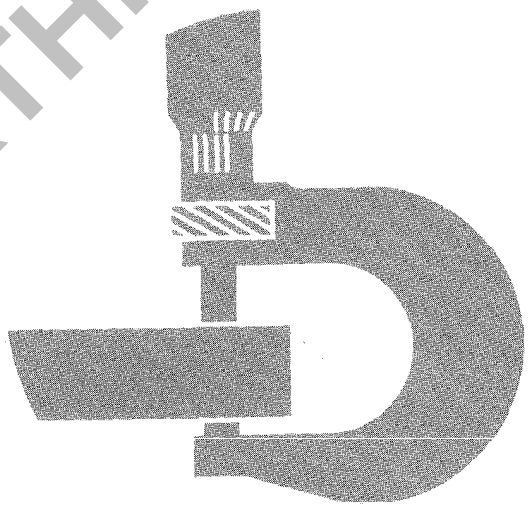
John Deere
400G
Crawler Bulldozer
Repair



TECHNICAL MANUAL

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TM-1412 (Mar-88)
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400G CRAWLER BULLDOZER
TECHNICAL MANUAL
TM1412 (Mar–88)
REPAIR

SECTION AND GROUP CONTENTS

NOTE: This manual covers machine repair. For Operation and Test information, see TM–1411.

SECTION I—GENERAL INFORMATION
Group I—Introduction and Safety Information
Group II—General Specifications
Group III—Torque Values
Group IV—Fuels and Lubrication
Group V—Inspection Procedures

SECTION 01—TRACKS
Group 0130—Track Systems
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SECTION 02—AXLES AND SUSPENSION SYSTEMS
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Final Drive, Steering Brakes, Steering Clutch, Linkage, and Adjustments

SECTION 03—TRANSMISSION
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Group 0360—Hydraulic System
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SECTION 07—CLUTCH
Group 0715—Controls
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Engine Clutch Assembly and Clutch Housing

Continued on next page

All information, illustrations and specifications contained in this technical manual are based on the latest information available at the time of publication. The right is reserved to make changes at any time without notice.

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RECOGNIZE SAFETY INFORMATION

This is the safety-alert symbol. When you see this symbol on your machine or in this manual, be alert to the potential for personal injury.

Follow recommended precautions and safe operating practices.



AB6;T81389 053;ALERT 160687

UNDERSTAND SIGNAL WORDS

A signal word—DANGER, WARNING, or CAUTION—is used with the safety-alert symbol. DANGER identifies the most serious hazards.

Safety signs with signal word DANGER or WARNING are typically near specific hazards.

General precautions are listed on CAUTION safety signs. CAUTION also calls attention to safety messages in this manual.



AB6;TS187 053;SIGNAL 071085

USE HANDHOLDS AND STEPS

Falling is one of the major causes of machine accidents.

When you get on and off the machine, always maintain a three point contact with the steps and handrails and face the machine. Do not use any controls as handholds.

Never jump either on or off the machine. Never mount or dismount a moving machine.

Be careful of slippery conditions on platforms, steps, and handrails when leaving the machine.



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Engine: John Deere 4-239D

Type	4-stroke cycle, naturally aspirated diesel
Bore and stroke	4.19 x 4.33 (106.5 x 110 mm)
Number of cylinders	4
Displacement	239 cu in. (3.9 L)
Compression ratio	17.8:1
Maximum net torque @ 1300 rpm	180 lb ft (244 N·m) (24.9 kgm)
Lubrication	Pressure system with full-flow filter
Cooling fan	Blower
Air cleaner	Dry
Electrical system	12 volt with alternator
Batteries	Reserve capacity: 180 minutes

Power @ 2100 engine rpm — SAE

Net	60 hp (36 kW)

Transmission ..... H-L-R

Steering Clutches ..... Oil-cooled, hydraulically actuated multiple disk

Brakes ..... Self-adjusting, oil-cooled

Travel Speeds—mph (km/h)

With machine at rated engine speed, travel speed will be:

Gear	High	Low	Reverse
1	1.7 (2.7)	1.2 (1.9)	1.6 (2.6)
2	2.6 (4.2)	1.9 (3.1)	2.5 (4.0)
3	4.0 (6.4)	2.8 (4.5)	3.8 (6.1)
4	6.2 (10.0)	4.4 (7.1)	5.9 (9.5)

Hydraulic system:

Pump	Gear, 15 gpm (57 L/min)
Pressure	2250 psi (15 514 kPa) (155.1 bar)

Tracks (5-roller track frames with track guides):

