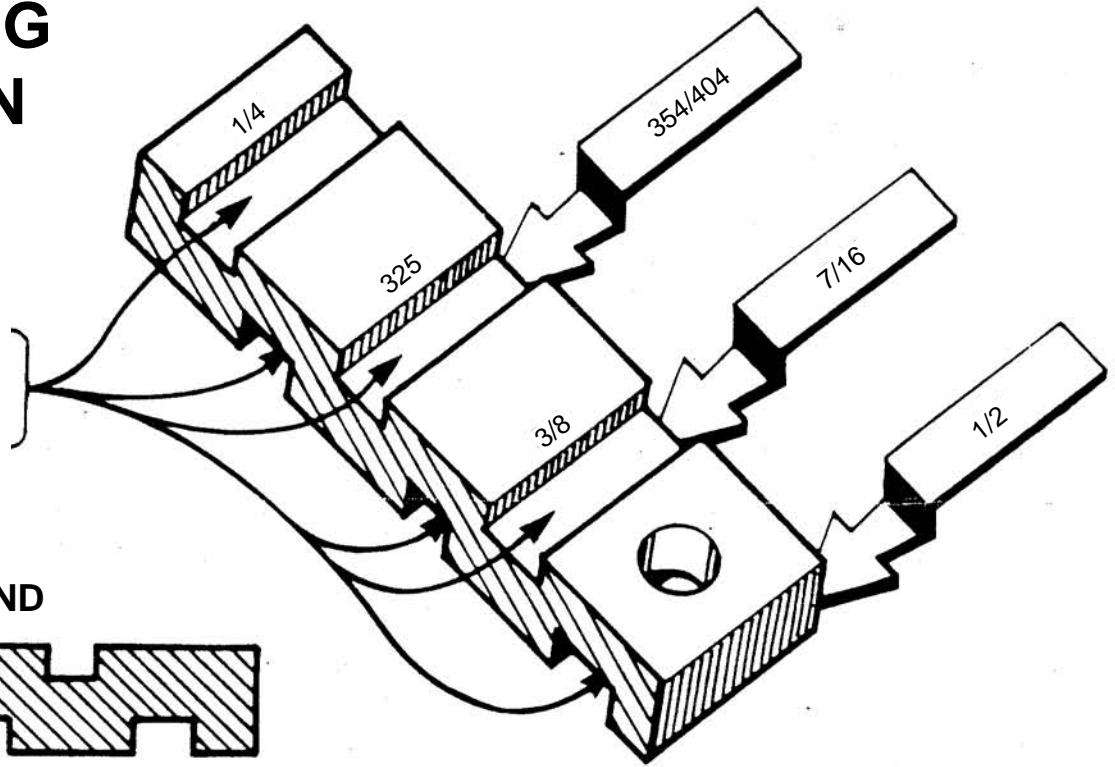
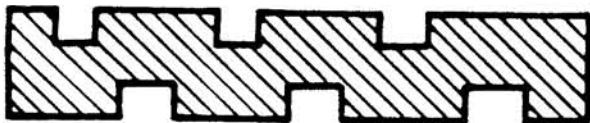


OPERATING THE CHAIN BREAKER

ANVIL HAS 6 DIFFERENT SLOTS...



3 ON ONE SIDE AND



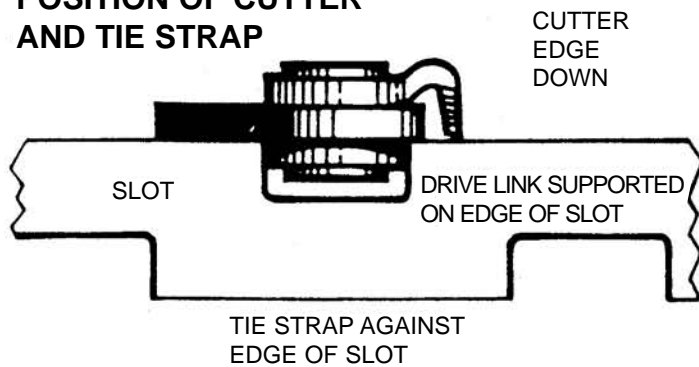
3 ON THE OTHER

AS SHOWN...

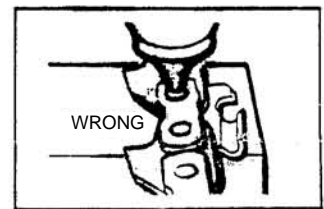
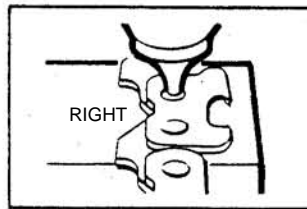
The anvil has six different size slots. To find out the correct size slot for use in breaking the chain, match up the pitch of the chain and the pitch number stamped beside the slot and use that slot.

1. Position the chain in the predetermined slot on the anvil. As shown, push the chain so the bottom tie-strap is flush up against the slot edge so that the drive link is supported by both sides of the slot. NOTE: If the drive link is not supported by both sides of the slot, damage to the punch and chain could result during breaking.

