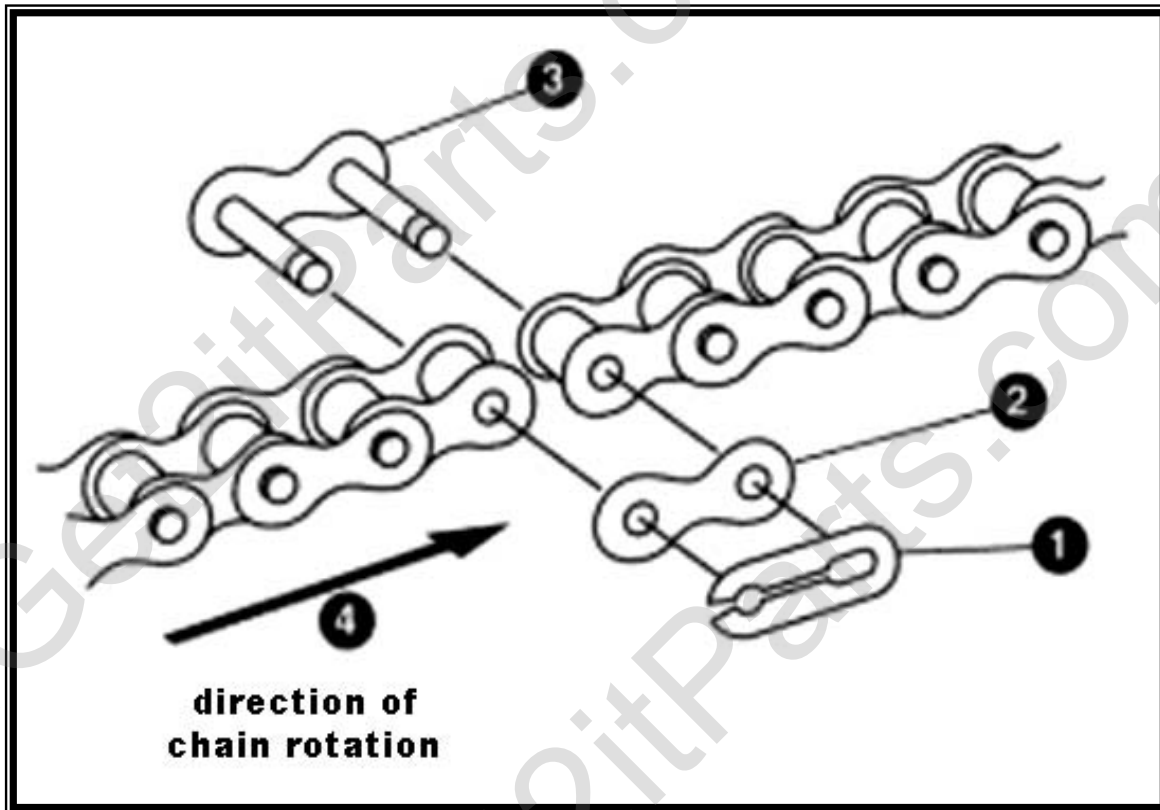


Chain Replacement



Chain Replacement

Removal

1. Remove the guards covering the drive components.
2. Rotate the drive wheel to place the master link (3) in an accessible position between the two sprockets.
3. Slide the retaining clip (1) of the master link (3) until the relief is centered over the link pins. Remove the clip and side plate (2). Slide the master link out and remove the chain.

Installation

- 1. Install new chain.
- 2. Slide the pin portion of the master link (3) in to each end of the chain to be connected.
- 3. Slide the side plate (2) portion of the master link on to the pins.
- 4. Slide the retaining clip (1) on to the pins until the clip snaps securely in to place.

Caution: The master link should be installed with the open end of the retaining clip (1) facing away from the direction of the chain rotation (4).

