

**CATERPILLAR®**

# **Custom Track Service Handbook**



**CUSTOM  
TRACK  
SERVICE**

**15th edition**

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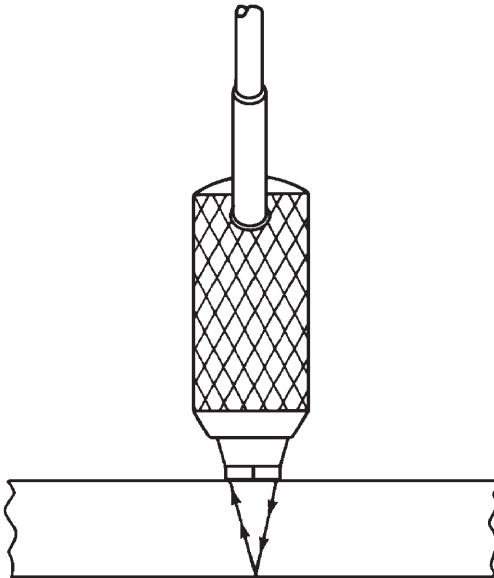
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### Ultrasonic Wear Indicator

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



# General Information

## VIBRATION

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.

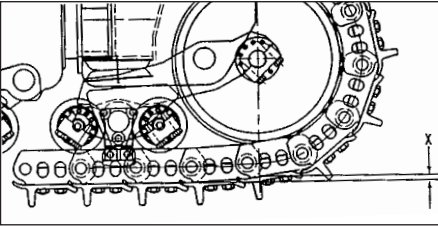


Illustration 3. Measurement points on a soft surface.

**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.

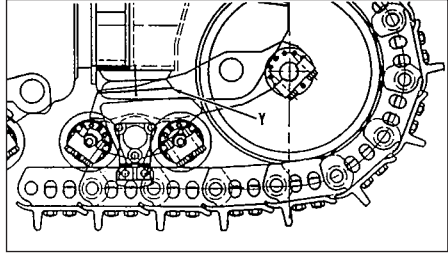


Illustration 4. Add plates at point Y.

| 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

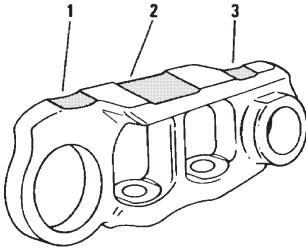
Prior to adding plates under the bogie pads, raise the machine until the bogies are hanging free. Carefully support the machine. See the disassembly and assembly module in your machine's Service Manual for the correct procedure.

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.

# General Information

## LINKS



### 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).

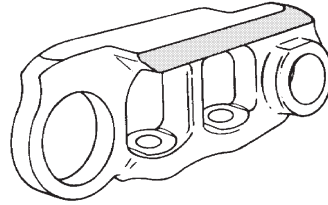
CAUSES: No. 2: Sliding wear due to reduced contact area with idler at center of link rail.

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.



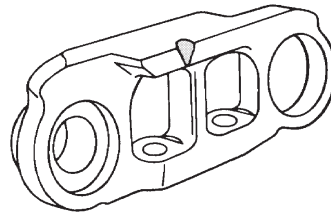
### Rail Side Wear (inside and/or outside)

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.



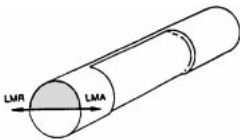
### Rail Inside Gouged

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.



### Pin Boss Side Wear

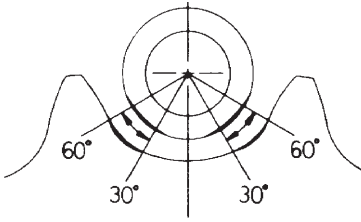
CAUSES: Sliding contact with guiding and/or roller guards plus abrasives (may be seen at either or both ends of pin — usually more severe on outboard side).

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.

## General Information

### SEALED & LUBRICATED TRACK PINS & BUSHINGS



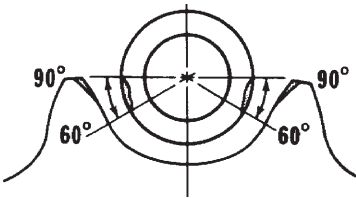
#### Reverse and/or Forward Drive Side (30° to 60° from vertical)

**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.



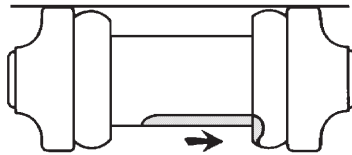
#### Reverse and/or Forward Drive Side Pocket Wear (60° to 90° from vertical)

**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.



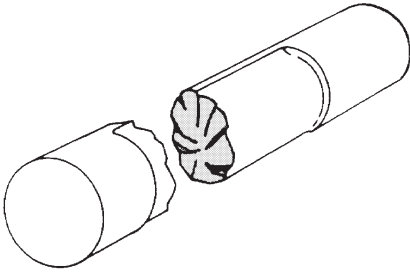
#### Off Center Wear

**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.

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#### 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.**

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# General Information

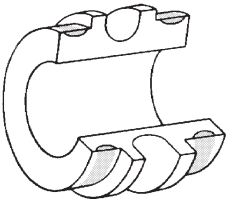
## CARRIER ROLLERS

### 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.



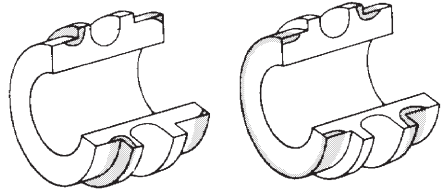
#### Tread Wear (Uniform)

**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

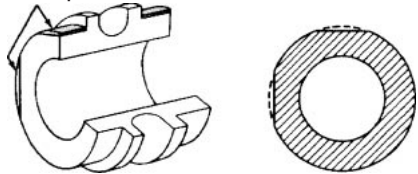
**CAUSES:** Rolling and sliding contact with link rail top and sides not aligned with carrier roller.

**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

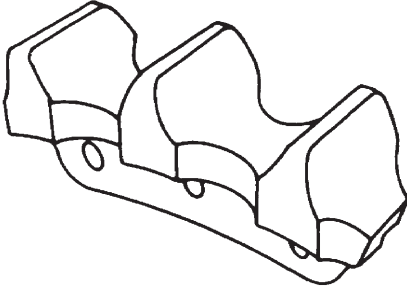
**CAUSES:** Sliding contact with link rail tops when carrier roller not turning.