Grouser	14 ini. (356 mm)
Track shoes, each side	36
Ground contact area	1939 sq in. (12 510 cm²)
Ground pressure	5.9 psi (40.7 kPa) (0.407 bar)

Winch:

Drum diameter	6 iin. (152 mm)
Drum capacity	(no allowance for looseness or uneven spooling):
1/2 in. (12.7 mm) cable	159 ft (48.5 m)
5/8 in. (15.9 mm) cable	105 ft (31.9 m)
3/4 in. (19 mm) cable	74 ft (22.5 m)

Cable speed (at 2500 rpm engine speed with 5/8 in. (15.9 mm) cable:

With bore drum	119 fpm (36.3 mpm)
With full drum	186 fpm (56.7 mpm)

Cable pull (at 1300 rpm engine speed):

With bore drum	15,700 lb (7120 kg)
with full drum	10,020 lb (4544 kg)

Shipping weight:

Winch (without cable)	815 lb (370 kg)
Fairlead	110 lb (50 kg)
Drawbar	44 lb (20 kg)

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DRAIN AND REFILL CAPACITIES

	U.S.	Metric
Fuel tank	31 gal	117.3 L
Cooling system	3.5 gal	12.3 L
Engine oil, including filter	8.5 qt	8.0 L
Hydraulic system (reservoir only), including filter	6.0 gal	22.5 L
Transmission, steering clutch, final drive, including filter		
Steering clutches (each)	3.5 gal	(13.2 L)
Transmission	7.0 gal	(28.5 L)
Winch reservoir	9.0 qt	8.5 L

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HARDWARE TORQUE VALUES

NOTE: Torque wrench tolerance is ± 10 per cent of specified torque.

Customary Hardware





Cap Screw Size-Inches	Grade B lb-ft.	Grade B (N-m)	Grade D lb-ft.	Grade D (N-m)	Grade F lb-ft.	Grade F (N-m)
1/4	6	(8)	10	(14)	14	(19)
5/16	10	(14)	20	(27)	27	(37)
3/8	20	(27)	35	(47)	50	(68)
7/16	30	(40)	55	(75)	80	(108)
1/2	45	(60)	85	(115)	120	(163)
9/16	70	(95)	120	(160)	170	(230)
5/8	95	(130)	165	(225)	235	(320)
3/4	165	(225)	300	(405)	420	(570)
7/8	170	(230)	450	(610)	675	(915)
1	255	(345)	720	(975)	1015	(1375)
1-1/8			900	(1220)	1430	(1940)
1-1/4			1250	(1700)	2025	(2750)

Seating Torque Values for Set Screws

INCH SCREWS

Screw Size	Seating Torque (Lb-in.)	Seating Torque (Nm)
5	9	1
6	9	1
8	20	2
10	33	4
1/4	87	10
5/16	165	19
3/8	290	33
7/16	430	49
1/2	620	70
9/16	620	70
5/8	1225	138
3/4	2125	240

METRIC SCREWS

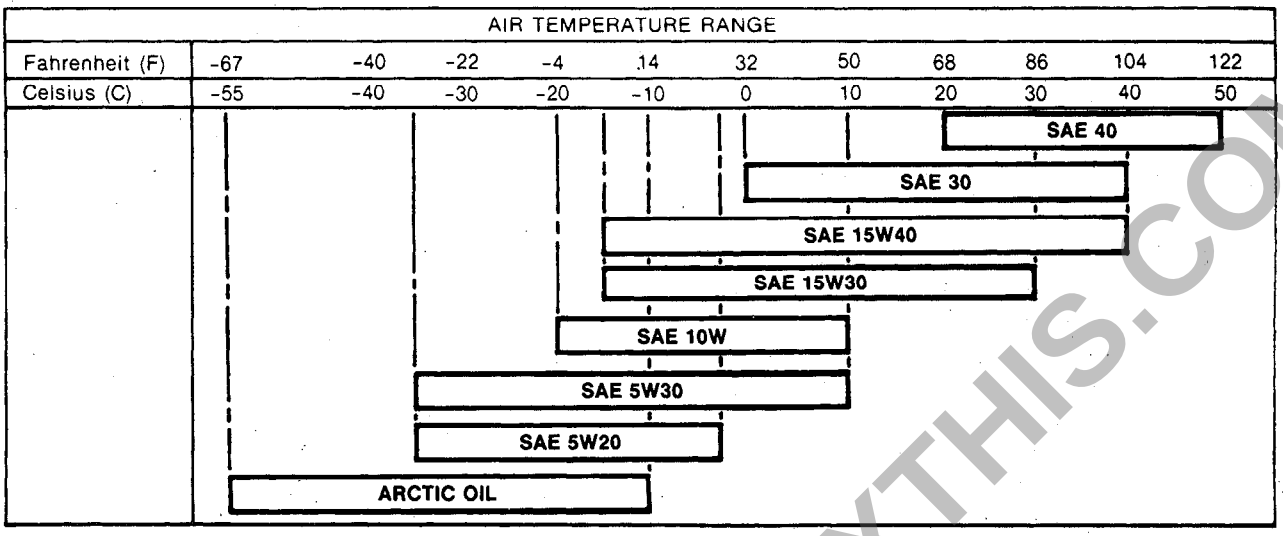
Screw Size	Seating Torque (Nm)
M3	0.9
M4	2.5
M5	5.0
M6	8.5
M8	20
M10	40
M12	65
M16	160
M20	310
M24	520

