109	1.76	(44.5)	2.48	(63.0)
10.02	(254.5)	112	1.78	(45.0)	2.46	(62.5)
9.98	(253.5)	115	1.80	(45.5)	2.44	(62.0)
9.94	(252.5)	118	1.82	(46.0)	2.42	(61.5)
9.90	(251.5)	121	1.84	(46.5)	2.40	(61.0)

Flange diameter is 13.58" (345 mm)

Undercarriage Code: 665

Sprockets



Caliper Inches	(mm)	% Worn
1.90	(48.5)	0
1.85	(47.0)	6
1.80	(45.5)	12
1.75	(44.5)	18
1.70	(43.0)	24
1.65	(42.0)	30
1.60	(40.5)	36
1.55	(39.5)	42
1.50	(38.0)	48
1.45	(37.0)	54
1.40	(35.5)	60
1.35	(34.5)	66
1.30	(33.0)	70
1.25	(32.0)	73
1.20	(30.5)	76
1.15	(29.0)	79
1.10	(28.0)	82
1.05	(26.5)	85
1.00	(25.5)	88
0.95	(24.0)	91
0.90	(23.0)	94
0.85	(21.5)	97
0.80	(20.5)	100
0.75	(19.0)	103
0.70	(18.0)	106
0.65	(16.5)	109
0.60	(15.0)	112
0.55	(14.0)	115
0.50	(12.5)	118
0.45	(11.5)	121

Undercarriage Code: 670, 671

205, 211, 213 — 6.75" (171.5 mm)

Bushings for Sealed Track

External Wear

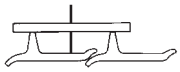
Caliper		Allowable Wear		Ultrasonic	
		Lesser	Greater		
Inches	(mm)	% Worn	% Worn	Inches	(mm)
2.14	(54.4)	0	0	0.39	(9.9)
2.13	(54.1)	9	7	0.38	(9.7)
2.12	(53.8)	18	14	0.37	(9.4)
2.11	(53.6)	27	21	0.36	(9.1)
2.10	(53.3)	36	28	0.35	(8.9)
2.09	(53.1)	45	35	0.34	(8.6)
2.08	(52.8)	54	42	0.33	(8.4)
2.07	(52.6)	63	49	0.32	(8.1)
2.06	(52.3)	72	56	0.31	(7.9)
2.05	(52.1)	81	63	0.30	(7.6)
2.04	(51.8)	88	70	0.29	(7.4)
2.03	(51.6)	92	73	0.28	(7.1)
2.02	(51.3)	96	76	0.27	(6.9)
2.01	(51.1)	100	79	0.26	(6.6)
2.00	(50.8)	104	82	0.25	(6.4)
1.99	(50.5)	108	85	0.24	(6.1)
1.98	(50.3)	112	88	0.23	(5.8)
1.97	(50.0)	116	91	0.22	(5.6)
1.96	(49.8)	120	94	0.21	(5.3)
1.95	(49.5)		97	0.20	(5.1)
1.94	(49.3)		100	0.19	(4.8)
1.93	(49.0)		103	0.18	(4.6)
1.92	(48.8)		106	0.17	(4.3)
1.91	(48.5)		109	0.16	(4.1)
1.90	(48.3)		112	0.15	(3.8)
1.89	(48.0)		115	0.14	(3.6)
1.88	(47.8)		118	0.13	(3.3)
1.87	(47.5)		121	0.12	(3.0)

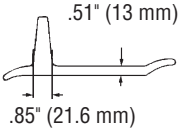
Undercarriage Code: 401, 402, 411, 412, 421, 422

215 — 6.75" (171.5 mm)

Track Shoes

Moderate Service





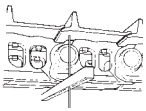
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
2.25	(57.0)	0	2.75	(69.9)
2.20	(56.0)	4	2.70	(68.6)
2.15	(54.5)	8	2.65	(67.4)
2.10	(53.5)	12	2.60	(66.1)
2.05	(52.0)	16	2.55	(64.8)
2.00	(51.0)	20	2.50	(63.6)
1.95	(49.5)	24	2.45	(62.3)
1.90	(48.5)	28	2.40	(61.0)
1.85	(47.0)	32	2.35	(59.7)
1.80	(45.5)	36	2.30	(58.5)
1.75	(44.5)	40	2.25	(57.2)
1.70	(43.0)	44	2.20	(55.9)
1.65	(42.0)	48	2.15	(54.7)
1.60	(40.5)	52	2.10	(53.4)
1.55	(39.5)	56	2.05	(52.1)
1.50	(38.0)	60	2.00	(50.9)
1.45	(37.0)	64	1.95	(49.6)
1.40	(35.5)	67	1.90	(48.3)
1.35	(34.5)	70	1.85	(47.0)
1.30	(33.0)	73	1.80	(45.8)
1.25	(32.0)	76	1.75	(44.5)
1.20	(30.5)	79	1.70	(43.2)
1.15	(29.0)	82	1.65	(42.0)
1.10	(28.0)	85	1.60	(40.7)
1.05	(26.5)	88	1.55	(39.4)
1.00	(25.5)	91	1.50	(38.2)
0.95	(24.0)	94	1.45	(36.9)
0.90	(23.0)	97	1.40	(35.6)
0.85	(21.5)	100	1.35	(34.3)
0.80	(20.5)	103	1.30	(33.1)
0.75	(19.0)	106	1.25	(31.8)
0.70	(18.0)	109	1.20	(30.5)
0.65	(16.5)	112	1.15	(29.3)
0.60	(15.0)	115	1.10	(28.0)
0.55	(14.0)	118	1.05	(26.7)
0.50	(12.5)	121	1.00	(25.5)