SECTION OF ANVIL... SHOWING CORRECT POSITION OF CUTTER AND TIE STRAP



CAUTION: When breaking at a cutter, be sure to put the cutter edge down against the anvil. Breaking with cutter edge up can damage the cutter.



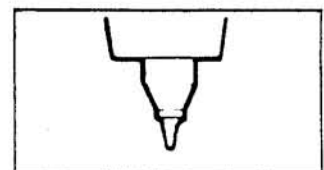
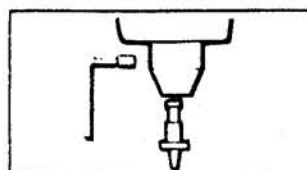
2. Position the anvil and chain on the Breaker base.

3. Move the rivet head directly under the punch so the punch is in the center of the rivet. Note: One punch fits all size chain.

4. Pull the handle down *just far enough* to push out the rivet. Do not use excessive force.

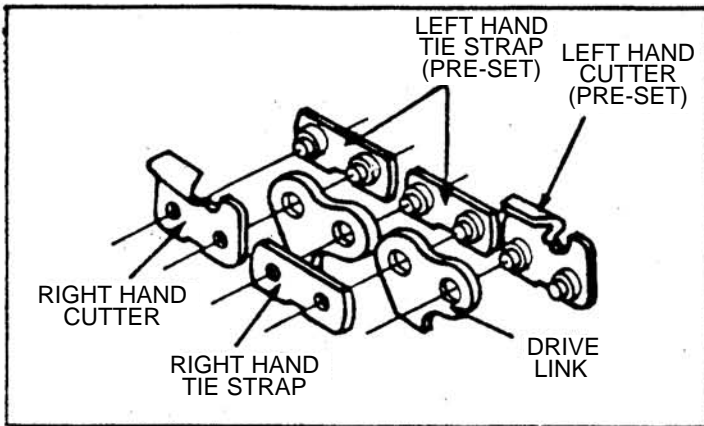
REPLACING A PUNCH

Use a 3/32" hex wrench to loosen the socket head screw which holds the punch in place. Remove the punch by allowing it to drop out. Insert the new punch until it seats itself in the holder then tighten the screw.



CHAIN SEQUENCE

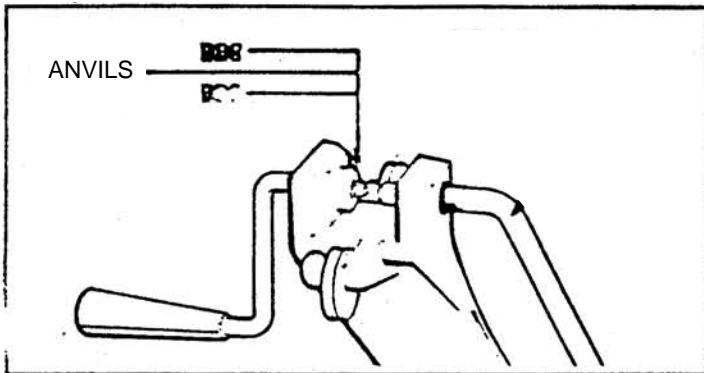
It is important that the proper sequence and position of the cutter (left or right) and drive link be observed when repairing or replacing parts of a chain.



MANUALLY OPERATING THE RIVET SPINNER

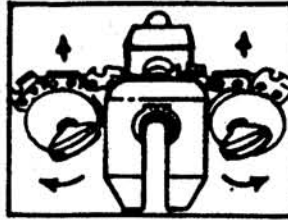
- Choose one of the three anvils listed which corresponds to the size chain being repaired.

"11" anvil	Used on 7/16, 1/2, 9/16, 5/8 and 3/4 pitch chain
"13" anvil	Used on 354, 3/8 and 404 pitch chain
"15" anvil	Used on 1/4, 325, 37 and 375 pitch chain



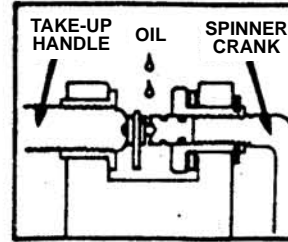
- Place the Spinner crank in the threaded hole on the side of the Spinner (The correct hole is the one with a retaining ring on the outside)
- Choose the Take-up anvil that matches the Spinner anvil.
- Place the letter side of the anvil in the socket opposite the Take-up handle.

- Pick up the chain and lay it across both chain support discs as necessary to give proper elevation and support to the chain being joined.

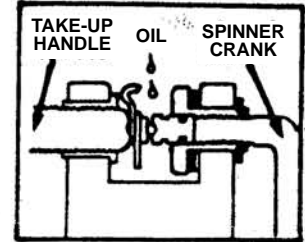


- Position the cutter or tie strap with the pre-set rivet in the recessed end of the Take-up handle.
- Turn the Take-up handle until the un-spun hub of the rivet contacts the Spinner anvil.
- Turn the Spinner crank a few times to center the un-spun rivet hub in the Spinner anvil.

- Apply a few drops of oil to the rivet hub.