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ENGINE OIL



Depending upon the expected air temperature range between oil changes, use oil viscosity shown on the temperature chart above.

Additives are not required nor recommended.

John Deere TORQ-GARD SUPREME® engine oil is recommended because it is a specifically balanced formulation to provide maximum engine life. It provides excellent protection against mechanical wear, carbon deposits, and lacquer formation, plus providing superior cold weather starting performance.

If other oils are used, they must have one of the following specifications:

Oil Specification	Use
API Service: CD/SF, CD/SE, CD/SD, CD/SC, or MIL-L-2104C, MIL-L-2104D	Recommended
*API Service CC/SF, CC/SE, CC/SD, CC/SC or *MIL-L-46152, *MIL-L-46152B	For SAE 5W20, SAE 5W30 and arctic oil only, use if recommended oil is not available.
*MIL-L-46167A	For arctic oil only

**Change oil at one-half the normal interval.*

018;T6172AI 02T;45 J15. 270188

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The following inspections must be performed by you, the dealer. Check off each item as it is completed. Refer to the Operator's Manual for detailed information of items 1—25. Refer to Operational Checkout for checkout procedure of items 26—38.

PDI OK	ASI OK		PDI OK	ASI OK	
☐	☐	1. Check engine oil level.	☐	☐	20. Check rollers and idlers.
☐	☐	2. Check coolant level; freeze protection. Use JT05460.		☐	21. Check track shoe bolt torque.
☐	☐	3. Check hose clamps: air intake, coolant.	☐	☐	22. Check track sag.
☐	☐	4. Check air cleaner elements.	☐	☐	23. Check for loose or missing hardware.
☐	☐	5. Air restriction indicator.	☐	☐	24. Check lines for leaks: cooling, fuel hydraulic.
☐	☐	6. Check belt tension.	☐	☐	25. Check control lever operations.
☐	☐	7. Drain fuel filter sediment.	☐	☐	26. Check monitor gauges and lights.
☐	☐	8. Check fuel tank filler screen.	☐	☐	27. Check brake and H-L-R lock.
☐	☐	9. Check hydraulic oil level.	☐	☐	28. Check neutral start system.
☐	☐	10. Check fuel tank level.	☐	☐	29. Check starting operation.
☐	☐	11. Check transmission oil level.	☐	☐	30. Check clutch and decelerator pedals.
☐	☐	12. Check battery electrolyte level; specific gravity. Use JTO5460.	☐	☐	31. Check brake pedal.
☐	☐	13. Lubricate all grease fittings.	☐	☐	32. Check steering pedals/levers.
☐	☐	14. Drain fuel tank sump.	☐	☐	33. Check driving operation; transmission gear noise H-L-R rate-of-shift.
	☐	15. Check engine speeds.	☐	☐	34. Check all operating lights.
	☐	16. Record radiator air flow. Use JTO5529	☐	☐	35. Check seat adjustments.
	☐	17. Change hydraulic oil filter.	☐	☐	36. Check start aid—if equipped.
	☐	18. Change transmission oil filter.	☐	☐	37. Check locks and latches.
	☐	19. Change engine oil and filter.	☐	☐	38. Clean machine; check paint, decals.