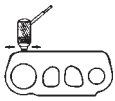
Undercarriage Code: 430, 431, 432

225, 219, 215 S.A., FB221, FB217, DL221 — 7.50" (190 mm)

Track Links

7T4043 & 44
7.50" (190 mm) Pitch



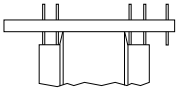


Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
4.17	(106.0)	0	1.21	(30.7)
4.15	(105.5)	9	1.19	(30.2)
4.13	(105.0)	18	1.17	(29.7)
4.11	(104.5)	27	1.15	(29.2)
4.09	(104.0)	36	1.13	(28.7)
4.07	(103.5)	44	1.11	(28.2)
4.05	(103.0)	51	1.09	(27.7)
4.03	(102.5)	58	1.07	(27.2)
4.01	(102.0)	65	1.05	(26.7)
3.99	(101.5)	72	1.03	(26.2)
3.97	(101.0)	79	1.01	(25.7)
3.95	(100.5)	86	0.99	(25.1)
3.93	(100.0)	93	0.97	(24.6)
3.91	(99.5)	100	0.95	(24.1)
3.89	(99.0)	107	0.93	(23.6)
3.87	(98.5)	114	0.91	(23.1)
3.85	(98.0)	121	0.89	(22.6)

Undercarriage Code: 442, 443, 454, 455

225, 219, 215 S.A., FB221, FB217, DL221 — 7.50" (190 mm) & 6.91" (175.5 mm)

Idlers



Depth Gauge Inches	(mm)	% Worn
0.78	(20.0)	0
0.80	(20.5)	12
0.82	(21.0)	24
0.84	(21.5)	36
0.86	(22.0)	48
0.88	(22.5)	60
0.90	(23.0)	72
0.92	(23.5)	82
0.94	(24.0)	85
0.96	(24.5)	88
0.98	(25.0)	91
1.00	(25.5)	94
1.02	(26.0)	97
1.04	(26.5)	100
1.06	(27.0)	103
1.08	(27.5)	106
1.10	(28.0)	109
1.12	(28.5)	112
1.14	(29.0)	115
1.16	(29.5)	118
1.18	(30.0)	121

Flange width: 3.31" (84 mm)

Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.36	(9.1)	0.00	(0.0)
0.34	(8.6)	0.02	(0.5)
0.32	(8.1)	0.04	(1.0)
0.30	(7.6)	0.06	(1.5)
0.28	(7.1)	0.08	(2.0)
0.26	(6.6)	0.10	(2.5)
0.24	(6.1)	0.12	(3.0)
0.22	(5.6)	0.14	(3.5)
0.20	(5.1)	0.16	(4.0)
0.18	(4.6)	0.18	(4.5)
0.16	(4.1)	0.20	(5.0)
0.14	(3.6)	0.22	(5.5)
0.12	(3.0)	0.24	(6.0)
0.10	(2.5)	0.26	(6.5)
0.08	(2.0)	0.28	(7.0)
0.06	(1.5)	0.30	(7.5)
0.04	(1.0)	0.32	(8.0)
0.02	(0.5)	0.34	(8.5)

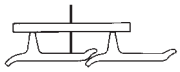
NOTE: Ultrasonic measurement is to determine flange wear only.

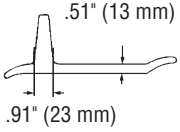
Undercarriage Code: 433, 434, 440, 442, 443, 445, 452, 453, 454, 455

225 — 6.75" (171.5 mm)

Track Shoes

Moderate Service





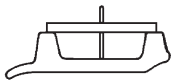
Depth Gauge			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
2.25	(57.0)	0	2.75	(69.9)
2.20	(56.0)	4	2.70	(68.6)
2.15	(54.5)	8	2.65	(67.4)
2.10	(53.5)	12	2.60	(66.1)
2.05	(52.0)	16	2.55	(64.8)
2.00	(51.0)	20	2.50	(63.6)
1.95	(49.5)	24	2.45	(62.3)
1.90	(48.5)	28	2.40	(61.0)
1.85	(47.0)	32	2.35	(59.7)
1.80	(45.5)	36	2.30	(58.5)
1.75	(44.5)	40	2.25	(57.2)
1.70	(43.0)	44	2.20	(55.9)
1.65	(42.0)	48	2.15	(54.7)
1.60	(40.5)	52	2.10	(53.4)
1.55	(39.5)	56	2.05	(52.1)
1.50	(38.0)	60	2.00	(50.9)
1.45	(37.0)	64	1.95	(49.6)
1.40	(35.5)	67	1.90	(48.3)
1.35	(34.5)	70	1.85	(47.0)
1.30	(33.0)	73	1.80	(45.8)
1.25	(32.0)	76	1.75	(44.5)
1.20	(30.5)	79	1.70	(43.2)
1.15	(29.0)	82	1.65	(42.0)
1.10	(28.0)	85	1.60	(40.7)
1.05	(26.5)	88	1.55	(39.4)
1.00	(25.5)	91	1.50	(38.2)
0.95	(24.0)	94	1.45	(36.9)
0.90	(23.0)	97	1.40	(35.6)
0.85	(21.5)	100	1.35	(34.3)
0.80	(20.5)	103	1.30	(33.1)
0.75	(19.0)	106	1.25	(31.8)
0.70	(18.0)	109	1.20	(30.5)
0.65	(16.5)	112	1.15	(29.3)
0.60	(15.0)	115	1.10	(28.0)
0.55	(14.0)	118	1.05	(26.7)
0.50	(12.5)	121	1.00	(25.5)

