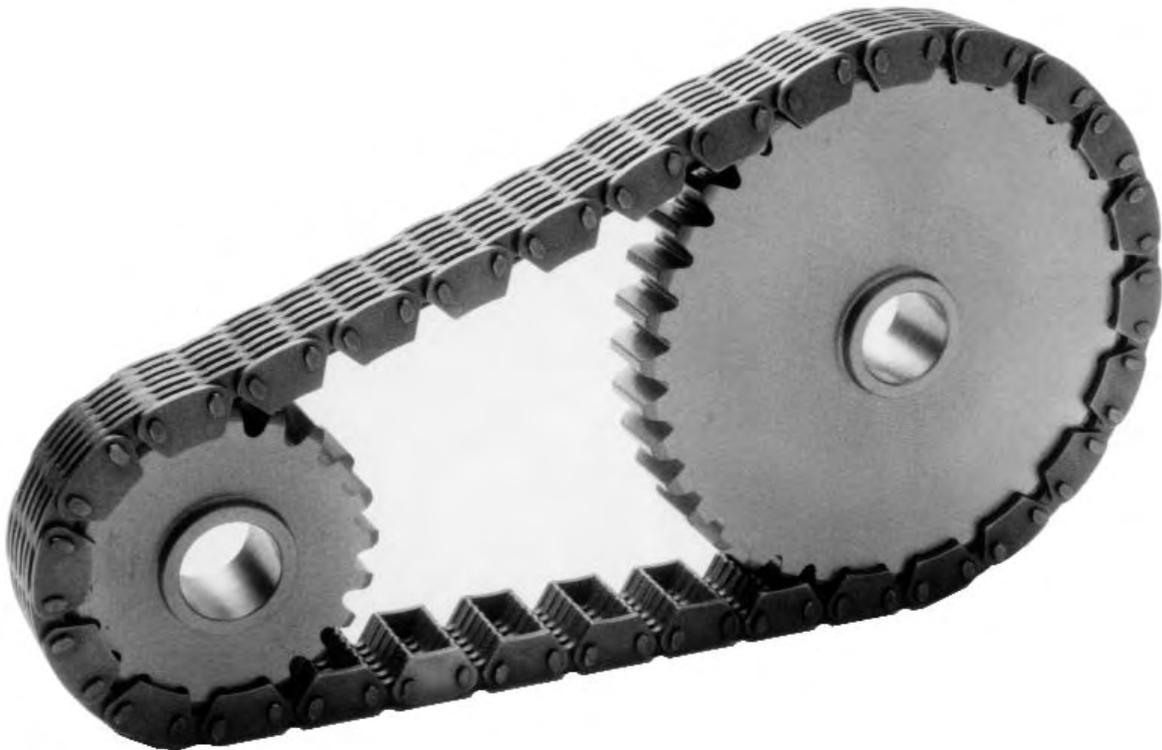


# Instruction Manual

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## Connect/ Disconnect Instructions for Silent Chain



# Contents

	<u>Page</u>
General Information and Safety .....	1
Silent Chain with Two Pin Joints	
Side Guide Chain	
Side link Connection .....	2
Washer Connection .....	3
Center Guide Chain	
Side link Connection .....	4
Washer Connection .....	5
Silent Conveyor Chain with Single Pin Joints .....	6

## General Information

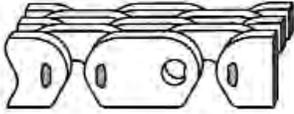
There are a number of industrial silent chain manufacturers in the United States and each produces different types of silent chain. Chains from different manufacturers differ in design and therefore should not be interconnected, nor should their parts be interchanged. These instructions illustrate and describe the procedures for connecting and disconnecting some of the most common silent chains. For information on chains not shown here consult the manufacturer.

## Safety

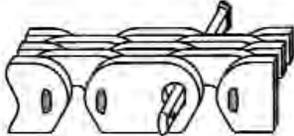
Serious personal injury can result if safety rules are not followed. Observe the following safety precautions when installing a chain:

- \* Shut off power to the equipment and lock out the power switches before installing chains.
- \* Always wear safety glasses to protect your eyes.
- \* Wear protective clothing, gloves, and safety shoes as appropriate.
- \* Support the chain to prevent uncontrolled movement of the chain or parts.
- \* Restrain shafts and sprockets from free rotation where such rotation could permit uncontrolled chain movement and cause personal injury or equipment damage.
- \* Use pressing equipment to remove or install press fit pins or link plates. Keep tooling in good condition and use it properly. If pressing equipment is not available contact the chain manufacturer for additional guidance.
- \* Know and understand the chain construction, including the correct direction for pin removal and insertion, before connecting or disconnecting a chain.

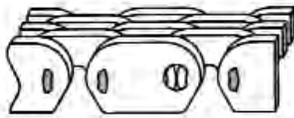
## Connecting Side Guide Chain With a Side Link Connection



1. Bring the ends of the chain together so the holes in the link plates are aligned



2. Insert a drilled connecting pin.



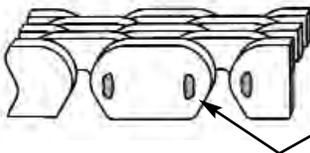
3. Insert a short pin next to the drilled pin, making sure that the convex pin surfaces are facing.



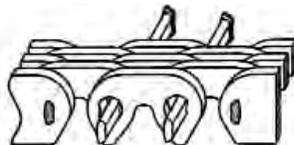
4. Secure the drilled pin using a roll pin.