**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.

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#### 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.

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INSPECTION REPORT

RECOMMENDATION CHECKLIST AND TOTAL LIFE SCALES

| ITEM                                               | AT SMU or DATE                | ITEM                                                                                                                                                                                                                         | POSITION                      | AT SMU or DATE |
|----------------------------------------------------|-------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|----------------|
| LINK ASSEMBLY:                                     |                               | TRACK ROLLERS:                                                                                                                                                                                                               |                               |                |
| REPAIR DRY JOINTS .....                            |                               | F 2 3 4 5 6 7 8                                                                                                                                                                                                              |                               |                |
| TURN PINS & BUSHINGS .....                         |                               | WELD TREAD (✓) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>       |                               |                |
| REPLACE PINS & BUSHINGS .....                      |                               | RESHELL (✓) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>          |                               |                |
| TURN BUSHINGS WET .....                            |                               | SWAP-L HAND* <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>         |                               |                |
| REPLACE BUSHING/SEALS .....                        |                               | SWAP-R HAND* <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>         |                               |                |
| TURN BUSHINGS DRY .....                            |                               | SWAP-L TO R* <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>         |                               |                |
| SWAP SIDES .....                                   |                               | *WRITE-IN NEW POSITIONS                                                                                                                                                                                                      |                               |                |
| REPLACE WITH NEW .....                             |                               | SPIN IN PLACE (✓) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>    |                               |                |
| ADJUST TENSION <input type="checkbox"/>            |                               | TRIM FLANGES (✓) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>                              |                               |                |
| SHOES:                                             |                               | REPLACE WITH NEW (✓) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |                               |                |
| REGROUSER .....                                    |                               | EXCHANGE AVAILABLE: WELDED <input type="checkbox"/> RESHELLED <input type="checkbox"/>                                                                                                                                       |                               |                |
| REPLACE WITH NEW .....                             |                               | SPROCKETS/SEGMENTS:                                                                                                                                                                                                          |                               |                |
| TYPE: _____ LENGTH: _____                          |                               | REPLACE AT TURN <input type="checkbox"/> REUSE AT TURN <input type="checkbox"/> TIME: _____                                                                                                                                  |                               |                |
| IDLERS:                                            |                               | REPLACE AT PIN/BUSHING REPLACEMENT TIME: _____                                                                                                                                                                               |                               |                |
| WELD TREADS .....                                  |                               | REPLACE AT NEW LINK ASSEMBLY TIME: _____                                                                                                                                                                                     |                               |                |
| SWAP SIDES .....                                   |                               | GUARDS:                                                                                                                                                                                                                      |                               |                |
| SWAP FRONT/REAR .....                              |                               | GUIDING - END <input type="checkbox"/> CENTER <input type="checkbox"/>                                                                                                                                                       |                               |                |
| REPLACE WITH NEW .....                             |                               | REPLACE WEAR STRIPS: _____                                                                                                                                                                                                   |                               |                |
| WELDED EXCHANGE AVAILABLE <input type="checkbox"/> |                               | REPLACE ASSEMBLIES: _____                                                                                                                                                                                                    |                               |                |
| CARRIER ROLLERS:                                   |                               | ROLLER/ROCK: _____                                                                                                                                                                                                           |                               |                |
| RESHELL .....                                      |                               | REMOVE: _____                                                                                                                                                                                                                |                               |                |
| SWAP SIDES .....                                   |                               | REPLACE: _____                                                                                                                                                                                                               |                               |                |
| SWAP FRONT/REAR .....                              |                               | FINAL DRIVE/SPROCKET: _____                                                                                                                                                                                                  |                               |                |
| REPLACE WITH NEW .....                             |                               | REPLACE WEAR SHOE/STRI P: _____                                                                                                                                                                                              |                               |                |
| EXCHANGE AVAILABLE <input type="checkbox"/>        |                               | OTHER:                                                                                                                                                                                                                       |                               |                |
|                                                    |                               | ROLLER FRAME - ALIGN/STRAIGHTEN: _____                                                                                                                                                                                       |                               |                |
|                                                    |                               | BOGIE PADS - REPLACE: _____                                                                                                                                                                                                  |                               |                |
|                                                    |                               | HYDRAULIC ADJUSTER - REPAIR: _____                                                                                                                                                                                           |                               |                |
| OPTION 1                                           |                               | OPTION 2                                                                                                                                                                                                                     |                               |                |
| LINKS                                              | - - -   - - -   - - -   - - - | LINKS                                                                                                                                                                                                                        | - - -   - - -   - - -   - - - |                |
| BUSHINGS                                           | - - -   - - -   - - -   - - - | BUSHINGS                                                                                                                                                                                                                     | - - -   - - -   - - -   - - - |                |
| SHOES                                              | - - -   - - -   - - -   - - - | SHOES                                                                                                                                                                                                                        | - - -   - - -   - - -   - - - |                |
| IDLERS                                             | - - -   - - -   - - -   - - - | IDLERS                                                                                                                                                                                                                       | - - -   - - -   - - -   - - - |                |
| FRONT                                              | - - -   - - -   - - -   - - - | FRONT                                                                                                                                                                                                                        | - - -   - - -   - - -   - - - |                |
| REAR                                               | - - -   - - -   - - -   - - - | REAR                                                                                                                                                                                                                         | - - -   - - -   - - -   - - - |                |
| CARRIER ROLLERS                                    | - - -   - - -   - - -   - - - | CARRIER ROLLERS                                                                                                                                                                                                              | - - -   - - -   - - -   - - - |                |
| TRACK ROLLERS                                      | - - -   - - -   - - -   - - - | TRACK ROLLERS                                                                                                                                                                                                                | - - -   - - -   - - -   - - - |                |
| WORST                                              | - - -   - - -   - - -   - - - | WORST                                                                                                                                                                                                                        | - - -   - - -   - - -   - - - |                |
| SWAPPED                                            | - - -   - - -   - - -   - - - | SWAPPED                                                                                                                                                                                                                      | - - -   - - -   - - -   - - - |                |