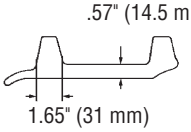
Undercarriage Code: 450, 451

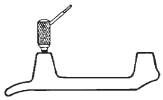
227, 229, 231, 225 S.A., LL225 — 8.00" (203.2 mm)

Track Shoes

Double Grouser







Depth Gauge Inches	Depth Gauge (mm)	High Impact % Worn	Low Impact % Worn	Ultrasonic Inches	Ultrasonic (mm)
1.65	(42.0)	0	0	2.20	(55.9)
1.60	(40.5)	6	5	2.15	(54.6)
1.55	(39.5)	12	10	2.10	(53.3)
1.50	(38.0)	18	15	2.05	(52.1)
1.45	(37.0)	24	20	2.00	(50.8)
1.40	(35.5)	30	25	1.95	(49.5)
1.35	(34.5)	36	30	1.90	(48.3)
1.30	(33.0)	42	35	1.85	(47.0)
1.25	(32.0)	48	40	1.80	(45.7)
1.20	(30.5)	54	44	1.75	(44.5)
1.15	(29.0)	60	48	1.70	(43.2)
1.10	(28.0)	65	52	1.65	(41.9)
1.05	(26.5)	70	56	1.60	(40.6)
1.00	(25.5)	75	60	1.55	(39.4)
0.95	(24.0)	80	64	1.50	(38.1)
0.90	(23.0)	85	68	1.45	(36.8)
0.85	(21.5)	90	72	1.40	(35.6)
0.80	(20.5)	95	76	1.35	(34.3)
0.75	(19.0)	100	80	1.30	(33.0)
0.70	(18.0)	105	84	1.25	(31.8)
0.65	(16.5)	110	88	1.20	(30.5)
0.60	(15.0)	115	92	1.15	(29.2)
0.55	(14.0)	120	96	1.10	(27.9)
0.50	(12.5)		100	1.05	(26.7)
0.45	(11.5)		104	1.00	(25.4)
0.40	(10.0)		108	0.95	(24.1)
0.35	(9.0)		112	0.90	(22.9)
0.30	(7.5)		116	0.85	(21.6)
0.25	(6.5)		120	0.80	(20.3)

Undercarriage Code: 458, 460, 462, 463, 472, 473

235, LL235 — 8.50" (215.9 mm)

Bushings for Sealed Track

External Wear

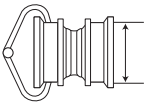
Caliper		Allowable Wear		Ultrasonic	
		Lesser	Greater		
Inches	(mm)	% Worn	% Worn	Inches	(mm)
2.83	(71.9)	0	0	0.46	(11.7)
2.82	(71.6)	9	7	0.45	(11.4)
2.81	(71.4)	18	14	0.44	(11.2)
2.80	(71.1)	27	21	0.43	(10.9)
2.79	(70.9)	36	28	0.42	(10.7)
2.78	(70.6)	45	35	0.41	(10.4)
2.77	(70.4)	54	42	0.40	(10.2)
2.76	(70.1)	63	49	0.39	(9.9)
2.75	(69.9)	72	56	0.38	(9.7)
2.74	(69.6)	81	63	0.37	(9.4)
2.73	(69.3)	88	70	0.36	(9.1)
2.72	(69.1)	92	73	0.35	(8.9)
2.71	(68.8)	96	76	0.34	(8.6)
2.70	(68.6)	100	79	0.33	(8.4)
2.69	(68.3)	104	82	0.32	(8.1)
2.68	(68.1)	108	85	0.31	(7.9)
2.67	(67.8)	112	88	0.30	(7.6)
2.66	(67.6)	116	91	0.29	(7.4)
2.65	(67.3)	120	94	0.28	(7.1)
2.64	(67.1)		97	0.27	(6.9)
2.63	(66.8)		100	0.26	(6.6)
2.62	(66.5)		103	0.25	(6.4)
2.61	(66.3)		106	0.24	(6.1)
2.60	(66.0)		109	0.23	(5.8)
2.59	(65.8)		112	0.22	(5.6)
2.58	(65.5)		115	0.21	(5.3)
2.57	(65.3)		118	0.20	(5.1)
2.56	(65.0)		121	0.19	(4.8)

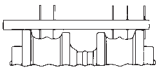
Undercarriage Code: 481, 482, 483, 484, 485, 486

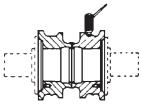
235, LL235 — 8.50" (215.9 mm)