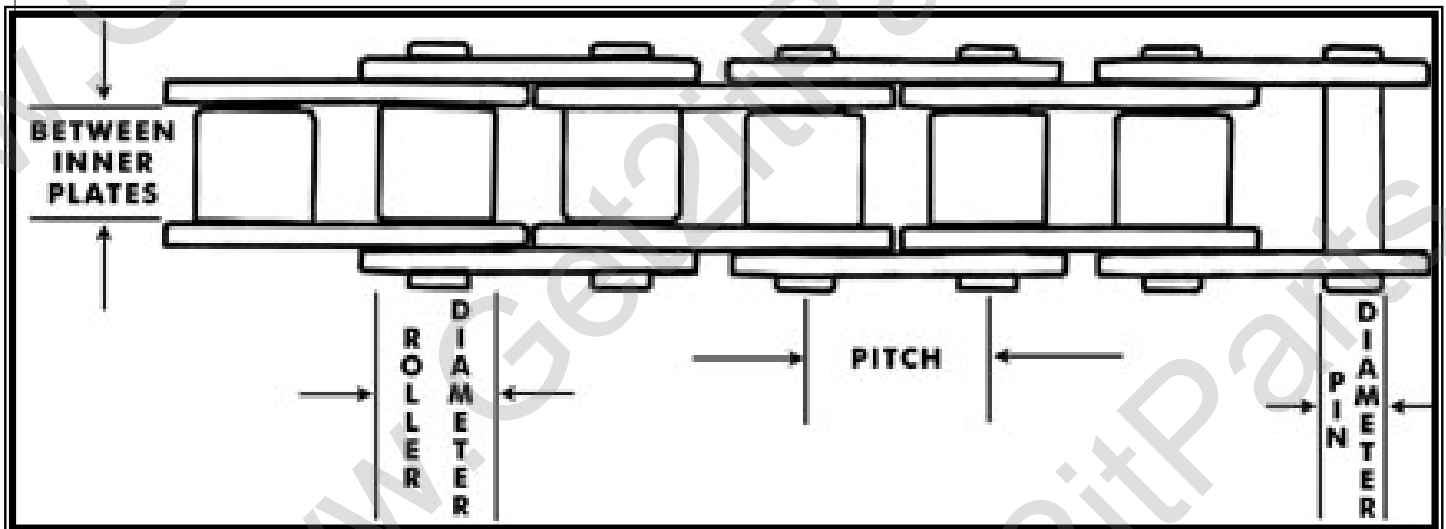


WP-0012
10/01/2003

Chain Replacement

Chain Specifications

Chain No.	Pitch	Roller Diameter	Width Between Inner Plates	Pin Diameter	Pin Length		Inner Plate Depth	Ultimate Tensile Strength	Average Tensile Strength	Weight Per Meter
	Pitch	d1 max	B1 min	D2 max	L max	Lc max	h2 max	Q min	Q0	q
	mm	mm	mm	mm	mm	mm	mm	KN	KN	kg/m
*068B	9.525	6.35	5.72	3.28	13.20	14.10	8.20	9.00	10.00	0.41
415H	12.700	7.77	4.76	3.96	13.10	14.50	12.00	14.40	16.30	0.50
420	12.700	7.77	4.76	3.69	13.10	14.50	12.00	16.00	16.60	0.55
428	12.700	8.51	7.75	4.45	16.70	18.05	12.30	17.80	18.40	0.70
428H	12.700	8.51	7.94	4.45	18.90	20.10	12.30	20.60	21.50	0.79
428HG	12.700	8.51	7.94	4.51	18.90	20.10	12.30	24.60	25.20	0.79
520	15.875	10.16	6.35	5.08	17.70	19.00	15.00	26.50	29.50	0.89
530	15.875	10.16	9.40	5.08	20.90	22.20	15.00	26.50	29.90	1.06
630	19.050	11.91	12.63	5.94	25.90	27.70	18.00	35.00	37.00	1.50



Part Number	Description	Size	Links
650052	Std #420x84L	420	84
650081	Std #520x70L	520	70
650425	Std #420x78L	420	78
650556	Std #520x66L	520	66
650749	Std #520x48L	520	48
700177	Std #420x68L	420	68
810220	O-Ring #520x78L	520	78

