

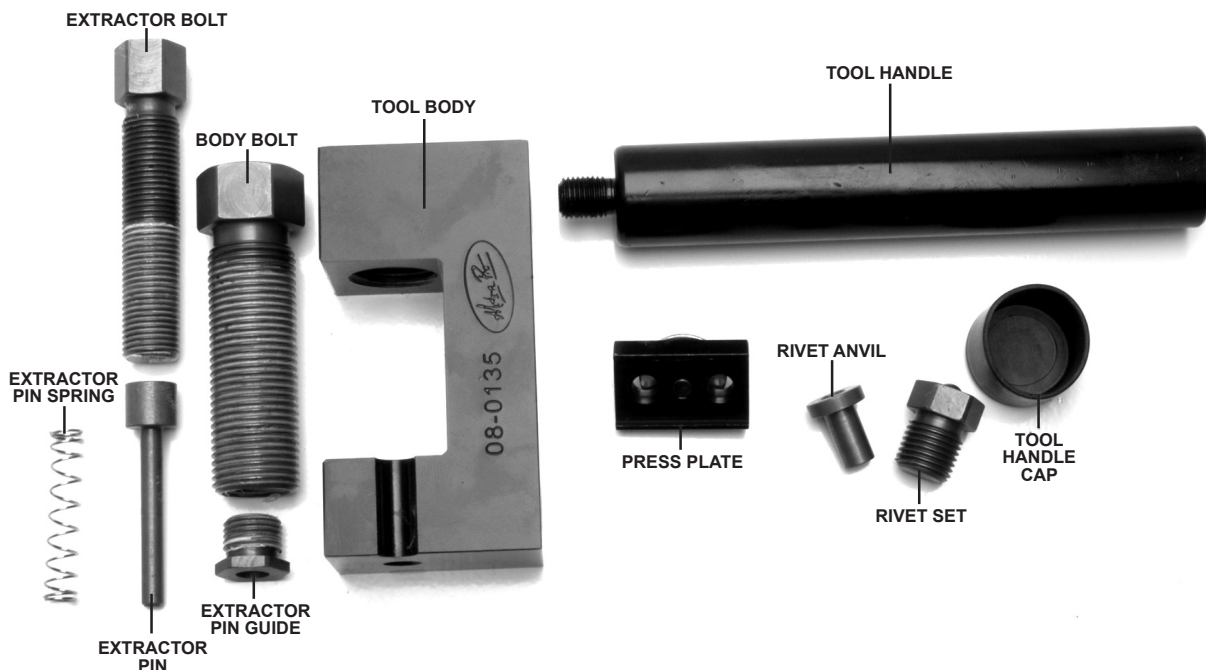


Motion Pro, Inc.
 867 American Street
 San, Carlos, CA 94070
 Tel: 650.594.9600 Fax: 650.594.9610
 www.motionpro.com

INSTRUCTIONS

Motion Pro Jumbo Chain Tool Part# 08-0135

The Motion Pro Jumbo Chain Tool is designed for breaking roller chain from 520 through 630 and will rivet chains up to 530. The tool may be used as a hand held device using the screw in handle. It may also be clamped in a bench vice or bolted to a workbench by using two 3/8-24 bolts [not supplied]. If the tool is bolted to a workbench an air impact driver with 9/16" impact socket may be used.



Jumbo Chain Tool Components

08-0D35	EXTRACTOR PIN	C08-135C	EXTRACTOR BOLT
C08-135E	EXTRACTOR PIN GUIDE	C08-135F	TOOL HANDLE
C08-001D	EXTRACTOR PIN SPRING	C08-135G	RIVET ANVIL
C08-135A	TOOL BODY	C08-135H	RIVET SET
C08-135B	BODY BOLT	C08-135K	PRESS PLATE

TO BREAK CHAIN:

Assemble chain tool with Body Bolt, Extractor Pin Guide, Spring, Extractor Pin and Extractor Bolt in place (Fig 1). Unscrew the Extractor Bolt from the Body Bolt until the Extractor Pin has withdrawn 1/8" into the Extractor Pin Guide (Fig 2). Position the chain pin to be removed between the hole in the Extractor Pin Guide and the corresponding hole in the Tool Body. Using a 13/16" wrench, lightly tighten the Body Bolt until the Extractor Pin Guide rests securely against the side plate of the chain (Fig 3). Next, while holding the Tool Handle, tighten the Extractor Bolt with a 9/16" wrench until the Extractor Pin has pushed the chain pin completely out the opposite side of the chain (Fig 4). Unscrew the Extractor Bolt and then the Body Bolt far enough to remove the tool from the chain.

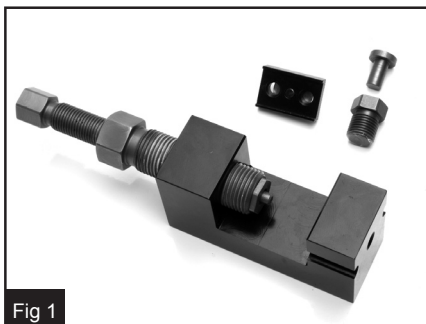


Fig 1



Fig 2

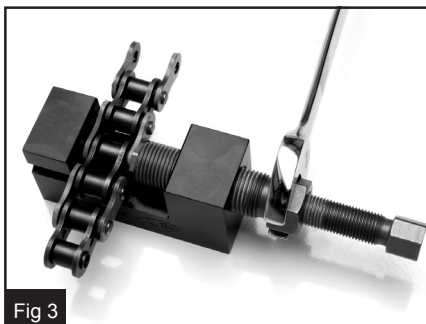


Fig 3

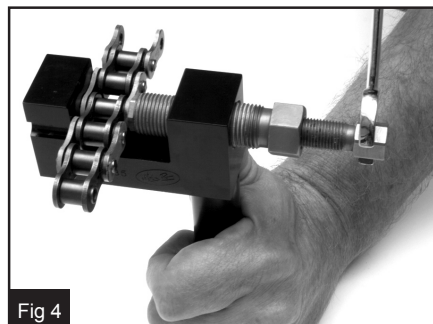


Fig 4

TO INSTALL SIDE PLATE (530 chain and smaller)

Remove the Extractor Bolt, Extractor Pin and Spring leaving the Extractor Pin Guide in place. Insert the Press Plate attachment into the Extractor Pin Guide (Fig 5). Set the chain in place on both front and rear sprockets, apply grease to the pins of the master link and install the link onto the chain. Apply grease to the chain side plate and position the chain in the tool body and the side plate in the Press Plate attachment (a little extra grease on the side plate will help hold it in place on the Press Plate attachment). Using a 13/16" wrench, lightly tighten the body bolt until the side plate is in the proper position (Fig 6).

CAUTION: Be careful to only press the side plate on far enough to allow for proper riveting of the chain. Excessive pressing of the side plate will cause the chain to bind and/or damage to the "O" rings, leading to possible chain failure. If a clip type masterlink is used, remove the tool and install the masterlink clip.

TO RIVET MASTERLINKS WITH A RECESSED DIMPLE IN THE END OF THE PIN.

Unscrew the Extractor Pin Guide from the Body Bolt and screw the Rivet Set into the Body Bolt and place the Rivet Anvil in the proper hole of the Tool Body (Fig 7). Position the chain in the Tool Body at the pin to be riveted. Flare the end of the master link pin to the chain manufacturer specification by lightly tightening the Body Bolt with a 13/16" wrench (Fig 8). Repeat procedure for the other masterlink pin (Fig 9). The specification of the flare vary widely depending on the grade and make of the chain. Only the chain manufacturer can supply this information.

CAUTION: DO NOT ATTEMPT TO RIVET CLIP TYPE MASTERLINKS!