Track Rollers

8E Rim







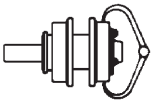
Caliper Inches	Caliper (mm)	% Worn	Depth Gauge Inches	Depth Gauge (mm)	Ultrasonic Inches	Ultrasonic (mm)
6.69	(170.0)	0	0.69	(17.5)	1.73	(43.9)
6.65	(169.0)	5	0.71	(18.0)	1.71	(43.4)
6.61	(168.0)	10	0.73	(18.5)	1.69	(42.9)
6.57	(167.0)	15	0.75	(19.0)	1.67	(42.4)
6.53	(166.0)	20	0.77	(19.5)	1.65	(41.9)
6.49	(165.0)	25	0.79	(20.0)	1.63	(41.4)
6.45	(164.0)	30	0.81	(20.5)	1.61	(40.9)
6.41	(163.0)	35	0.83	(21.0)	1.59	(40.4)
6.37	(162.0)	40	0.85	(21.5)	1.57	(39.9)
6.33	(161.0)	45	0.87	(22.0)	1.55	(39.4)
6.29	(160.0)	50	0.89	(22.5)	1.53	(38.9)
6.25	(159.0)	55	0.91	(23.0)	1.51	(38.4)
6.21	(157.5)	60	0.93	(23.5)	1.49	(37.8)
6.17	(156.5)	65	0.95	(24.0)	1.47	(37.3)
6.13	(155.5)	70	0.97	(24.5)	1.45	(36.8)
6.09	(154.5)	75	0.99	(25.0)	1.43	(36.3)
6.05	(153.5)	80	1.01	(25.5)	1.41	(35.8)
6.01	(152.5)	85	1.03	(26.0)	1.39	(35.3)
5.97	(151.5)	88	1.05	(26.5)	1.37	(34.8)
5.93	(150.5)	91	1.07	(27.0)	1.35	(34.3)
5.89	(149.5)	94	1.09	(27.5)	1.33	(33.8)
5.85	(148.5)	97	1.11	(28.0)	1.31	(33.3)
5.81	(147.5)	100	1.13	(28.5)	1.29	(32.8)
5.77	(146.5)	103	1.15	(29.0)	1.27	(32.3)
5.73	(145.5)	106	1.17	(29.5)	1.25	(31.8)
5.69	(144.5)	109	1.19	(30.0)	1.23	(31.2)
5.65	(143.5)	112	1.21	(30.5)	1.21	(30.7)
5.61	(142.5)	115	1.23	(31.0)	1.19	(30.2)
5.57	(141.5)	118	1.25	(32.0)	1.17	(29.7)
5.53	(140.5)	121	1.27	(32.5)	1.15	(29.2)

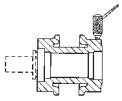
Flange diameter is 8.07" (205 mm)

Undercarriage Code: 484, 486

235 — 8.00" (203.2 mm)

Carrier Rollers





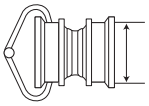
Caliper			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
7.38	(187.5)	0	1.86	(47.2)
7.34	(186.5)	5	1.84	(46.7)
7.30	(185.5)	10	1.82	(46.2)
7.26	(184.5)	15	1.80	(45.7)
7.22	(183.5)	20	1.78	(45.2)
7.18	(182.5)	25	1.76	(44.7)
7.14	(181.5)	30	1.74	(44.2)
7.10	(180.5)	35	1.72	(43.7)
7.06	(179.5)	40	1.70	(43.2)
7.02	(178.5)	45	1.68	(42.7)
6.98	(177.5)	50	1.66	(42.2)
6.94	(176.5)	55	1.64	(41.7)
6.90	(175.5)	60	1.62	(41.1)
6.86	(174.0)	65	1.60	(40.6)
6.82	(173.0)	70	1.58	(40.1)
6.78	(172.0)	75	1.56	(39.6)
6.74	(171.0)	79	1.54	(39.1)
6.70	(170.0)	82	1.52	(38.6)
6.66	(169.0)	85	1.50	(38.1)
6.62	(168.0)	88	1.48	(37.6)
6.58	(167.0)	91	1.46	(37.1)
6.54	(166.0)	94	1.44	(36.6)
6.50	(165.0)	97	1.42	(36.1)
6.46	(164.0)	100	1.40	(35.6)
6.42	(163.0)	103	1.38	(35.1)
6.38	(162.0)	106	1.36	(34.5)
6.34	(161.0)	109	1.34	(34.0)
6.30	(160.0)	112	1.32	(33.5)
6.26	(159.0)	115	1.30	(33.0)
6.22	(158.0)	118	1.28	(32.5)
6.18	(157.0)	121	1.26	(32.0)

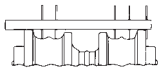
Undercarriage Code: 480

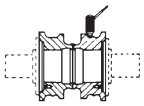
245 — 10.25" (260.4 mm)