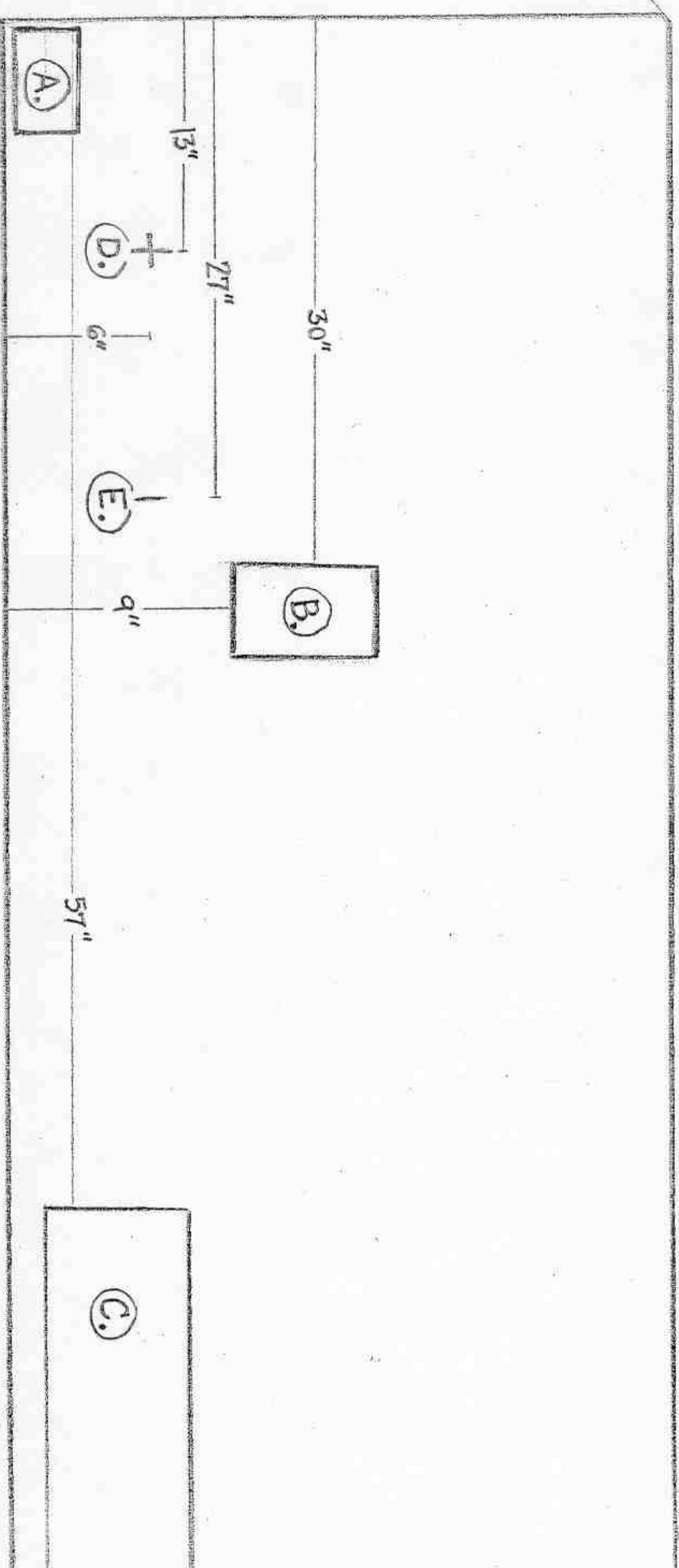
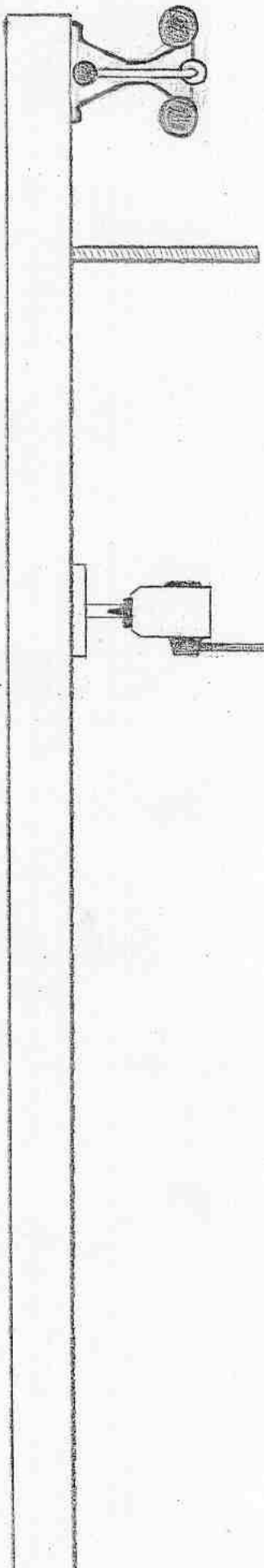


SPINNING TIE STRAP



SPINNING CUTTER

- Turn the Spinner Crank and continue to tighten the Take-up handle until the rivet head is spun tight.



- A. SPINNER
- B. BREAKER
- C. CHAIN CHART
- D. THREADED BOLT STOCK
- E. CUT-OFF MARK