Comments: _____

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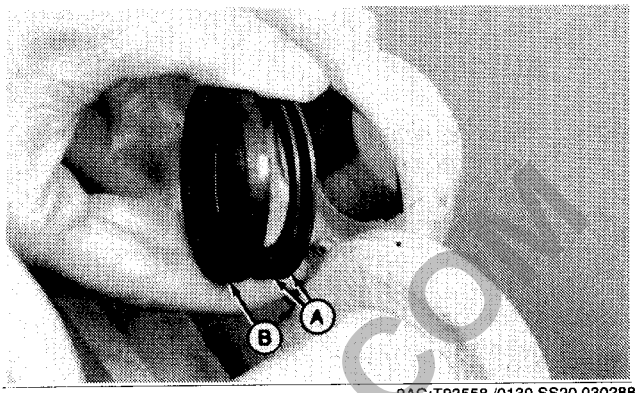
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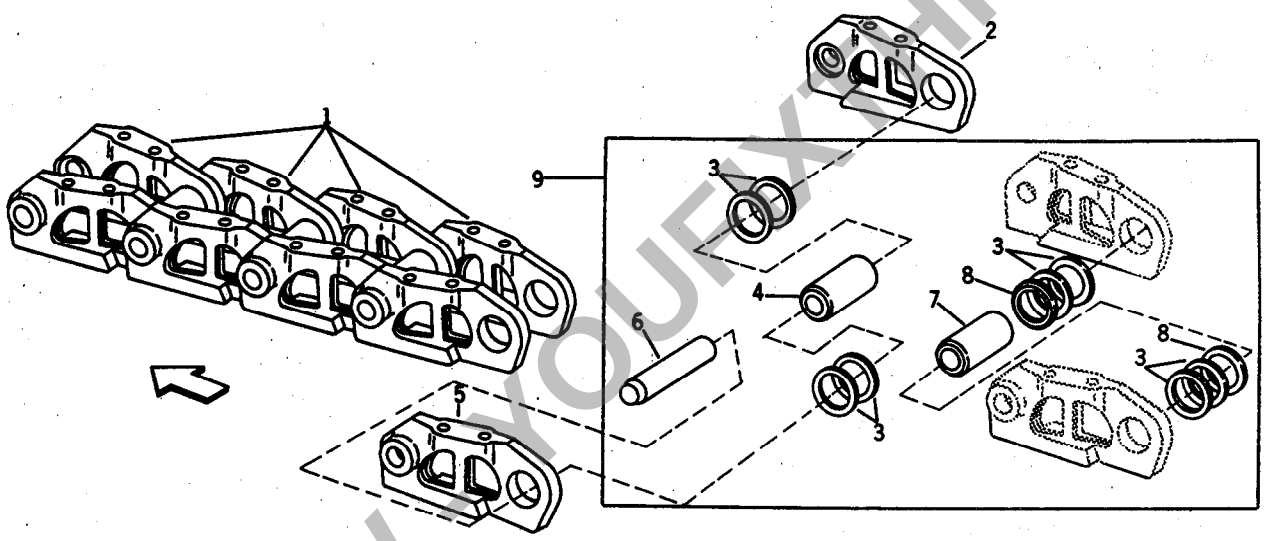
9. Pull track chain apart. Remove spacers (B) and seals (A) from between left and right track links.

10. Lift side of machine or operate crawler and rotate track in the reverse direction. Slowly, unwrap track off drive sprocket.

11. Place a jack under both crossbars and raise crawler to provide clearance. Block crawler up securely.



2AG;T93558 /0130 SS20 030288



T59376F

1—Track Chain
2—Right Track Link
3—Belleville Seals
4—Bushing
5—Left Track Link
6—Pin Standard
Pin, Master
(Drill Point On End)
7—Master Bushing
8—Spacer (Master Bushing)
9—Pin and Bushing Repair Kit

2AG;T59376 /0130 SS21 030288

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SERVICE EQUIPMENT AND TOOLS

NOTE: Order tools from your SERVICE-GARD™ Catalog. Some tools may be available from a local supplier.

Name	Use
Seal driver set	Install bushings in arms.

T48;0315 6046NC 010285

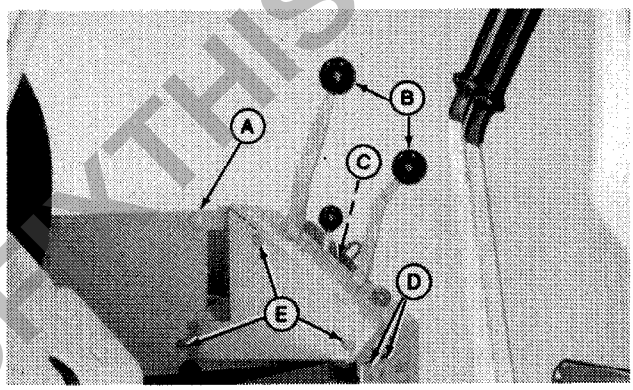
REMOVE SPEED CONTROL QUADRANT

1. Remove knobs (B) and disconnect engine speed control linkage (C).

2. Remove three cap screws (E).

3. Remove nut, lock washer and cap screw (A).

4. Remove nut, ground strap, two cap screws (D) and washers. Remove quadrant.



A—Cap Screw
B—Knob (2 used)
C—Engine Speed Control Linkage
D—Cap Screw (2 used)
E—Cap Screw (3 used)

