

## D. Chain installation

### Joining chain ends

Assemble the chain by inserting the steel pin that comes with each chain link, into the opposite end of another link.

#### Tools required

Pliers

Chain tool

#### Procedure

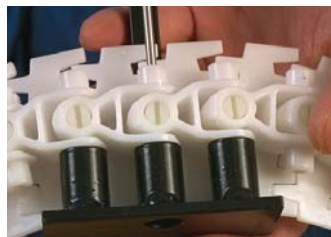
- 1 Insert the plastic pivot with the slot facing outward.



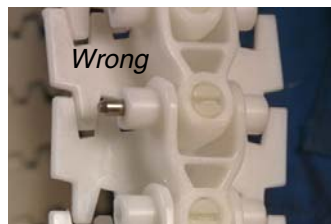
- 2 Insert the steel pin halfway, using a pair of pliers. Always use new steel pins and plastic pivots when joining chain ends.



- 3 Line the chain tool up with the pin. Slowly depress the trigger until the pin seats.



- 4 Check that the chain is flexible in the joint, and that the pin does not stick out or go through the other side.



#### Taking the chain apart:

- 1 Line the chain tool up with the pin.
- 2 Depress the trigger until the pin pops out.
- 3 Depress lever, pull insertion pin out.
- 4 Pull chain apart.

### Preparations for chain installation

- 1 Remove the drive unit transmission cover.
- 2 Release the slip clutch so that the drive shaft is free to turn.
- 3 Remove the side plate on the drive unit.
- 4 Before mounting, run a short piece of chain (1 m) through the conveyor to ensure a smooth running system. If any obstructions are found, they should be removed and the checking process repeated.



### Chain installation

Make sure that the slip clutch is released allowing the drive shaft to turn freely. See page 470.

#### Tools required

Pin insertion tool

X..MJ

#### Procedure

- 1 Insert the chain into the underside of the drive unit. Make sure the chain will be moving in the correct direction, as indicated by the arrow located at the side of all chain links.
- 2 Feed the chain along the conveyor by pulling it through the idler unit and back to the drive unit.



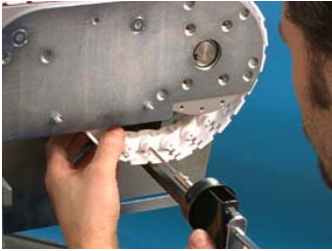
## D. Chain installation (continued)

- 3 Join 5 meter lengths of chain when necessary.



- 4 Remove links if necessary, so that the chain will exhibit some slack at the drive unit. Length adjustment, see page 472.

Join the chain ends.  
See page 471.



### Using a beam section for chain installation

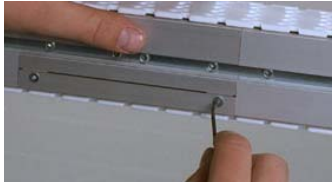
The beam section X\_CC 160/XKCC 200 is used to permit chain installation anywhere along the conveyor.

#### Tools required

Allen key	
Pin insertion tool	X..MJ
Clamp	

#### Procedure

- 1 Loosen the screws on the beam section flanges



- 2 Remove the flange so that the chain becomes accessible.



- 3 Clamp the chain to the beam profile. Use the chain tool to remove a steel pin from the chain, so that two links are separated.



- 4 Remove excess links and use the chain tool to join the chain ends.



### Length adjustment of the conveyor chain

#### End drive, intermediate drive and catenary drive units

- 1 Adjustment of the conveyor chain is carried out at the drive end of the conveyor.
- 2 Remove catenary protection plates to allow easy access for the pin insertion tool.
- 3 The conveyor chain should be tensioned within the conveyor system by pulling down the conveyor chain at the chain catenary in the underside of the drive unit. Clamp across the conveyor chain to trap the chain on to the beam profile. The clamp should be placed over the edges of the drive unit to reduce the risk of damage to the aluminium profile.
- 4 Remove all slack links from the conveyor chain using the pin insertion tool.
- 5 Rejoin the conveyor chain.
- 6 Remove the chain clamp and reinstall the catenary protection plates. The conveyor is now ready for operation.

#### Bend drive units

In a wheel bend drive, the outer aluminium profile can be removed by slackening the set screws in the beam connecting strips. The slide rail must be fitted to allow the removal of this section. A slide rail fastened with rivets must not be longer than the outer bend section.

- 1 After removal of the outer aluminium profile, the conveyor chain can be pulled out of the wheel bend disc. Lift the chain upwards.
- 2 Remove chain links using the pin insertion tool.
- 3 Rejoin the chain ends.
- 4 The tensioned chain can now be pulled back into position on the bend guide disc, and the outer profile put into place.

#### Guided drive units

Drive unit types X\_EB HLG/HRG, X\_EB HLGP/HRGP.

- 1 Adjustment of the conveyor chain is carried out at the idler end unit.
- 2 Undo the screws on one side plate and remove it.
- 3 Undo the screw holding the shaft. Remove the idler wheel together with the shaft.
- 4 Remove the required number of links.
- 5 Reinstall the idler wheel and shaft together with the chain. Tighten the screw that holds the shaft.
- 6 Reinstall the side plates, make sure that the slide rails are properly installed. Tighten the screws.