Track Rollers

8E Rim







Caliper Inches	Caliper (mm)	% Worn	Depth Gauge Inches	Depth Gauge (mm)	Ultrasonic Inches	Ultrasonic (mm)
9.84	(250.0)	0	0.78	(20.0)	2.87	(72.9)
9.80	(249.0)	4	0.80	(20.5)	2.85	(72.4)
9.76	(248.0)	8	0.82	(21.0)	2.83	(71.9)
9.72	(247.0)	12	0.84	(21.5)	2.81	(71.4)
9.68	(246.0)	16	0.86	(22.0)	2.79	(70.9)
9.64	(245.0)	20	0.88	(22.5)	2.77	(70.4)
9.60	(244.0)	24	0.90	(23.0)	2.75	(69.9)
9.56	(243.0)	28	0.92	(23.5)	2.73	(69.3)
9.52	(242.0)	32	0.94	(24.0)	2.71	(68.8)
9.48	(241.0)	36	0.96	(24.5)	2.69	(68.3)
9.44	(240.0)	40	0.98	(25.0)	2.67	(67.8)
9.40	(239.0)	44	1.00	(25.5)	2.65	(67.3)
9.36	(237.5)	48	1.02	(26.0)	2.63	(66.8)
9.32	(236.5)	52	1.04	(26.5)	2.61	(66.3)
9.28	(235.5)	56	1.06	(27.0)	2.59	(65.8)
9.24	(234.5)	60	1.08	(27.5)	2.57	(65.3)
9.20	(233.5)	64	1.10	(28.0)	2.55	(64.8)
9.16	(232.5)	68	1.12	(28.5)	2.53	(64.3)
9.12	(231.5)	72	1.14	(29.0)	2.51	(63.8)
9.08	(230.5)	76	1.16	(29.5)	2.49	(63.2)
9.04	(229.5)	80	1.18	(30.0)	2.47	(62.7)
9.00	(228.5)	84	1.20	(30.5)	2.45	(62.2)
8.96	(227.5)	88	1.22	(31.0)	2.43	(61.7)
8.92	(226.5)	92	1.24	(31.5)	2.41	(61.2)
8.88	(225.5)	96	1.26	(32.0)	2.39	(60.7)
8.84	(224.5)	100	1.28	(32.5)	2.37	(60.2)
8.80	(223.5)	103	1.30	(33.0)	2.35	(59.7)
8.76	(222.5)	106	1.32	(33.5)	2.33	(59.2)
8.72	(221.5)	109	1.34	(34.0)	2.31	(58.7)
8.68	(220.5)	112	1.36	(34.5)	2.29	(58.2)
8.64	(219.5)	115	1.38	(35.0)	2.27	(57.7)
8.60	(218.5)	118	1.40	(35.5)	2.25	(57.2)
8.56	(217.5)	121	1.42	(36.0)	2.23	(56.6)

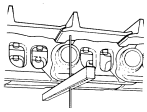
Flange diameter is 11.42" (290 mm)

Undercarriage Code: 492, 493

E70B — 5.31" (135 mm)

Track Links

931969 & 70



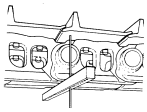
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
2.91	(74.0)	0	0.78	(19.8)
2.89	(73.5)	9	0.76	(19.3)
2.87	(73.0)	18	0.74	(18.8)
2.85	(72.5)	27	0.72	(18.3)
2.83	(72.0)	36	0.70	(17.8)
2.81	(71.5)	45	0.68	(17.3)
2.79	(71.0)	54	0.66	(16.8)
2.77	(70.5)	63	0.64	(16.3)
2.75	(70.0)	72	0.62	(15.7)
2.73	(69.5)	79	0.60	(15.2)
2.71	(69.0)	86	0.58	(14.7)
2.69	(68.5)	93	0.56	(14.2)
2.67	(68.0)	100	0.54	(13.7)
2.65	(67.5)	107	0.52	(13.2)
2.63	(67.0)	114	0.50	(12.7)
2.61	(66.5)	121	0.48	(12.2)

Undercarriage Code: 500, 501

E120B, E110B — 6.75" (171.5 mm)

Track Links

4I7475 & 76



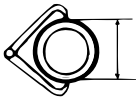
Depth Gauge			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
3.54	(90.0)	0	0.97	(24.6)
3.52	(89.5)	9	0.95	(24.1)
3.50	(89.0)	18	0.93	(23.6)
3.48	(88.5)	27	0.91	(23.1)
3.46	(88.0)	36	0.89	(22.6)
3.44	(87.5)	45	0.87	(22.1)
3.42	(87.0)	54	0.85	(21.6)
3.40	(86.5)	63	0.83	(21.1)
3.38	(86.0)	72	0.81	(20.6)
3.36	(85.5)	79	0.79	(20.1)
3.34	(85.0)	86	0.77	(19.6)
3.32	(84.5)	93	0.75	(19.1)
3.30	(84.0)	100	0.73	(18.5)
3.28	(83.5)	107	0.71	(18.0)
3.26	(83.0)	114	0.69	(17.5)
3.24	(82.5)	121	0.67	(17.0)

Undercarriage Code: 515, 530

E140 — 6.75" (171.5 mm)

Bushings for Sealed Track

External Wear

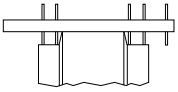


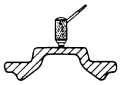
Caliper			Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)
1.99	(50.5)	0	0.32	(8.1)
1.98	(50.3)	8	0.31	(7.9)
1.97	(50.0)	16	0.30	(7.6)
1.96	(49.8)	24	0.29	(7.4)
1.95	(49.5)	32	0.28	(7.1)
1.94	(49.3)	40	0.27	(6.9)
1.93	(49.0)	48	0.26	(6.6)
1.92	(48.8)	56	0.25	(6.4)
1.91	(48.5)	64	0.24	(6.1)
1.90	(48.3)	72	0.23	(5.8)
1.89	(48.0)	76	0.22	(5.6)
1.88	(47.8)	80	0.21	(5.3)
1.87	(47.5)	84	0.20	(5.1)
1.86	(47.2)	88	0.19	(4.8)
1.85	(47.0)	92	0.18	(4.6)
1.84	(46.7)	96	0.17	(4.3)
1.83	(46.5)	100	0.16	(4.1)
1.82	(46.2)	104	0.15	(3.8)
1.81	(46.0)	108	0.14	(3.6)
1.80	(45.7)	112	0.13	(3.3)
1.79	(45.5)	116	0.12	(3.0)
1.78	(45.2)	120	0.11	(2.8)