# Management & Merchandising

## COST PER HOUR

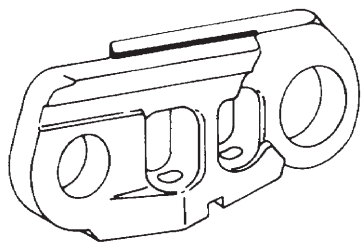
### Total Cost Per Hour of New Track Groups

|                                                      | (a.)<br>10,000                            | (b.)<br>12,000                            | (c.)<br>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)<br>8,000                          | (Once)<br>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<br>per hour of effective life | $\frac{23,200}{7,000 \text{ SMU}} = 3.31$ | $\frac{20,500}{7,000 \text{ SMU}} = 2.93$ | $\frac{15,950}{7,000 \text{ SMU}} = 2.28$ |

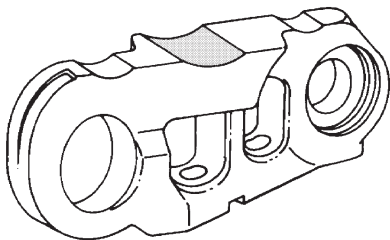
This comparison could be expanded to include respective segment, roller, carrier roller, idler and other wear part costs over the same link life or compared individually over their own respective and effective total wear lives.

# Elevated Sprocket Machines

## COMPONENTS



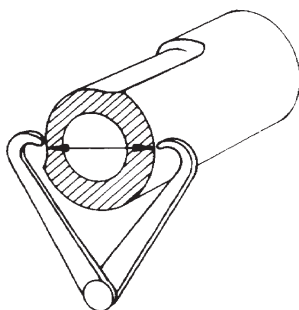
**Wear Patterns** — The undercarriage design of elevated sprocket machines and the absence of “snakiness” in Sealed and Lubricated Track allow it to “track” very straight. This straight tracking causes the roller to wear with a slight ridge running down the center of the tread. This ridge results from 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.

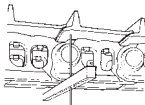
The choice between the two allowable wears for elevated sprocket machines is different because the sprocket is not subject to impact. For machines in underfoot conditions which have only fine granular materials, use the chart showing the greater allowable wear. For all other conditions use the chart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

# Elevated Sprocket Machines

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

## Track Links

Heavy Duty Track  
Rotating Bushing Track  
108-0947 & 48



| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (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) |

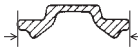
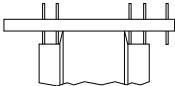
Undercarriage Code: 1108, 111, 1121, 1122, 1208, 121, 124, 125, 1251, 128, 129, 1291

# Elevated Sprocket Machines

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

## Idlers

Original Idler



5.31" (135 mm)

| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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)

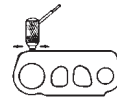
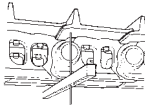
Undercarriage Code: 110, 11002, 1101, 11012, 1108, 111,  
1121, 120, 12002, 1201, 12012, 1208,  
121, 124, 1248, 12482, 125, 128, 1291

# Elevated Sprocket Machines

D5H, D6M, D6N, 517 — 7.50" (190 mm)

## Track Links

Heavy Duty Track  
Rotating Bushing Track  
106-1625 & 26



| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | 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) |

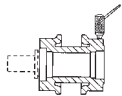
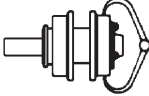
Undercarriage Code: 1338, 137, 140, 141, 1411, 144, 146, 1461, 280, 281

# Elevated Sprocket Machines

D5H, D6M, D6N, 517 — 7.50" (190 mm)

## Carrier Rollers

Use with 1061625 & 26 Heavy Duty and Rotating Bushing Track



| Caliper |         | % Worn | Ultrasonic |        |
|---------|---------|--------|------------|--------|
| Inches  | (mm)    |        | 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) |

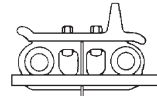
Undercarriage Code: 1338, 137, 140, 141, 1411, 144, 146, 1461, 280, 281

# Elevated Sprocket Machines

D6H, D6R, 527 — 8.00" (203.2 mm)

## Bushings for Heavy Duty Track

Use with 8E7405 & 06 Links



| Inches | Caliper<br>(mm) | Allowable Wear<br>Lesser<br>% Worn | Greater<br>% Worn | Ultrasonic<br>Inches | (mm)   | Depth Gauge<br>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."**

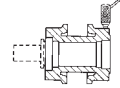
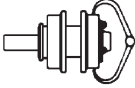
Undercarriage Code: 153, 157, 158, 1581, 163, 290, 291

# Elevated Sprocket Machines

D6H, D6R, 527 — 8.00" (203.2 mm)

## Carrier Rollers

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



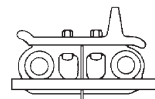
| Caliper |         | % Worn | Ultrasonic |        |
|---------|---------|--------|------------|--------|
| Inches  | (mm)    |        | Inches     | (mm)   |
| 7.38    | (187.5) | 0      | 1.86       | (47.2) |
| 7.34    | (186.5) | 4      | 1.84       | (46.7) |
| 7.30    | (185.5) | 8      | 1.82       | (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

# Elevated Sprocket Machines

D7H, D7R, 572R — 8.50" (215.9 mm)

## Bushings for Heavy Duty Track



| Caliper |        | Allowable Wear |                | Ultrasonic |        | Depth Gauge |        |
|---------|--------|----------------|----------------|------------|--------|-------------|--------|
| Inches  | (mm)   | Lesser % Worn  | Greater % Worn | Inches     | (mm)   | 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."**

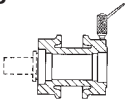
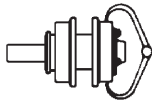
Undercarriage Code: 1642, 166, 169, 170, 1701, 173, 174, 1741

# Elevated Sprocket Machines

D7H, D7R, 572R — 8.50" (215.9 mm)

## Carrier Rollers

Use with Heavy Duty or Rotating Bushing Track



| Caliper |         | % Worn | Ultrasonic |        |
|---------|---------|--------|------------|--------|
| Inches  | (mm)    |        | 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

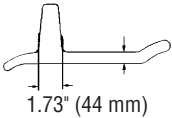
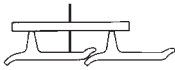
# Elevated Sprocket Machines

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

## Track Shoes

Super Extreme Service

.83" (21 mm)



| Depth Gauge |        | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic |         |
|-------------|--------|-----------------------|----------------------|------------|---------|
| Inches      | (mm)   |                       |                      | 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