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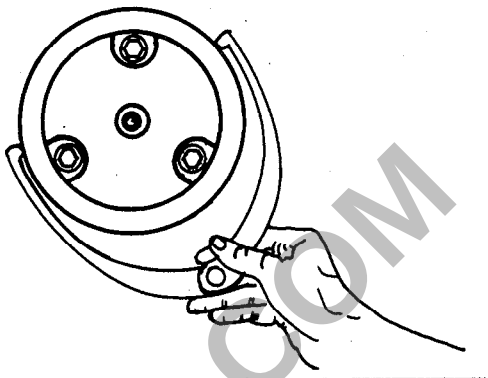
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MEASURE CARRIER ROLLER WEAR

1. Use calipers to measure most worn area of roller running surface.

2. Measure caliper tip spread to the nearest 0.5 mm (0.002 in.) using the scale.

3. Flat spots on roller thread indicates roller is not free to turn.



CARRIER ROLLER WEAR SPECIFICATION

O.D. of new carrier roller	124.0 mm (4.88 in.)
Minimum Recommended O.D.	110.7 mm (4.36 in.)

NOTE: For additional information on measuring carrier roller wear, refer to UNDERCARRIAGE APPRAISAL MANUAL SP–236.

2AG;T5819AC /0130 SS5 030288

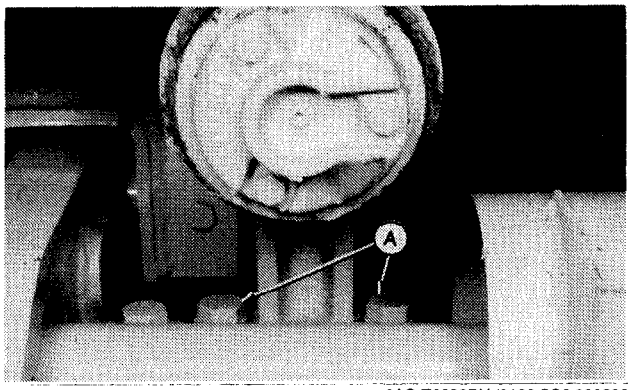
REMOVE AND INSTALL CARRIER ROLLER ASSEMBLY

1. Remove cap screws (A) to remove carrier roller.

2. Install carrier roller. Tighten cap screws to specifications.

TORQUE SPECIFICATION

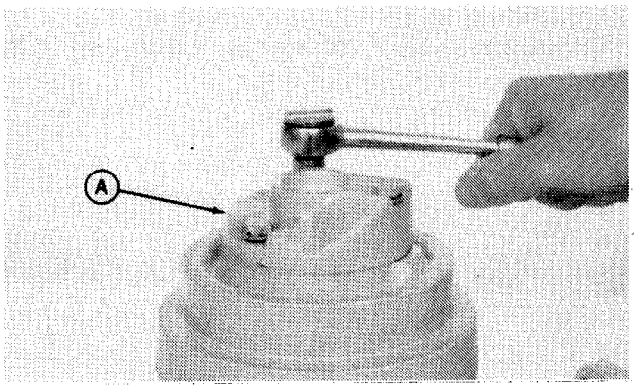
Cap Screw	576 ± 57 N·m (425 ± 42 lb–ft)



2AG;T6699DV /0130 SS6 030288

DISASSEMBLE AND ASSEMBLE CARRIER ROLLER

1. Remove cover (A) and gasket.



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SECTION 09—STEERING SYSTEM
Group 0960—Hydraulic System
Steering Valve Spools

SECTION 15—EQUIPMENT ATTACHING
Group 1511—Fairlead

SECTION 16—ELECTRICAL SYSTEM
Group 1671—Batteries, Support, and Cables
Group 1672—Alternator, Regulator, and Charging System Wiring
Group 1673—Lighting System
Group 1674—Wiring Harness and Switches
Group 1676—Instruments and Indicators
Logic Module, Relay, Circuit Breakers, and Switches
Group 1677—Motors and Actuators
Starting Motor

SECTION 17—FRAME, CHASSIS, OR SUPPORTING STRUCTURE
Group 1740—Frames
Side Frames

SECTION 18—OPERATOR'S STATION
Group 1810—Operator Enclosure
Roll–Over Protective Structure (ROPS)
Group 1821—Seat and Seat Belt

SECTION 19—SHEET METAL AND STYLING
Group 1910—Hood or Engine Enclosure
Grille Housing and Cowl