Undercarriage Code: 545

EL180, E180 — 6.91" (175.5 mm)

Idlers





Depth Gauge Inches	(mm)	% Worn
0.76	(19.5)	0
0.78	(20.0)	12
0.80	(20.5)	24
0.82	(21.0)	36
0.84	(21.5)	48
0.86	(22.0)	60
0.88	(22.5)	72
0.90	(23.0)	76
0.92	(23.5)	80
0.94	(24.0)	84
0.96	(24.5)	88
0.98	(25.0)	92
1.00	(25.5)	96
1.02	(26.0)	100
1.04	(26.5)	104
1.06	(27.0)	108
1.08	(27.5)	112
1.10	(28.0)	116
1.12	(28.5)	120

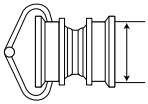
Flange width: 3.31" (84.0 mm)

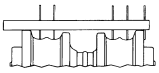
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
0.38	(9.7)	0.00	(0.0)
0.36	(9.1)	0.02	(0.5)
0.34	(8.6)	0.04	(1.0)
0.32	(8.1)	0.06	(1.5)
0.30	(7.6)	0.08	(2.0)
0.28	(7.1)	0.10	(2.5)
0.26	(6.6)	0.12	(3.0)
0.24	(6.1)	0.14	(3.5)
0.22	(5.6)	0.16	(4.0)
0.20	(5.1)	0.18	(4.5)
0.18	(4.6)	0.20	(5.0)
0.16	(4.1)	0.22	(5.5)
0.14	(3.6)	0.24	(6.0)
0.12	(3.0)	0.26	(6.5)
0.10	(2.5)	0.28	(7.0)
0.08	(2.0)	0.30	(7.5)
0.06	(1.5)	0.32	(8.0)
0.04	(1.0)	0.34	(8.5)
0.02	(0.5)	0.36	(9.0)

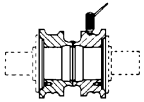
NOTE: Ultrasonic measurement is to determine flange wear only.

EL200B, E200B — 7.50" (190 mm)

Track Rollers







Caliper			Depth Gauge		Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)	Inches	(mm)
5.90	(150.0)	0	0.69	(17.5)	1.69	(42.9)
5.88	(149.5)	5	0.70	(18.0)	1.68	(42.7)
5.86	(149.0)	10	0.71	(18.0)	1.67	(42.4)
5.84	(148.5)	15	0.72	(18.5)	1.66	(42.2)
5.82	(148.0)	20	0.73	(18.5)	1.65	(41.9)
5.80	(147.5)	25	0.74	(19.0)	1.64	(41.7)
5.78	(147.0)	30	0.75	(19.0)	1.63	(41.4)
5.76	(146.5)	35	0.76	(19.5)	1.62	(41.1)
5.74	(146.0)	40	0.77	(19.5)	1.61	(40.9)
5.72	(145.5)	43	0.78	(20.0)	1.60	(40.6)
5.70	(145.0)	46	0.79	(20.0)	1.59	(40.4)
5.68	(144.5)	49	0.80	(20.5)	1.58	(40.1)
5.66	(144.0)	52	0.81	(20.5)	1.57	(39.9)
5.64	(143.5)	55	0.82	(21.0)	1.56	(39.6)
5.62	(142.5)	58	0.83	(21.0)	1.55	(39.4)
5.60	(142.0)	61	0.84	(21.5)	1.54	(39.1)
5.58	(141.5)	64	0.85	(21.5)	1.53	(38.9)
5.56	(141.0)	67	0.86	(22.0)	1.52	(38.6)
5.54	(140.5)	70	0.87	(22.0)	1.51	(38.4)
5.52	(140.0)	73	0.88	(22.5)	1.50	(38.1)
5.50	(139.5)	76	0.89	(22.5)	1.49	(37.8)
5.48	(139.0)	79	0.90	(23.0)	1.48	(37.6)
5.46	(138.5)	82	0.91	(23.0)	1.47	(37.3)
5.44	(138.0)	85	0.92	(23.5)	1.46	(37.1)
5.42	(137.5)	88	0.93	(23.5)	1.45	(36.8)
5.40	(137.0)	91	0.94	(24.0)	1.44	(36.6)
5.38	(136.5)	94	0.95	(24.0)	1.43	(36.3)
5.36	(136.0)	97	0.96	(24.5)	1.42	(36.1)
5.34	(135.5)	100	0.97	(24.5)	1.41	(35.8)
5.32	(135.0)	103	0.98	(25.0)	1.40	(35.6)
5.30	(134.5)	106	0.99	(25.0)	1.39	(35.3)
5.28	(134.0)	109	1.00	(25.5)	1.38	(35.1)
5.26	(133.5)	112	1.01	(25.5)	1.37	(34.8)
5.24	(133.0)	115	1.02	(26.0)	1.36	(34.5)
5.22	(132.5)	118	1.03	(26.0)	1.35	(34.3)
5.20	(132.0)	121	1.04	(26.5)	1.34	(34.0)

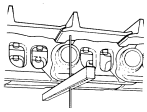
Flange diameter is 7.28" (185 mm)

Undercarriage Code: 565

E300B, EL300B, EL300 — 8.00" (203.2 mm)