# Elevated Sprocket Machines

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

## Sprockets

Do not use with D8L



| Tape Measure |         | % Worn |
|--------------|---------|--------|
| Inches       | (mm)    |        |
| 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

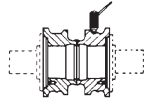
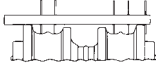
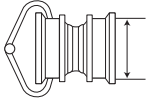
Undercarriage Code: 1785, 179, 180, 183, 184

# Elevated Sprocket Machines

D9N, D9R — 9.45" (240 mm)

## Track Rollers

### Double Flange



| Caliper |         | % Worn | Depth Gauge |        | Ultrasonic |        |
|---------|---------|--------|-------------|--------|------------|--------|
| Inches  | (mm)    |        | 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)

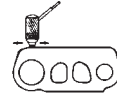
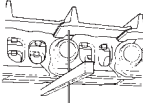
Undercarriage Code: 195, 196

# Elevated Sprocket Machines

D10N, D10R — 10.25" (260.4 mm)

## Track Links

9W5265 & 66  
7T0715 & 16



| Depth Gauge |         | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic |        |
|-------------|---------|-----------------------|----------------------|------------|--------|
| Inches      | (mm)    |                       |                      | Inches     | (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

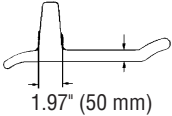
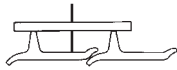
# Elevated Sprocket Machines

D10 — 10.25" (260.4 mm)

## Track Shoes

Extreme Service

.89" (22.5 mm)



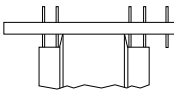
| Depth Gauge |         | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic |         |
|-------------|---------|-----------------------|----------------------|------------|---------|
| Inches      | (mm)    |                       |                      | Inches     | (mm)    |
| 4.00        | (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

# Elevated Sprocket Machines

D11N, D11R — 12.50" (317.5 mm)

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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)

|                    | Undercarriage |                                                                                    |
|--------------------|---------------|------------------------------------------------------------------------------------|
|                    | Model         | 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

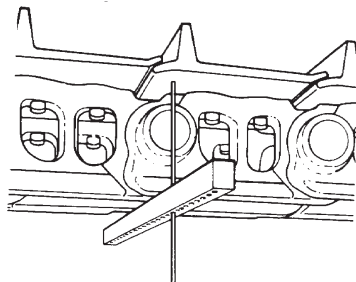
See pages 11 through 25 for details on the effects of:

|                                  | Page |
|----------------------------------|------|
| Controllable Variables           | 11   |
| Track Adjustment                 | 11   |
| Shoe Width                       | 12   |
| Alignment                        | 14   |
| Non-Controllable Variables       | 21   |
| Soil & Underfoot Conditions      | 21   |
| Underfoot Conditions             | 22   |
| Partially Controllable Variables | 25   |

### Components

#### Links

See pages 28 through 35 for detailed link information.



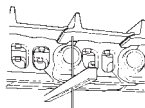
**Measurement** — Measure the track link over the centerline of the pin and bushing bores. See page 28 for details.

# Low Sprocket Machines

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

## Track Links

6S3143 & 44



| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | 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) |

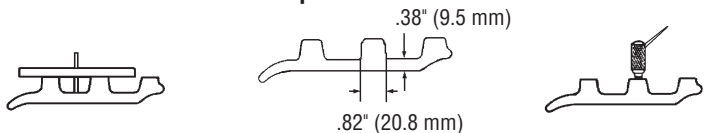
Undercarriage Code: 100

# Low Sprocket Machines

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

## Track Shoes

### Triple Grouser



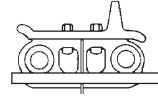
| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 0.60        | (15.0) | 0      | 1.00       | (25.4) |
| 0.55        | (14.0) | 15     | 0.95       | (24.1) |
| 0.50        | (12.5) | 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

# Low Sprocket Machines

D4, 941 — 6.75" (171.5 mm)

## Bushings for Sealed & Lubricated Track



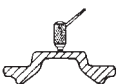
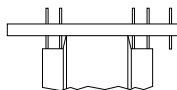
| Inches | Caliper<br>(mm) | Allowable Wear   |                   | Inches | Ultrasonic<br>(mm) | Inches | Depth Gauge<br>(mm) |
|--------|-----------------|------------------|-------------------|--------|--------------------|--------|---------------------|
|        |                 | Lesser<br>% Worn | Greater<br>% Worn |        |                    |        |                     |
| 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

# Low Sprocket Machines

D4, 941 — 6.75" (171.5 mm)

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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 |       | Center Flange Wear |       |
|------------|-------|--------------------|-------|
| Inches     | (mm)  | 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) |

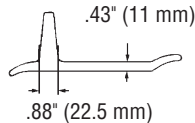
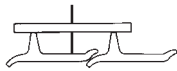
NOTE: Ultrasonic measurement is to determine flange wear only.

Undercarriage Code: 116, 118, 311, 313

# Low Sprocket Machines

D5G, D5C, 939 — 6.75" (171.5 mm)

## Track Shoes Moderate Service



| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | 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) |

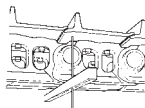
Undercarriage Code: 134, 13402, 135, 13502, 1351, 1352, 1353,  
13532, 1354, 1355, 307, 3071, 3072, 3073

# Low Sprocket Machines

D5, 955, 951, 561 — 6.91" (175.5 mm)

## Track Links

7T4539 & 40



| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (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) |

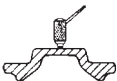
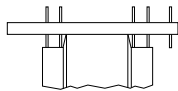
Undercarriage Code: 105, 131, 332

# Low Sprocket Machines

D5, 955, 951, 561 — 6.91" (175.5 mm)

## Idlers

(Has no side plate indentations)



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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 |       | Center Flange Wear |       |
|------------|-------|--------------------|-------|
| Inches     | (mm)  | 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.