SECTION 30—WINCH
Group 3015—Controls Linkage
Group 3050—Winch Drive and Clutches
Group 3060—Winch Hydraulic System

SECTION 32—BULLDOZER
Group 3201—Blade
Group 3215—Control Linkage
Group 3240—Frames
Group 3260—Hydraulic System
Hydraulic Oil Filter, Reservoir, Hydraulic Pump, Pump Drive, Dozer Valve, Relief Valves and Cylinders

SECTION 40—PTO OR WINCH DRIVE
Group 4051—Gears, Shafts and Bearings
Powershaft and Winch Drive

SECTION 42—GROUND CONDITIONING TOOLS
Group 4201—Teeth and Shanks
Group 4240—Frame
Group 4260—Hydraulic System
Ripper Cylinder

SECTION 99—DEALER FABRICATED TOOLS

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ADJUST TRACK SAG

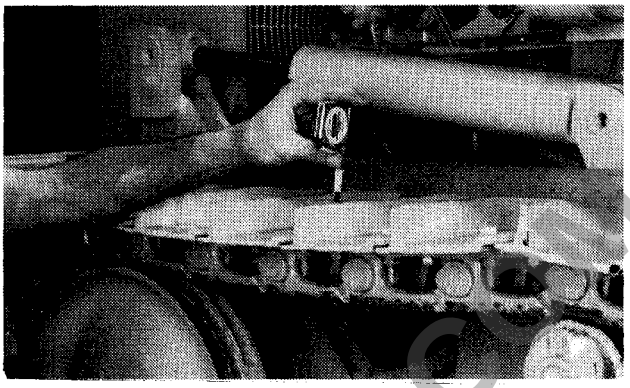
SPECIFICATIONS

Track Sag ..... 22.23—28.58 mm (7/8—1-1/8 in.)

NOTE: Check sag after a short period of operation when changing from one ground condition to another or when operating in extreme soil packing conditions.

1. Allow unit to slowly roll to a stop in the forward direction. For the most accurate measurement, a link pin must be centered on carrier roller.

2. Measure sag between carrier roller and front idler at the lowest point.



2AG;T6699DX /0130 SS14 030288

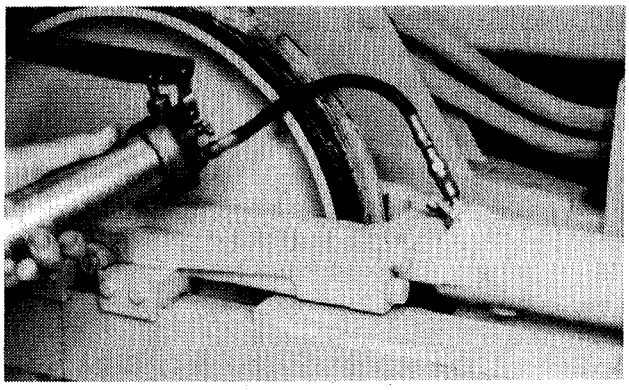
CAUTION: When you work near the track adjuster or recoil spring, USE EXTREME CARE. DO NOT disassemble parts unless you know the correct procedure and have correct tools.

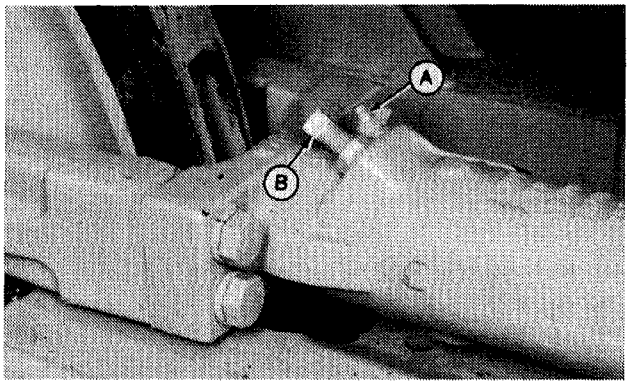
3. To decrease sag, apply grease to grease fitting (A) on yoke end using a 55 200 kPa (550 bar) (8000 psi) capacity grease gun.

4. After adding grease, operate unit to allow track adjuster cylinder to fully adjust and then check sag again.

CAUTION: Grease for track adjuster cylinder is under high pressure. Never remove grease fitting to release the grease. If grease does not escape immediately from vent hole, slowly drive unit in forward and reverse, then close check valve.

5. To increase track sag, turn set screw (B) one to three turns counterclockwise to release grease through vent hole (A). Tighten set screw. Operate unit to allow track adjuster cylinder to adjust and then check sag again.