Track Links

960263 & 64



Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
4.58	(116.5)	0	1.22	(31.0)
4.56	(116.0)	7	1.20	(30.5)
4.54	(115.5)	14	1.18	(30.0)
4.52	(115.0)	21	1.16	(29.5)
4.50	(114.5)	28	1.14	(29.0)
4.48	(114.0)	35	1.12	(28.4)
4.46	(113.5)	42	1.10	(27.9)
4.44	(113.0)	49	1.08	(27.4)
4.42	(112.5)	56	1.06	(26.9)
4.40	(112.0)	63	1.04	(26.4)
4.38	(111.5)	70	1.02	(25.9)
4.36	(110.5)	75	1.00	(25.4)
4.34	(110.0)	80	0.98	(24.9)
4.32	(109.5)	85	0.96	(24.4)
4.30	(109.0)	90	0.94	(23.9)
4.28	(108.5)	95	0.92	(23.4)
4.26	(108.0)	100	0.90	(22.9)
4.24	(107.5)	105	0.88	(22.4)
4.22	(107.0)	110	0.86	(21.8)
4.20	(106.5)	115	0.84	(21.3)
4.18	(106.0)	120	0.82	(20.8)

Undercarriage Code: 607, 608

Bushings for Sealed Track

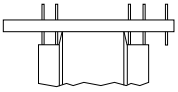
External Wear

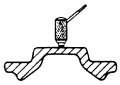
Caliper		Allowable Wear		Ultrasonic	
		Lesser	Greater		
Inches	(mm)	% Worn	% Worn	Inches	(mm)
2.32	(58.9)	0	0	0.40	(10.2)
2.31	(58.7)	10	7	0.39	(9.9)
2.30	(58.4)	20	14	0.38	(9.7)
2.29	(58.2)	30	21	0.37	(9.4)
2.28	(57.9)	40	28	0.36	(9.1)
2.27	(57.7)	50	35	0.35	(8.9)
2.26	(57.4)	60	42	0.34	(8.6)
2.25	(57.2)	70	49	0.33	(8.4)
2.24	(56.9)	80	56	0.32	(8.1)
2.23	(56.6)	90	63	0.31	(7.9)
2.22	(56.4)	95	68	0.30	(7.6)
2.21	(56.1)	100	72	0.29	(7.4)
2.20	(55.9)	105	76	0.28	(7.1)
2.19	(55.6)	110	80	0.27	(6.9)
2.18	(55.4)	115	84	0.26	(6.6)
2.17	(55.1)	120	88	0.25	(6.4)
2.16	(54.9)		92	0.24	(6.1)
2.15	(54.6)		96	0.23	(5.8)
2.14	(54.4)		100	0.22	(5.6)
2.13	(54.1)		104	0.21	(5.3)
2.12	(53.8)		108	0.20	(5.1)
2.11	(53.6)		112	0.19	(4.8)
2.10	(53.3)		116	0.18	(4.6)
2.09	(53.1)		120	0.17	(4.3)

Undercarriage Code: 605, 606

E450 — 8.50" (215.9 mm)

Idlers





Depth Gauge Inches	(mm)	% Worn
0.88	(22.5)	0
0.90	(23.0)	7
0.92	(23.5)	14
0.94	(24.0)	21
0.96	(24.5)	28
0.98	(25.0)	35
1.00	(25.5)	40
1.02	(26.0)	45
1.04	(26.5)	50
1.06	(27.0)	55
1.08	(27.5)	60
1.10	(28.0)	65
1.12	(28.5)	70
1.14	(29.0)	75
1.16	(29.5)	80
1.18	(30.0)	85
1.20	(30.5)	90
1.22	(31.0)	95
1.24	(31.5)	100
1.26	(32.0)	105
1.28	(32.5)	110
1.30	(33.0)	115
1.32	(33.5)	120

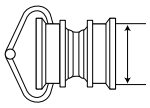
Flange width: 4.02" (102 mm)

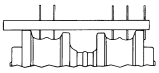
Ultrasonic Inches	(mm)	Center Flange Wear Inches	(mm)
1.06	(26.9)	0.00	(0.0)
1.04	(26.4)	0.02	(0.5)
1.02	(25.9)	0.04	(1.0)
1.00	(25.4)	0.06	(1.5)
0.98	(24.9)	0.08	(2.0)
0.96	(24.4)	0.10	(2.5)
0.94	(23.9)	0.12	(3.0)
0.92	(23.4)	0.14	(3.5)
0.90	(22.9)	0.16	(4.0)
0.88	(22.4)	0.18	(4.5)
0.86	(21.8)	0.20	(5.0)
0.84	(21.3)	0.22	(5.5)
0.82	(20.8)	0.24	(6.0)
0.80	(20.3)	0.26	(6.5)
0.78	(19.8)	0.28	(7.0)
0.76	(19.3)	0.30	(7.5)
0.74	(18.8)	0.32	(8.0)
0.72	(18.3)	0.34	(8.5)
0.70	(17.8)	0.36	(9.0)
0.68	(17.3)	0.38	(9.5)
0.66	(16.8)	0.40	(10.0)
0.64	(16.3)	0.42	(10.5)
0.62	(15.7)	0.44	(11.0)

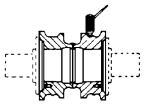
NOTE: Ultrasonic measurement is to determine flange wear only.