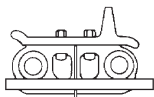
Undercarriage Code: 104, 130, 331, 350

# Low Sprocket Machines

D6, 955 — 8.00" (203.2 mm)

## Bushings for Rotating Bushing Track

Use with 8E Links



| Caliper |        | % Worn | Ultrasonic |        | Depth Gauge |        |
|---------|--------|--------|------------|--------|-------------|--------|
| Inches  | (mm)   |        | 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) |

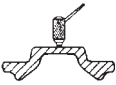
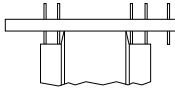
Undercarriage Code: 1551

# Low Sprocket Machines

D6, 955 — 8.00" (203.2 mm)

## Idlers

Extended Life Idlers  
(Has circular side plate indentations)



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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 |        | Center Flange Wear |        |
|------------|--------|--------------------|--------|
| Inches     | (mm)   | 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.

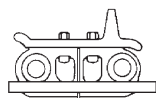
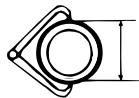
Undercarriage Code: 154, 1551, 353

# Low Sprocket Machines

D7, 977, 571, 572 — 8.50" (215.9 mm)

## Bushings for Sealed & Lubricated Track

Extended Life Bushings  
Use with current 7T Links



| Inches | Caliper<br>(mm) | Allowable Wear   |                   | Inches | Ultrasonic<br>(mm) | Depth Gauge |        |
|--------|-----------------|------------------|-------------------|--------|--------------------|-------------|--------|
|        |                 | Lesser<br>% Worn | Greater<br>% Worn |        |                    | 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) |

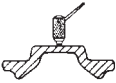
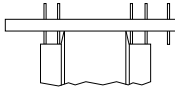
Undercarriage Code: 165, 383

# Low Sprocket Machines

D7, 977, 571, 572 — 8.50" (215.9 mm)

## Idlers

Extended Life Idlers  
(Has circular side plate indentations)



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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)

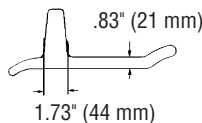
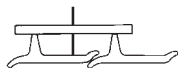
| Ultrasonic |        | Center Flange Wear |        |
|------------|--------|--------------------|--------|
| Inches     | (mm)   | Inches             | (mm)   |
| 0.48       | (12.2) | 0.00               | (0.0)  |
| 0.46       | (11.7) | 0.02               | (0.5)  |
| 0.44       | (11.2) | 0.04               | (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.

# Low Sprocket Machines

D8, 983 — 9.00" (228.6 mm)

## Track Shoes Super Extreme Service



| Depth Gauge |        | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic |         |
|-------------|--------|-----------------------|----------------------|------------|---------|
| Inches      | (mm)   |                       |                      | 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: 175, 390

# Low Sprocket Machines

D9, 594 — 10.25" (260.4 mm)

## Pins and Bushings for Sealed Track

Internal Wear



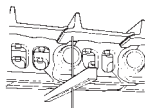
| Inches | (mm)     | % Worn |
|--------|----------|--------|
| 41.05  | (1042.5) | 0      |
| 41.10  | (1044.0) | 10     |
| 41.15  | (1045.0) | 20     |
| 41.20  | (1046.5) | 30     |
| 41.25  | (1048.0) | 40     |
| 41.30  | (1049.0) | 50     |
| 41.35  | (1050.5) | 60     |
| 41.40  | (1051.5) | 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    |

# Cat Classic Undercarriage

D5B — 6.91" (175.5 mm)

## Track Links

175-8248 & 49



| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (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) |

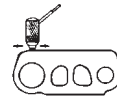
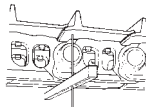
Undercarriage Code: 1315

# Cat Classic Undercarriage

D6 — 8.00" (203.2 mm)

## Track Links

175-8256 & 57



| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | 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

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- Please note: If there is no response to **CLICKING** the link, please download this PDF first and then click on it.

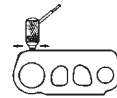
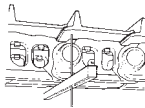
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# Cat Classic Undercarriage

D7 — 8.50" (215.9 mm)

## Track Links

188-5251 & 52



| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | 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) |

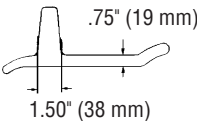
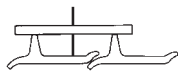
Undercarriage Code: 1655

# Cat Classic Undercarriage

D8 — 9.00" (228.7 mm)

## Track Shoes

Extreme Service



| Depth Gauge |        | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic |        |
|-------------|--------|-----------------------|----------------------|------------|--------|
| Inches      | (mm)   |                       |                      | Inches     | (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) |

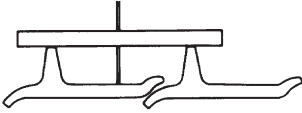
Undercarriage Code: 1755

# Hydrostatic Loaders

## COMPONENTS

### Shoes

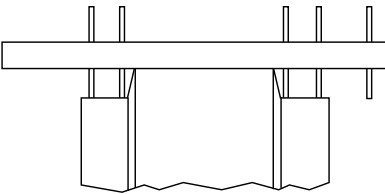
See pages 51 through 55 for detailed shoe information.



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

### Idlers

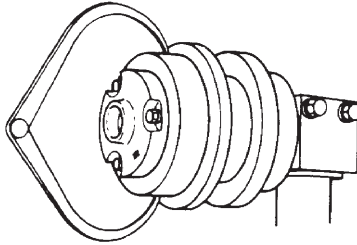
See pages 56 through 58 for detailed idler information.



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

### Carrier Rollers

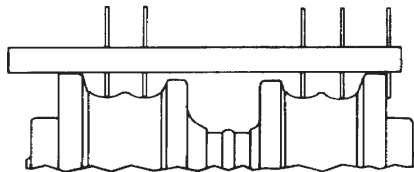
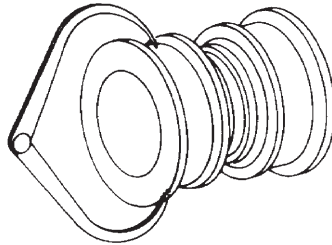
See pages 59 through 60 for detailed carrier roller information.



**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

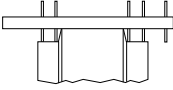
| Model | Bolt Size | Torque*          | Additional Turn |                         |
|-------|-----------|------------------|-----------------|-------------------------|
|       |           |                  | Regular Shoe    | Master Link Master Shoe |
| 943   | 5/8"      | 120 ± 30 ft. lb. | +1/3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

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

# Hydrostatic Loaders

943 — 6.75" (171.5 mm)

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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 |       | Center Flange Wear |       |
|------------|-------|--------------------|-------|
| Inches     | (mm)  | 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.