2AG;T6699DY, T6699DZ /0130 SS15 030288

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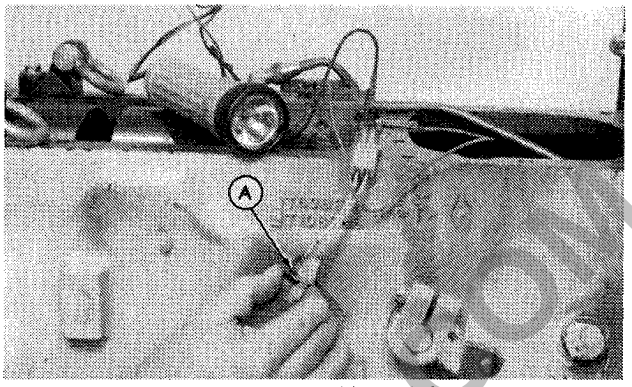
SPECIFICATIONS—Continued

Item	Measurement	Specification
Transmission Oil Pump Cap Screws	Torque	41 N·m (30 lb-ft)
Transmission Front Top Cover Cap Screw	Torque	61 N·m (45 lb-ft)
Transmission-to-Clutch Housing Cap Screws	Torque	365 N·m (270 lb-ft)
Clutch Housing-to-Transmission Cap Screws	Torque	365 N·m (270 lb-ft)
Right and Left Side Frame-to Steering Clutch Housing Cap Screws	Torque	290 N·m (215 lb-ft)
Rear Crossbar-to Final Drive Cap Screws	Torque	520 N·m (385 lb-ft)
Transmission Oil Pressure Regulating Valve Spring	Free Length (approximate) Test Length at 467 ± 44 N (105 ± 10 lb force)	50 mm (1.95 in.) 39 mm (1.54 in.)
Clutch Lubrication Bypass Valve Spring	Free Length (approximate) Test Length at 54 to 67 N (12.25 to 15 lb force)	44 mm (1.75 in.) 33 mm (1.31 in.)
Accumulator Bypass Valve Spring	Free Length (approximate) Test Length at 196 ± 19.6 N (44.06 ± 4.40 lb force)	53 mm (2.08 in.) 26 mm (1.02 in.)
Accumulator Inner Piston Spring	Free Length (approximate) Test Length at 280 ± 28 N (63 ± 6.3 lb force)	109.7 mm (4.32 in.) 65 mm (2.56 in.)
Accumulator Outer Piston Spring	Free Length (approximate) Test Length at 743 ± 74 N (167 ± 16.70 lb force)	131 mm (5.16 in.) 83 mm (3.26 in.)
Oil Manifold Valve Stop Spring	Free Length (approximate) Test Length at 1.5 to 2.08 N (5.5 to 7.5 oz force)	32 mm (1.25 in.) 22 mm (.88 in.)
Clutch Control Valve Spring	Free Length (approximate) Test Length at 115.7 N ± 13 N (26 ± 3 lb force)	21.5 mm (.84 in.) 15.2 mm (.60 in.)
Transmission Oil Filter Assembly Spring	Free Length (approximate) Test Length at 156 ± 18 N (35 ± 4 lb force)	78 mm (3.06 in.) 45 mm (1.75 in.)

T48;0350 R6 070188

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7. Install neutral start switch (A) without shims. Connect a test light to switch. Turn switch until test light comes on, then turn switch until it bottoms out. Count the turns and convert to degrees. Divide the number of degrees by 65. Multiply this figure by 0.010 to give the total number of shims to install.



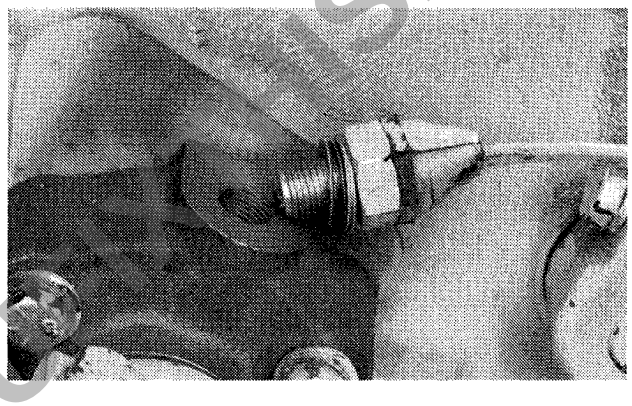
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8. Install the determined amount of shims with switch. Tighten switch to 34 ± 7 N·m (25 ± 5 lb-ft).

9. Check adjustment by installing test light and turning switch counterclockwise. The light should stay on for a minimum of 60° turn and go out within the next 45° turn.