E650 — 9.00" (228.7 mm)

Track Rollers







Caliper			Depth Gauge		Ultrasonic	
Inches	(mm)	% Worn	Inches	(mm)	Inches	(mm)
10.63	(270.0)	0	1.07	(27.0)	2.95	(74.9)
10.59	(269.0)	5	1.09	(27.5)	2.93	(74.4)
10.55	(268.0)	10	1.11	(28.0)	2.91	(73.9)
10.51	(267.0)	15	1.13	(28.5)	2.89	(73.4)
10.47	(266.0)	20	1.15	(29.0)	2.87	(72.9)
10.43	(265.0)	25	1.17	(29.5)	2.85	(72.4)
10.39	(264.0)	30	1.19	(30.0)	2.83	(71.9)
10.35	(263.0)	35	1.21	(30.5)	2.81	(71.4)
10.31	(262.0)	40	1.23	(31.0)	2.79	(70.9)
10.27	(261.0)	45	1.25	(32.0)	2.77	(70.4)
10.23	(260.0)	50	1.27	(32.5)	2.75	(69.9)
10.19	(259.0)	55	1.29	(33.0)	2.73	(69.3)
10.15	(258.0)	60	1.31	(33.5)	2.71	(68.8)
10.11	(257.0)	64	1.33	(34.0)	2.69	(68.3)
10.07	(256.0)	68	1.35	(34.5)	2.67	(67.8)
10.03	(255.0)	72	1.37	(35.0)	2.65	(67.3)
9.99	(253.5)	76	1.39	(35.5)	2.63	(66.8)
9.95	(252.5)	80	1.41	(36.0)	2.61	(66.3)
9.91	(251.5)	84	1.43	(36.5)	2.59	(65.8)
9.87	(250.5)	88	1.45	(37.0)	2.57	(65.3)
9.83	(249.5)	92	1.47	(37.5)	2.55	(64.8)
9.79	(248.5)	96	1.49	(38.0)	2.53	(64.3)
9.75	(247.5)	100	1.51	(38.5)	2.51	(63.8)
9.71	(246.5)	104	1.53	(39.0)	2.49	(63.2)
9.67	(245.5)	108	1.55	(39.5)	2.47	(62.7)
9.63	(244.5)	112	1.57	(40.0)	2.45	(62.2)
9.59	(243.5)	116	1.59	(40.5)	2.43	(61.7)
9.55	(242.5)	120	1.61	(41.0)	2.41	(61.2)

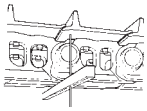
Flange diameter is 12.78" (324.5 mm)

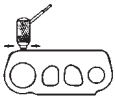
Undercarriage Code: 640

AP1050 — 6.125" (155.6 mm)

Track Links

6Y0935 & 36





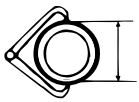
Depth Gauge Inches	Depth Gauge (mm)	% Worn	Ultrasonic Inches	Ultrasonic (mm)
3.46	(88.0)	0	1.00	(25.4)
3.44	(87.5)	13	0.98	(24.9)
3.42	(87.0)	26	0.96	(24.4)
3.40	(86.5)	39	0.94	(23.9)
3.38	(86.0)	52	0.92	(23.4)
3.36	(85.5)	65	0.90	(22.9)
3.34	(85.0)	78	0.88	(22.4)
3.32	(84.5)	90	0.86	(21.8)
3.30	(84.0)	100	0.84	(21.3)
3.28	(83.5)	110	0.82	(20.8)
3.26	(83.0)	120	0.80	(20.3)

Undercarriage Code: 790

PR450B, SF350, SF250B, TR225B — 6.125" (155.6 mm)

Track Bushings for Sealed Track

External Wear



Caliper		Allowable Wear		Ultrasonic	
		Lesser	Greater		
Inches	(mm)	% Worn	% Worn	Inches	(mm)
1.97	(50.0)	0	0	0.40	(10.2)
1.96	(49.8)	8	6	0.39	(9.9)
1.95	(49.5)	16	12	0.38	(9.7)
1.94	(49.3)	24	18	0.37	(9.4)
1.93	(49.0)	32	24	0.36	(9.1)
1.92	(48.8)	40	30	0.35	(8.9)
1.91	(48.5)	48	36	0.34	(8.6)
1.90	(48.3)	56	42	0.33	(8.4)
1.89	(48.0)	64	48	0.32	(8.1)
1.88	(47.8)	72	54	0.31	(7.9)
1.87	(47.5)	76	60	0.30	(7.6)
1.86	(47.2)	80	64	0.29	(7.4)
1.85	(47.0)	84	67	0.28	(7.1)
1.84	(46.7)	88	70	0.27	(6.9)
1.83	(46.5)	92	73	0.26	(6.6)
1.82	(46.2)	96	76	0.25	(6.4)
1.81	(46.0)	100	79	0.24	(6.1)
1.80	(45.7)	104	82	0.23	(5.8)
1.79	(45.5)	108	85	0.22	(5.6)
1.78	(45.2)	112	88	0.21	(5.3)
1.77	(45.0)	116	91	0.20	(5.1)
1.76	(44.7)	120	94	0.19	(4.8)
1.75	(44.5)		97	0.18	(4.6)
1.74	(44.2)		100	0.17	(4.3)
1.73	(43.9)		103	0.16	(4.1)
1.72	(43.7)		106	0.15	(3.8)
1.71	(43.4)		109	0.14	(3.6)
1.70	(43.2)		112	0.13	(3.3)
1.69	(42.9)		115	0.12	(3.0)
1.68	(42.7)		118	0.11	(2.8)
1.67	(42.4)		121	0.10	(2.5)

Undercarriage Code: 700, 730, 740, 770