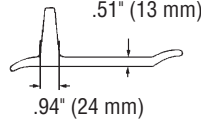
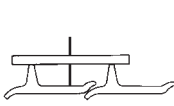
Undercarriage Code: 322, 323

# Hydrostatic Loaders

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

## Track Shoes

Moderate Service

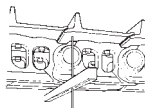


| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 2.25        | (57.0) | 0      | 2.75       | (69.9) |
| 2.20        | (56.0) | 4      | 2.70       | (68.6) |
| 2.15        | (54.5) | 8      | 2.65       | (67.3) |
| 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

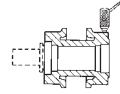
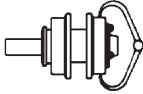


| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (mm)   |
| 5.03        | (128.0) | 0      | 1.67       | (42.4) |
| 5.01        | (127.5) | 4      | 1.65       | (41.9) |
| 4.99        | (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) |

# Hydrostatic Loaders

963 — 8.00" (203.2 mm)

## Carrier Rollers



| Caliper |         | % Worn | Ultrasonic |        |
|---------|---------|--------|------------|--------|
| Inches  | (mm)    |        | 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) |

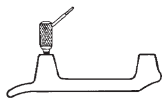
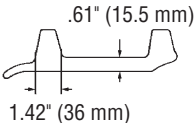
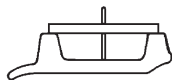
Undercarriage Code: 364, 365

# Hydrostatic Loaders

973 — 8.50" (215.9 mm)

## Track Shoes

### Double Grouser



| Depth Gauge<br>Inches | Depth Gauge<br>(mm) | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic<br>Inches | Ultrasonic<br>(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

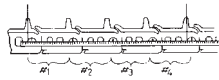
### Undercarriage Identification

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<br>3A9614 & 15                               |                  |
| 311, 312, 313, 314                        | 6.75"  | 4I7475 & 76                                                | 508-514          |
| 315, 317, 318, 320,<br>322, 320 FM        | 7.50"  | 9W3137 & 38<br>106-1625 & 26                               | 516-529          |
| 320S, 322 FM,<br>325, 325 FM              | 8.00"  | 6Y1607 & 08<br>8E7405 & 06                                 | 530-542          |
| 330                                       | 8.50"  | 6Y2589 & 90                                                | 544-555          |
| 330 FM, 345                               | 8.50"  | 150-4748 & 49<br>130-5333 & 34<br>209-6383 & 84            | 556-564          |
| 350                                       | 9.00"  | 8E6091 & 92                                                | 566-573          |
| 365, 375, 385, 5080, 5090                 | 10.25" | 142-1803 & 04<br>6Y6721 & 22                               | 574-583          |
| 5110                                      | 10.25" | 9W5933 & 34                                                | 584-591          |
| 5130                                      | 12.50" | 6I8643 & 44<br>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.,<br>FB221, FB217, DL221 | 7.50"  | 7T4043 & 44<br>3P7153 & 54                                 | 630-644          |
| 225                                       | 6.75"  | 9K6628 & 29                                                | 646-655          |
| 227, 229, 231,<br>225S.A., LL225          | 8.00"  | 3P1112 & 13                                                | 656-665          |
| 235, LL235                                | 8.50"  | 8E8641 & 42<br>130-5333 & 34<br>8S2589 & 90<br>7T9823 & 24 | 666-682          |
| 235                                       | 8.00"  | 3P1112 & 13                                                | 684-691          |
| 245                                       | 10.25" | 9S1927 & 28                                                | 692-701          |
| 245                                       | 9.00"  | 8K4754 & 56<br>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<br>093-1979                                       | 736-742          |
| E200B, EL200B                             | 7.50"  | 9W3137 & 38                                                | 744-750          |
| EL240B, E240B,<br>EL240, E240             | 7.50"  | 9W3137 & 38<br>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**

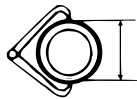
**Internal Wear  
5.31" (135 mm) Pitch**



| 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    |

Bushings for Sealed Track

External Wear



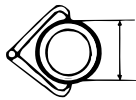
| Caliper |        | % Worn | Ultrasonic |       |
|---------|--------|--------|------------|-------|
| Inches  | (mm)   |        | Inches     | (mm)  |
| 1.99    | (50.5) | 0      | 0.32       | (8.1) |
| 1.98    | (50.3) | 8      | 0.31       | (7.9) |
| 1.97    | (50.0) | 16     | 0.30       | (7.6) |
| 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) |

# Excavators

320 FM — 7.50" (190 mm)

## Bushings for Sealed Track

External Wear  
Grease Lubricated Track  
Only use for 320 FM



| Caliper |        | Allowable Wear   |                   | Ultrasonic |        |
|---------|--------|------------------|-------------------|------------|--------|
| Inches  | (mm)   | Lesser<br>% Worn | Greater<br>% 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

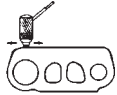
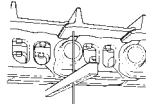
# Excavators

320S, 322 FM, 325 — 8.00" (203.2 mm)

## Track Links

6Y1607 & 08

Not for use on 325 FM



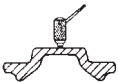
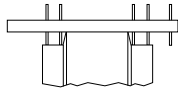
| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (mm)   |
| 4.52        | (115.0) | 0      | 1.26       | (32.0) |
| 4.50        | (114.5) | 8      | 1.24       | (31.5) |
| 4.48        | (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

# Excavators

320 S, 322 FM, 325 — 8.00" (203.2 mm)

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 0.78        | (20.0) | 0      |
| 0.80        | (20.5) | 12     |
| 0.82        | (21.0) | 24     |
| 0.84        | (21.5) | 36     |
| 0.86        | (22.0) | 44     |
| 0.88        | (22.5) | 48     |
| 0.90        | (23.0) | 52     |
| 0.92        | (23.5) | 56     |
| 0.94        | (24.0) | 60     |
| 0.96        | (24.5) | 64     |
| 0.98        | (25.0) | 68     |
| 1.00        | (25.5) | 72     |
| 1.02        | (26.0) | 76     |
| 1.04        | (26.5) | 80     |
| 1.06        | (27.0) | 84     |
| 1.08        | (27.5) | 88     |
| 1.10        | (28.0) | 92     |
| 1.12        | (28.5) | 96     |
| 1.14        | (29.0) | 100    |
| 1.16        | (29.5) | 104    |
| 1.18        | (30.0) | 108    |
| 1.20        | (30.5) | 112    |
| 1.22        | (31.0) | 116    |
| 1.24        | (31.5) | 120    |

