

CAUTION Chip off chain pin heads by grinder or other tools before cutting the chain if the chain is anchored by rust.

Breaking Chain

Required parts for breaking chain



420/428 size chain

Fit Pin holder red on Guide bolt S head.



Unscrew Pressure bolt and fit Cut pin S into guide bolt.

520/525/530 size chain

Fit Pin holder blue on Guide bolt L head.



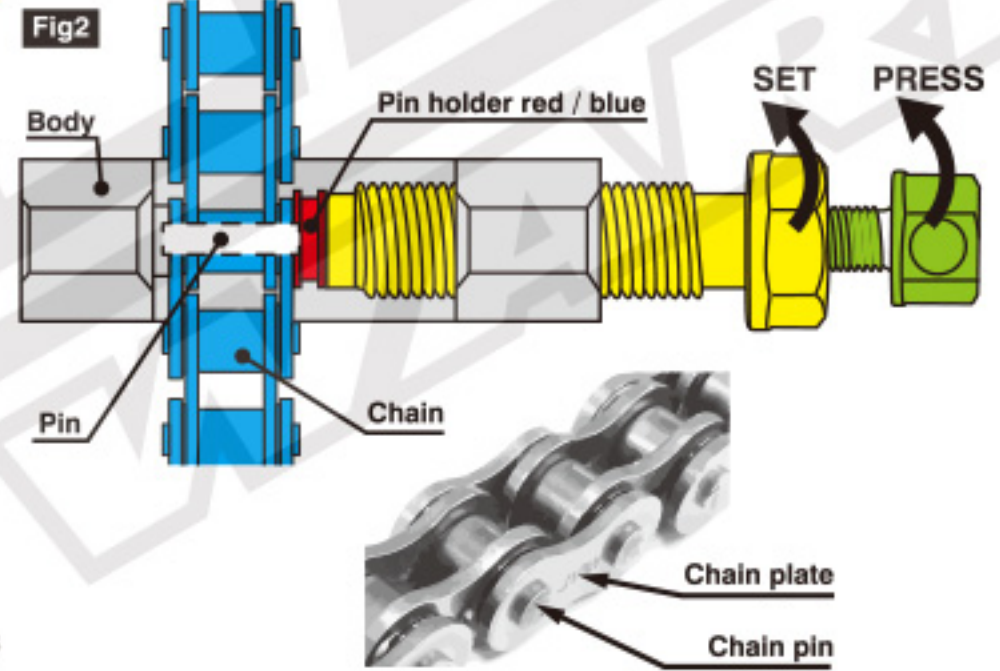
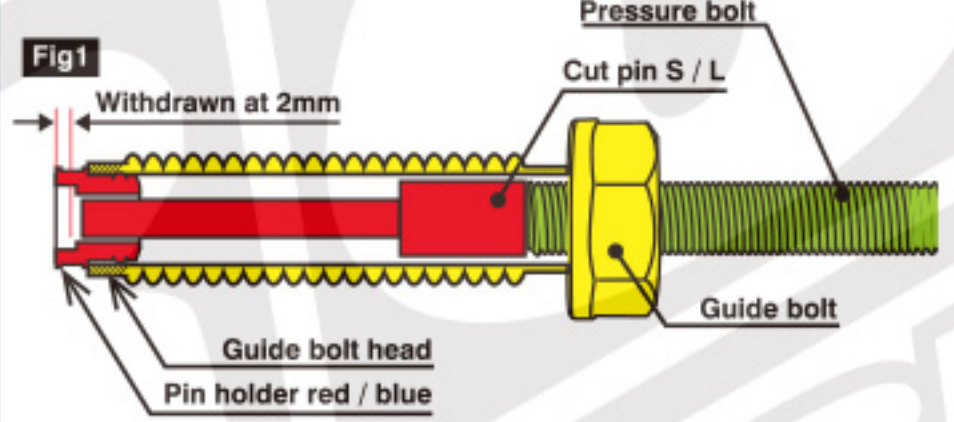
Unscrew Pressure bolt and fit Cut pin L into guide bolt.

1. Screw the Pressure bolt and adjust cut pin position withdrawn at 2mm into Pin holder for clearance between cut pin and chain link pin when the tool is set. **Fig1**

*This setting makes pin holder hold chain plate in a secure chain cutting position.

2. Set a chain in between Body and Pin holder. Screw guide bolt to hold the chain. **Fig2**

*Do not tighten beyond what is necessary to hold the chain in place. Pin holder will be broken by over tightening of guide bolt.



Verification

No clearance between pin holder and chain plate. If there are clearance, adjust position of cut pin inside of guide bolt.

*Cut pin will be broken with clearance between pin holder and chain plate.