Remove required amount of shims to get specifications. Tighten switch to 34 ± 7 N·m (25 ± 5 lb-ft).

10. See Group 0315 for H-L-R Neutral Start Range adjustment.

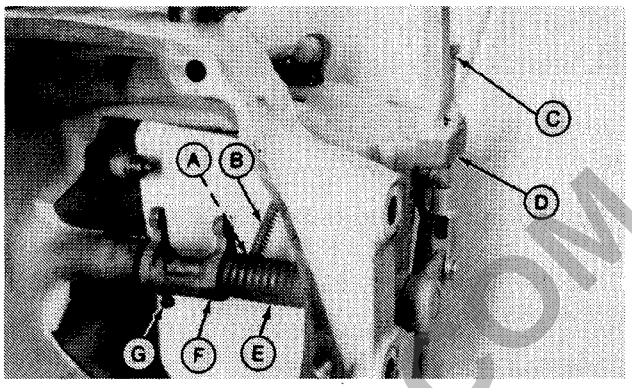


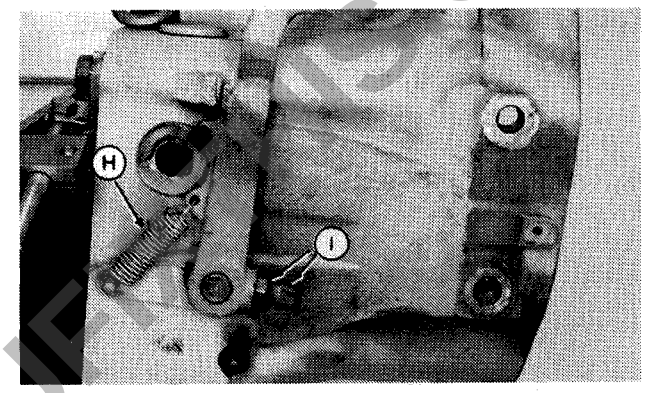
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DISASSEMBLE AND ASSEMBLE CLUTCH HOUSING





1. Install clutch housing in a suitable repair stand.

2. Remove spring (B) and washer (A).

3. Remove clutch adjustment cap screw (C) to relieve tension on spring (E).

4. Loosen set screw (G) to remove parts (D—F).

5. Remove spring (H) and loosen nut and screw (I) to remove brake pedal and linkage assembly.

6. Remove clutch housing bushings if necessary.

7. Install bushings flush with clutch housing case using 25 and 31 mm disks from driver set.

8. Install brake linkage and pedal assembly. Tighten set screw and nut (I).

9. Install spring (H).

10. Install parts (D—F).

11. Tighten set screw (G). Install clutch adjustment cap screw. Tighten cap screw to the approximate location it was removed.

12. Install washer (A) and spring (B).

A—Washer
B—Spring
C—Clutch Adjustment Cap Screw
D—Clutch Pedal and Linkage Assembly
E—Spring
F—Clutch Throwout Bearing Yoke
G—Set Screw
H—Spring
I—Lock Nut and Set Screw

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OTHER MATERIALS

Number	Name	Use
AT42386	John Deere/LOCTITE® Service Kit	Locking threads and sealing.
AT30408	High Temperature Grease	Winch drum bearings.

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SPECIFICATIONS

Item	Measurement	Specification
Ring Gear and Pinion	Backlash	0.15—0.30 mm (0.006—0.012 in.)
Input Shaft Bearing	Adjustment	0.05—0.10 mm (0.002—0.004 in.) preload
Pinion Shaft Bearing	Adjustment	0.10—0.15 mm (0.004—0.006 in.) preload
Winch Drum Bearing	Adjustment	0.05 mm (0.002 in.) endplay to 0.05 mm (0.002 in.) preload
Brake Band Support Cap Screw	Clearance	0.5—1.5 mm (0.02—0.60 in.) clearance
Brake Spring	Adjustment	119 mm (4.875 in.)
Right Hand Bearing Retainer-to-Drum	Torque	75 N·m (55 lb-ft)
Pinion Shaft Nut	Torque	135—170 N·m (100—125 lb-ft)
Pinion Shaft Cover-to-Winch Housing	Torque	47 N·m (35 lb-ft)
Front Cover-to-Winch Housing	Torque	47 N·m (35 lb-ft)
Input Shaft Quill-to-Front Cover	Torque	47 N·m (35 lb-ft)
Left Drum Quill-to-Housing	Torque	75 N·m (55 lb-ft)
Clutch and Brake Drum-to-Winch Drum	Torque	115 N·m (85 lb-ft)
Grease Retainer-to-Left Drum Quill	Torque	47 N·m (35 lb-ft)

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