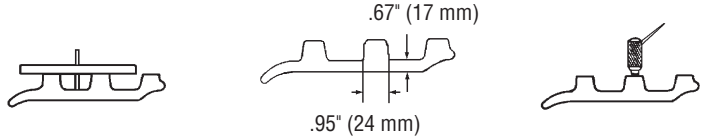
Flange width: 3.74" (95 mm)

| Ultrasonic |        | Center Flange Wear |        |
|------------|--------|--------------------|--------|
| Inches     | (mm)   | 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) |

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

Track Shoes

Extreme Service Triple Grouser



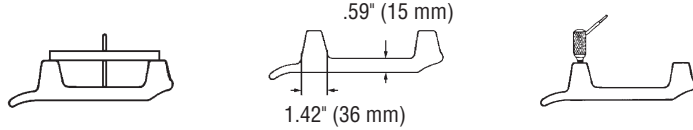
| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 1.35        | (34.5) | 0      | 1.95       | (49.5) |
| 1.30        | (33.0) | 6      | 1.90       | (48.2) |
| 1.25        | (32.0) | 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) |

# Excavators

330 FM, 345 — 8.50" (215.9 mm)

## Track Shoes

### Double Grouser

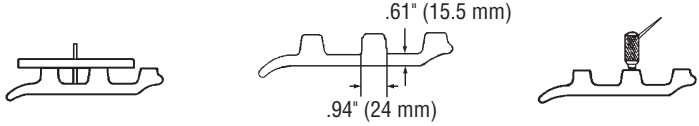


| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 1.95        | (49.5) | 0      | 2.54       | (64.5) |
| 1.85        | (47.0) | 10     | 2.44       | (62.0) |
| 1.75        | (44.5) | 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

Track Shoes

Triple Grouser

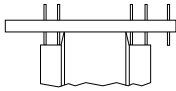


| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 1.35        | (34.5) | 0      | 1.95       | (49.5) |
| 1.30        | (33.0) | 6      | 1.90       | (48.2) |
| 1.25        | (32.0) | 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) |

# Excavators

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

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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    |

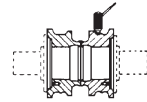
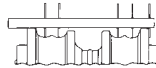
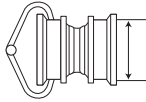
Flange width: 5.09" (129.3 mm)

| Ultrasonic |        | Center Flange Wear |        |
|------------|--------|--------------------|--------|
| Inches     | (mm)   | 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

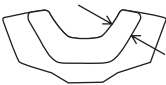
Track Rollers



| Caliper |         | % Worn | Depth Gauge |        | Ultrasonic |        |
|---------|---------|--------|-------------|--------|------------|--------|
| Inches  | (mm)    |        | Inches      | (mm)   | Inches     | (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)

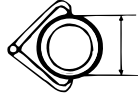
Sprockets



| Caliper |        | % Worn |
|---------|--------|--------|
| Inches  | (mm)   |        |
| 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    |

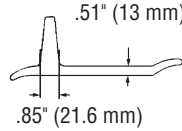
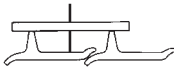
### Bushings for Sealed Track

#### External Wear



| Caliper |        | Allowable Wear   |                   | Ultrasonic |       |
|---------|--------|------------------|-------------------|------------|-------|
| Inches  | (mm)   | Lesser<br>% Worn | Greater<br>% 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) |

### Track Shoes Moderate Service



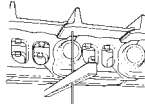
| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 2.25        | (57.0) | 0      | 2.75       | (69.9) |
| 2.20        | (56.0) | 4      | 2.70       | (68.6) |
| 2.15        | (54.5) | 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) |

# Excavators

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

## Track Links

7T4043 & 44  
7.50" (190 mm) Pitch



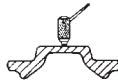
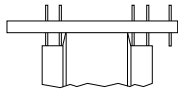
| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (mm)   |
| 4.17        | (106.0) | 0      | 1.21       | (30.7) |
| 4.15        | (105.5) | 9      | 1.19       | (30.2) |
| 4.13        | (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

# Excavators

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

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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    |

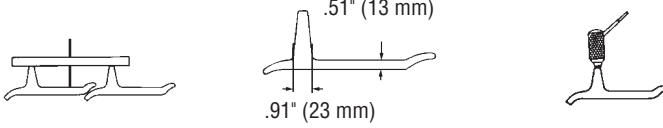
Flange width: 3.31" (84 mm)

| Ultrasonic |       | Center Flange Wear |       |
|------------|-------|--------------------|-------|
| Inches     | (mm)  | 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

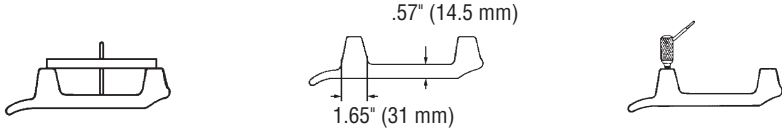
### Track Shoes Moderate Service



| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | 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) |

Track Shoes

Double Grouser



| Depth Gauge |        | High Impact<br>% Worn | Low Impact<br>% Worn | Ultrasonic |        |
|-------------|--------|-----------------------|----------------------|------------|--------|
| Inches      | (mm)   |                       |                      | Inches     | (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) |

### Bushings for Sealed Track

#### External Wear



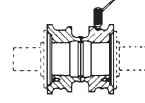
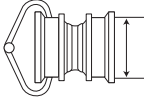
| Caliper<br>Inches (mm) |        | Allowable Wear   |                   | Ultrasonic<br>Inches (mm) |        |
|------------------------|--------|------------------|-------------------|---------------------------|--------|
|                        |        | Lesser<br>% Worn | Greater<br>% Worn |                           |        |
| 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)  |