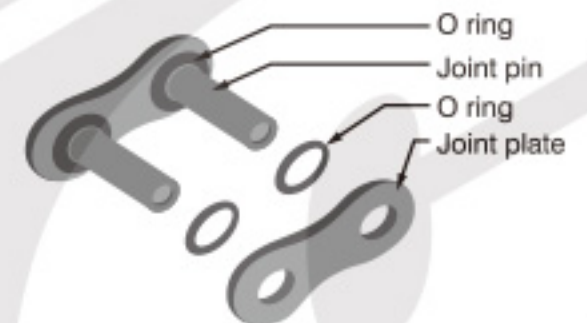
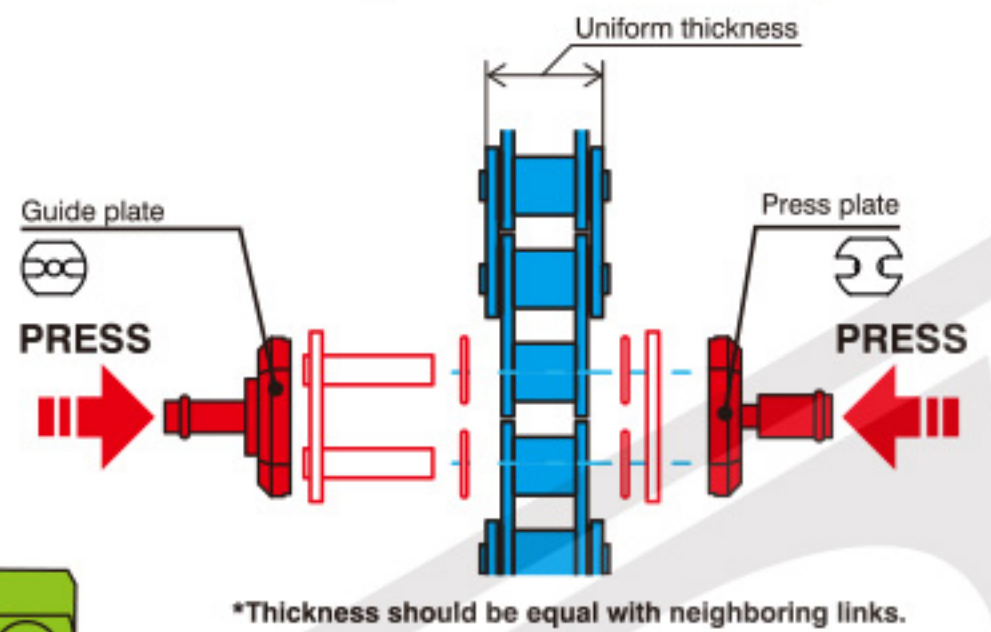
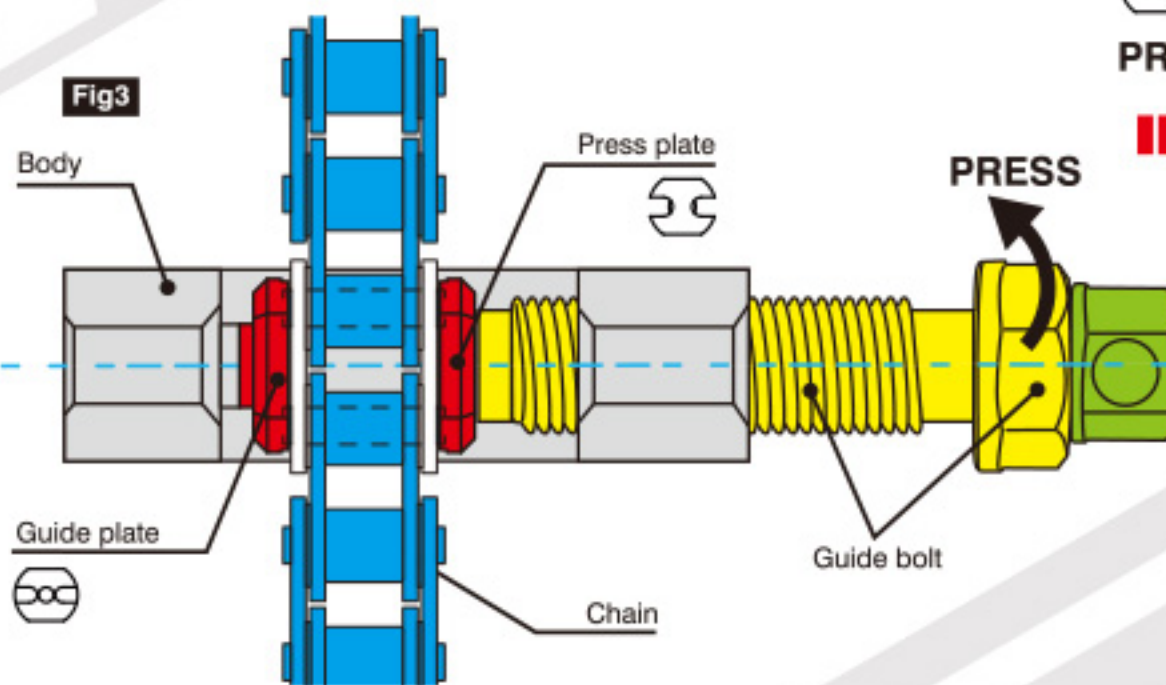
3. Tighten pressure bolt, breaking chain is completed when its bolt becomes loose.