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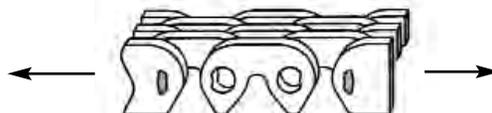
## Disconnecting Side Guide Chain With a Side Link Connection



1. Grind off both pin heads at a side link and remove the side link..



2. Remove both long and short pins from the chain.

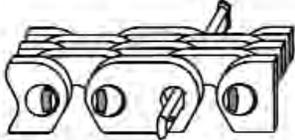


3. Separate the two ends of the chain. Save the loose link plates.

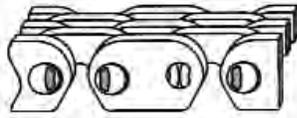
## Connecting Side Guide Chain With a Washer Connection



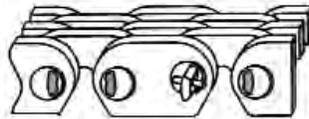
1. Bring the ends of the chain together so the holes in the link plates are aligned



2. Insert a drilled connecting pin.



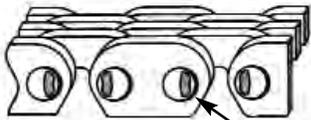
3. Insert a short pin next to the drilled pin, making sure that the convex pin surfaces are facing.



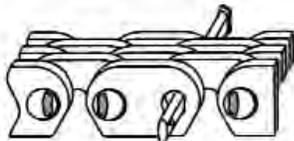
4. Put a washer on the drilled pin and secure with a roll pin.  
Note: Some manufacturers supply annealed pins or cotter pins as an alternative to roll pins.

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## Disconnecting Side Guide Chain With a Washer Connection



1. Grind off one pin head at a side link.



2. Remove both long and short pins from the chain.

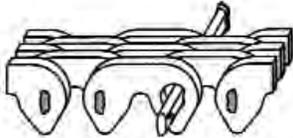


3. Separate the two ends of the chain.

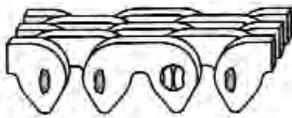
## Connecting Center Guide Chain With a Side Link Connection



1. Bring the ends of the chain together so the holes in the link plates are aligned



2. Insert a drilled connecting pin.



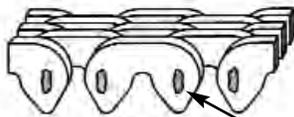
3. Insert a short pin next to the drilled pin, making sure that the convex pin surfaces are facing.



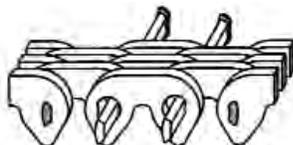
4. Secure the drill pin with a roll pin.

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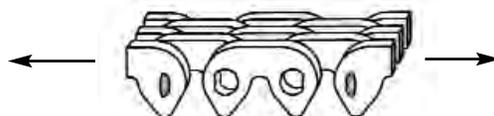
## Disconnecting Center Guide Chain With a Side Link Connection



1. Grind off both pin heads at a side link and remove the side link..



2. Remove both long and short pins from the chain.



3. Separate the two ends of the chain. Save the loose link plates.

## Connecting Center Guide Chain *With a Washer Connection*



1. Bring the ends of the chain together so the holes in the link plates are aligned



2. Insert a drilled connecting pin.



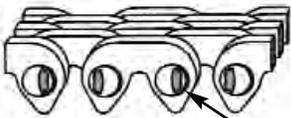
3. Insert a short pin next to the drilled pin, making sure that the convex pin surfaces are facing.



4. Insert drilled pin and secure with a roll pin. Note: Some manufacturers supply annealed pins or cotter pins as an alternative to roll pins.

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## Disconnecting Center Guide Chain *With a Washer Connection*



1. Grind off one pin head at a side link.

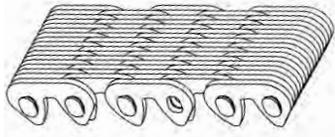


2. Remove both long and short pins from the chain.

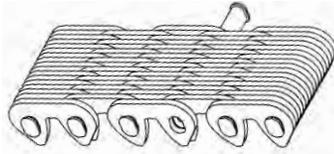


3. Separate the two ends of the chain.

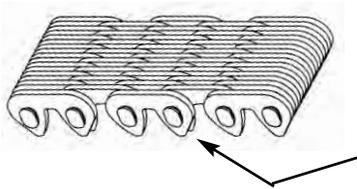
## Connecting Silent Conveyor Chain With a Single Pin Joint



1. Bring the ends of the chain together so the holes in the link plates are aligned



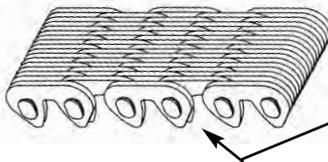
2. Insert a connecting pin.



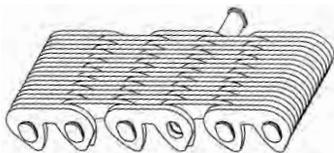
4. Peen the end of the connecting pin. Make sure the peened head is large enough to retain the pin within the chain.

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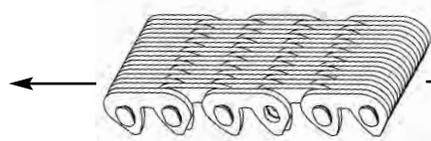
## Disconnecting Silent Conveyor Chain With a Single Pin Joint



1. Grind off one pin head at a side link.



2. Remove the pin.



3. Separate the two ends of the chain.

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