# Excavators

235, LL235 — 8.50" (215.9 mm)

## Track Rollers

8E Rim

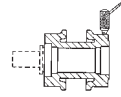
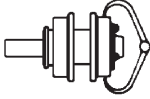


| Caliper |         | % Worn | Depth Gauge |        | Ultrasonic |        |
|---------|---------|--------|-------------|--------|------------|--------|
| Inches  | (mm)    |        | Inches      | (mm)   | Inches     | (mm)   |
| 6.69    | (170.0) | 0      | 0.69        | (17.5) | 1.73       | (43.9) |
| 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

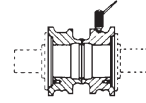
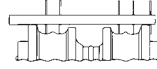
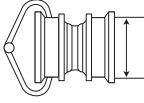
### Carrier Rollers



| Caliper |         | % Worn | Ultrasonic |        |
|---------|---------|--------|------------|--------|
| Inches  | (mm)    |        | 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) |

### Track Rollers

#### 8E Rim

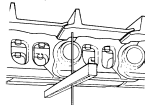


| Caliper |         | % Worn | Depth Gauge |        | Ultrasonic |        |
|---------|---------|--------|-------------|--------|------------|--------|
| Inches  | (mm)    |        | Inches      | (mm)   | Inches     | (mm)   |
| 9.84    | (250.0) | 0      | 0.78        | (20.0) | 2.87       | (72.9) |
| 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)

Track Links

931969 & 70

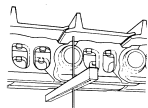


| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 2.91        | (74.0) | 0      | 0.78       | (19.8) |
| 2.89        | (73.5) | 9      | 0.76       | (19.3) |
| 2.87        | (73.0) | 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) |

# Excavators

E120B, E110B — 6.75" (171.5 mm)

## Track Links 417475 & 76

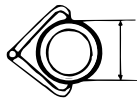


| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 3.54        | (90.0) | 0      | 0.97       | (24.6) |
| 3.52        | (89.5) | 9      | 0.95       | (24.1) |
| 3.50        | (89.0) | 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

Bushings for Sealed Track

External Wear

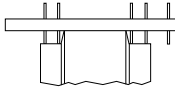


| Caliper |        | % Worn | Ultrasonic |       |
|---------|--------|--------|------------|-------|
| Inches  | (mm)   |        | Inches     | (mm)  |
| 1.99    | (50.5) | 0      | 0.32       | (8.1) |
| 1.98    | (50.3) | 8      | 0.31       | (7.9) |
| 1.97    | (50.0) | 16     | 0.30       | (7.6) |
| 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) |

# Excavators

EL180, E180 — 6.91" (175.5 mm)

## Idlers



| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 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 |       | Center Flange Wear |       |
|------------|-------|--------------------|-------|
| Inches     | (mm)  | 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) |

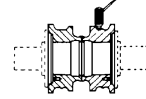
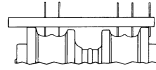
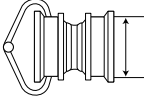
NOTE: Ultrasonic measurement is to determine flange wear only.

Undercarriage Code: 560

# Excavators

EL200B, E200B — 7.50" (190 mm)

## Track Rollers



| Caliper |         | % Worn | Depth Gauge |        | Ultrasonic |        |
|---------|---------|--------|-------------|--------|------------|--------|
| Inches  | (mm)    |        | 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)

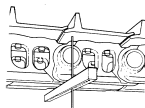
Undercarriage Code: 565

# Excavators

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

## Track Links

960263 & 64

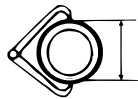


| Depth Gauge |         | % Worn | Ultrasonic |        |
|-------------|---------|--------|------------|--------|
| Inches      | (mm)    |        | Inches     | (mm)   |
| 4.58        | (116.5) | 0      | 1.22       | (31.0) |
| 4.56        | (116.0) | 7      | 1.20       | (30.5) |
| 4.54        | (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**

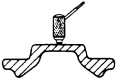
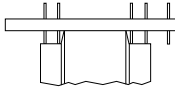


| Caliper |        | Allowable Wear   |                   | Ultrasonic |        |
|---------|--------|------------------|-------------------|------------|--------|
| Inches  | (mm)   | Lesser<br>% Worn | Greater<br>% Worn | Inches     | (mm)   |
| 2.32    | (58.9) | 0                | 0                 | 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)  |

# Excavators

E450 — 8.50" (215.9 mm)

## Idlers



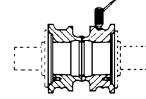
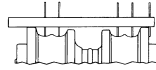
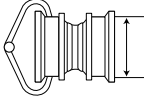
| Depth Gauge |        | % Worn |
|-------------|--------|--------|
| Inches      | (mm)   |        |
| 0.88        | (22.5) | 0      |
| 0.90        | (23.0) | 7      |
| 0.92        | (23.5) | 14     |
| 0.94        | (24.0) | 21     |
| 0.96        | (24.5) | 28     |
| 0.98        | (25.0) | 35     |
| 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 |        | Center Flange Wear |        |
|------------|--------|--------------------|--------|
| Inches     | (mm)   | 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.

### Track Rollers



| Caliper |         | % Worn | Depth Gauge |        | Ultrasonic |        |
|---------|---------|--------|-------------|--------|------------|--------|
| Inches  | (mm)    |        | 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) |

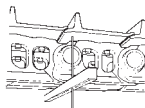
Flange diameter is 12.78" (324.5 mm)

# Paving Products/Drive Belts

AP1050 — 6.125" (155.6 mm)

## Track Links

6Y0935 & 36

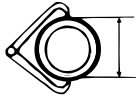


| Depth Gauge |        | % Worn | Ultrasonic |        |
|-------------|--------|--------|------------|--------|
| Inches      | (mm)   |        | Inches     | (mm)   |
| 3.46        | (88.0) | 0      | 1.00       | (25.4) |
| 3.44        | (87.5) | 13     | 0.98       | (24.9) |
| 3.42        | (87.0) | 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

Track Bushings for Sealed Track

External Wear



| Caliper |        | Allowable Wear   |                   | Ultrasonic |        |
|---------|--------|------------------|-------------------|------------|--------|
| Inches  | (mm)   | Lesser<br>% Worn | Greater<br>% 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)  |

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