Pressing chain plate

Required parts for pressing chain plate



1. Set Guide plate on chain tool body and Press plate on Guide bolt.
2. Position the chain between Guide plate and Press plate. **Fig3**
3. Tighten Guide bolt to compress Chain plate onto Joint pin. Make sure the Joint pin does not touch Press plate.



Rivet chain pin

Required parts for riveting chain

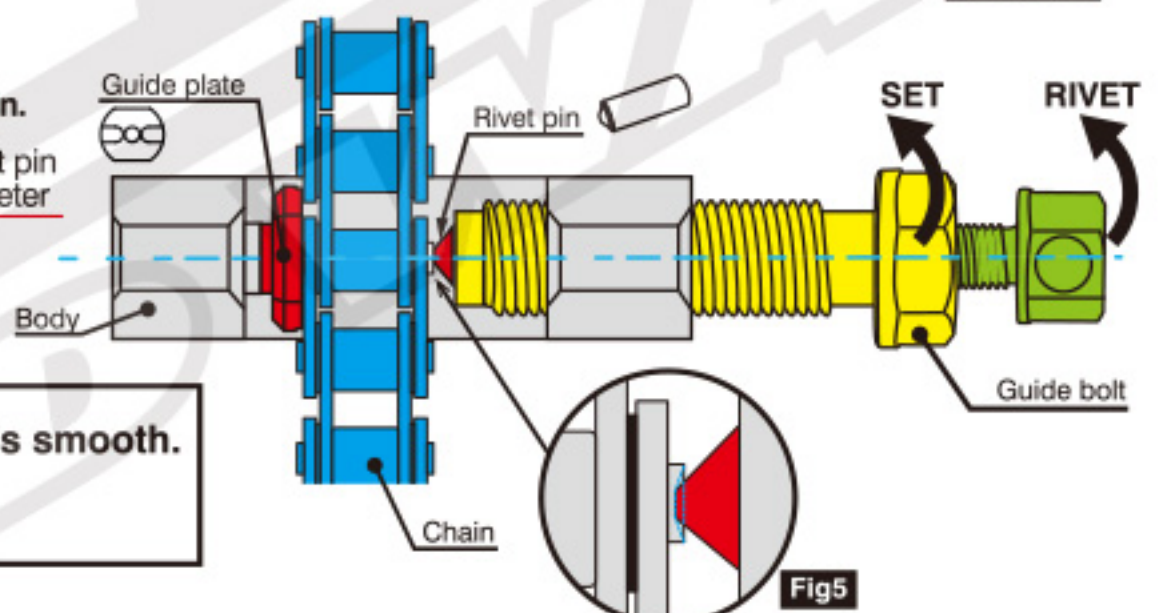
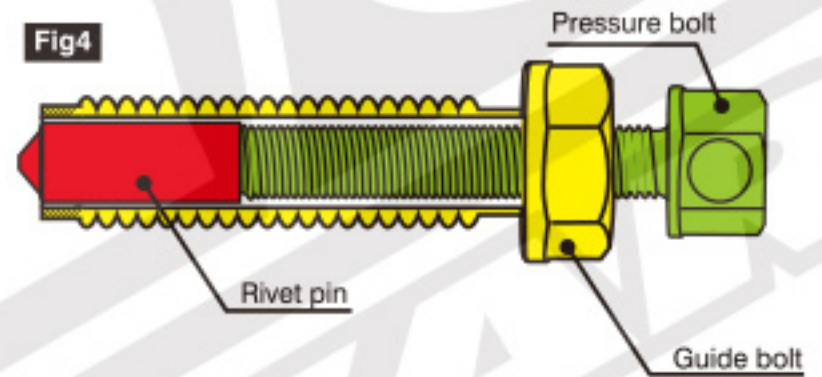


1. Remove Press plate from guide bolt and fit Rivet pin.
2. Adjust Rivet pin head position on guide bolt as shown on right drawing. **Fig4**
3. Tighten Guide bolt and set Rivet pin at center of Joint pin head. **Fig5**
4. Tighten Pressure bolt to rivet the Joint pin.

Check Joint pin head diameter before riveting. Rivet the Joint pin slowly and verify riveted Joint pin head diameter is 0.3mm to 0.4mm larger than Joint pin head before riveting.

*Diameters are rough indications.

Riveted joint pin diameters are different for each chain.



Verification

- Verify that riveted chain link's movement is smooth.
- No crushed O rings.
- No cracks on riveted pin heads.