TO RIVET MASTERLINKS WITH ANNEALED SOLID PINS (NO DIMPLE): USE QUAD STAKE KIT MOTION PRO P/N 08-0142



Fig 5

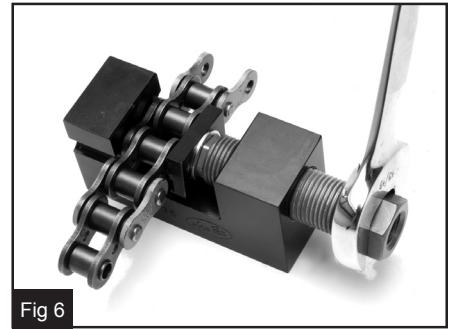


Fig 6

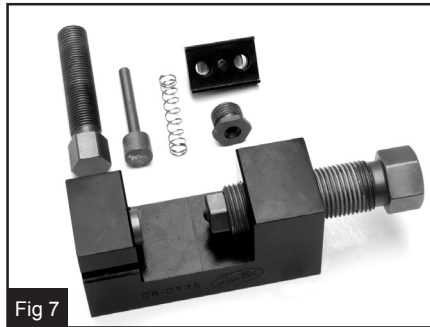


Fig 7

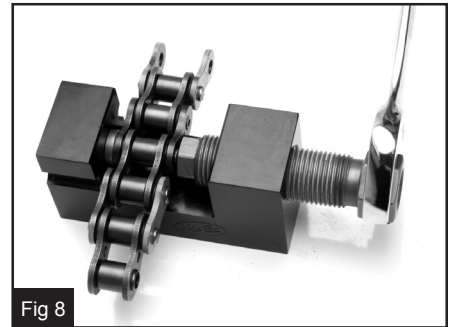


Fig 8

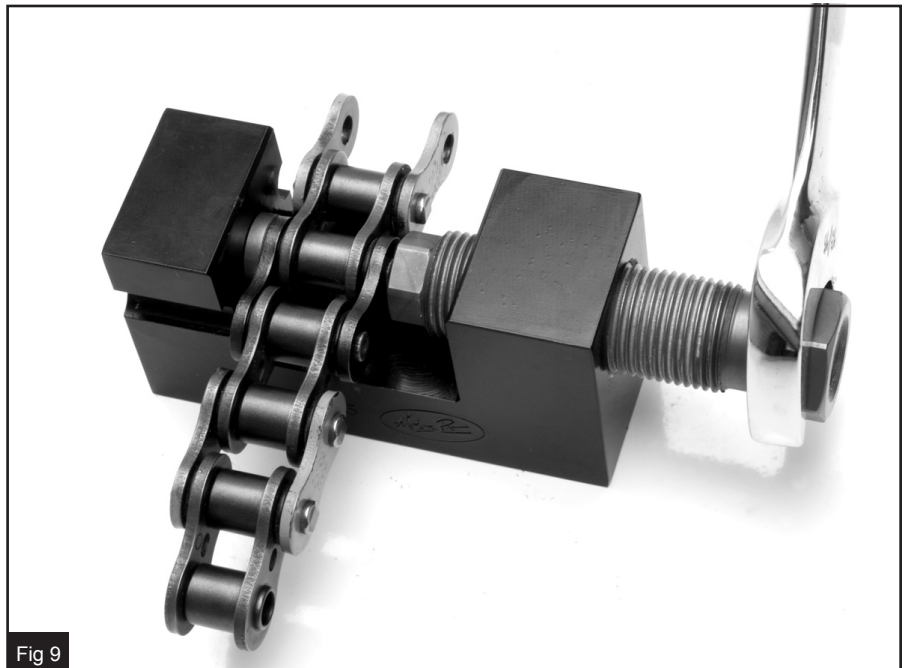


Fig 9

MAINTENANCE TIP:

Periodically clean the threads on the Tool Body, Body Bolt and Extractor Bolt and apply a thin layer of grease to keep the tool working smoothly and reduce wear to the components.