

Work Procedure -- Connecting (Master) Link for Seal Chain --

To make Seal Chain Endless Loop using Connecting (Master) Link
(DID 60LX, DID C2050LX, DID 80LD)

Working Procedure

1. Check the quantity of component inside package.

Plate/Pins Ass'y : Q'ty 1 Cover Plate :Q'ty 1

Seal Ring : Q'ty 4 Spring Clip :Q'ty 1

Chain Grease : Q'ty 1 (See Fig. 1)

2. Apply chain grease over (2) seal rings sufficiently with bare hands for smooth operation and avoiding damage & wear.

3. Insert seal ring into the base of each pin, one seal ring to be inserted to each pin.

4. Make sure that seal ring is positioned to the base of pin.

5. Make sure that chain grease is applied sufficiently over seal ring. Apply additional grease if necessary.

6. Apply chain grease over the pins with bare hands.(See Fig. 2)

7. Apply chain grease inside the bushings that will be connected by master link.(See Fig. 2)

8. Make sure that chain grease is applied over the pins, and insert the pins into bushings.

9. Make sure that chain grease is sufficient between pins and bushings. (See Fig. 3)

Go back to procedure 6 & 7 if it is not sufficient.

10. Apply chain grease over (2) seal rings being left and insert them into connecting pin after procedure 8 & 9.

11. Assemble cover plate into pins. Tools may be required when using interference fit cover plate.

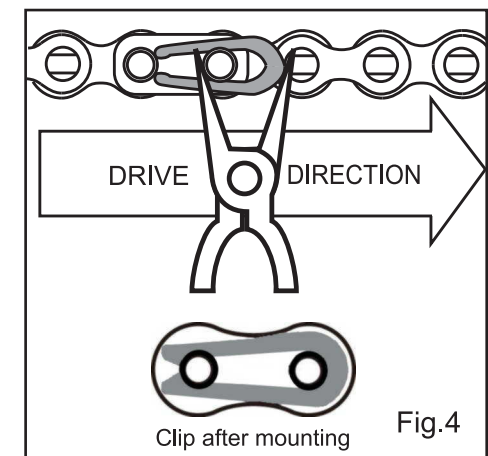
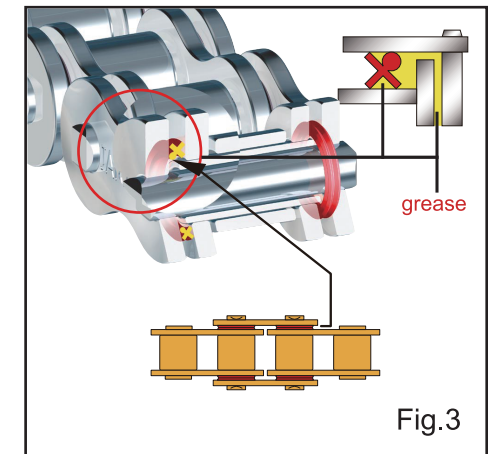
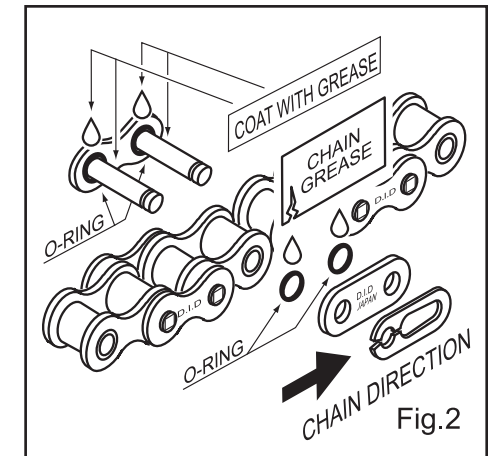
12. After assembling cover plate into pins, make sure that (4) seal rings look the same as the ones inserted at other position of chain body. Check the friction at position where connecting link is assembled, and make sure no significant difference from other position of chain body.

13. Insert spring clip into the pin grooves with right direction.

The head of clip (not open end) to be towards to chain direction. (See Fig. 4)

14. Make sure that spring clip is fitted in exactly with grooves.

Fig.1



⚠ Caution

Handle with bare hand. Do not wear gloves to avoid chain grease to be adhered and/or absorbed to gloves.
Prevent foreign matter from getting into chain grease to avoid damage to seal rings and rust to pins.
Chain Grease is NOT Food Grade. KEEP OUT OF REACH OF CHILDREN.