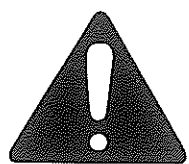
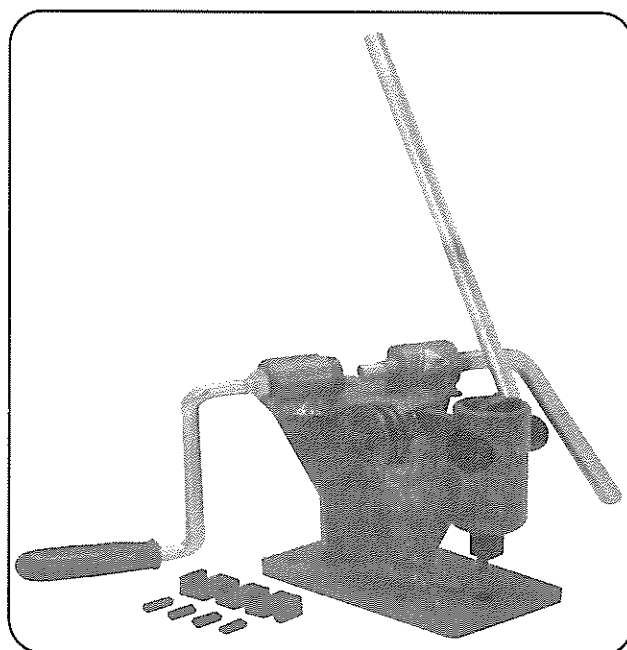
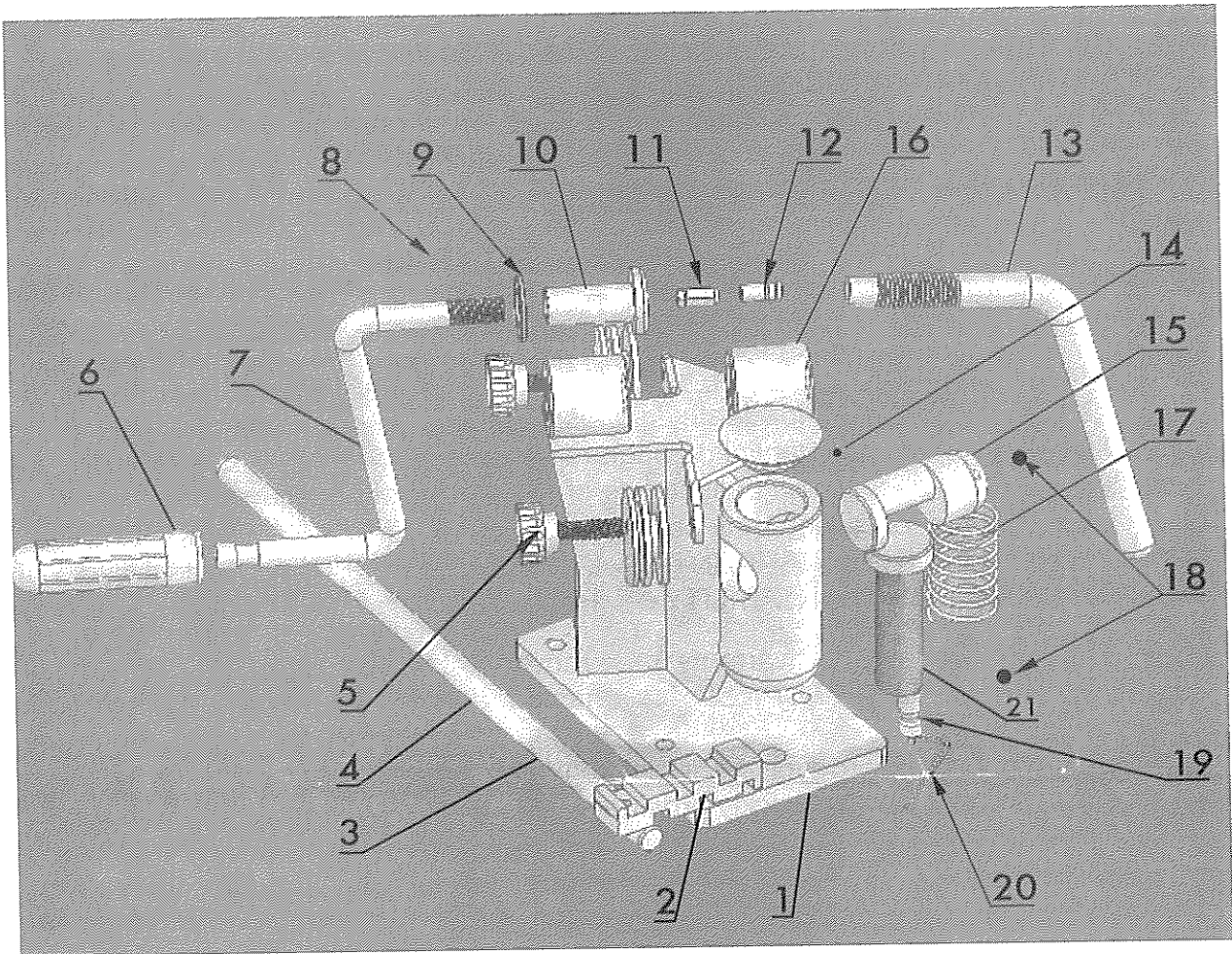


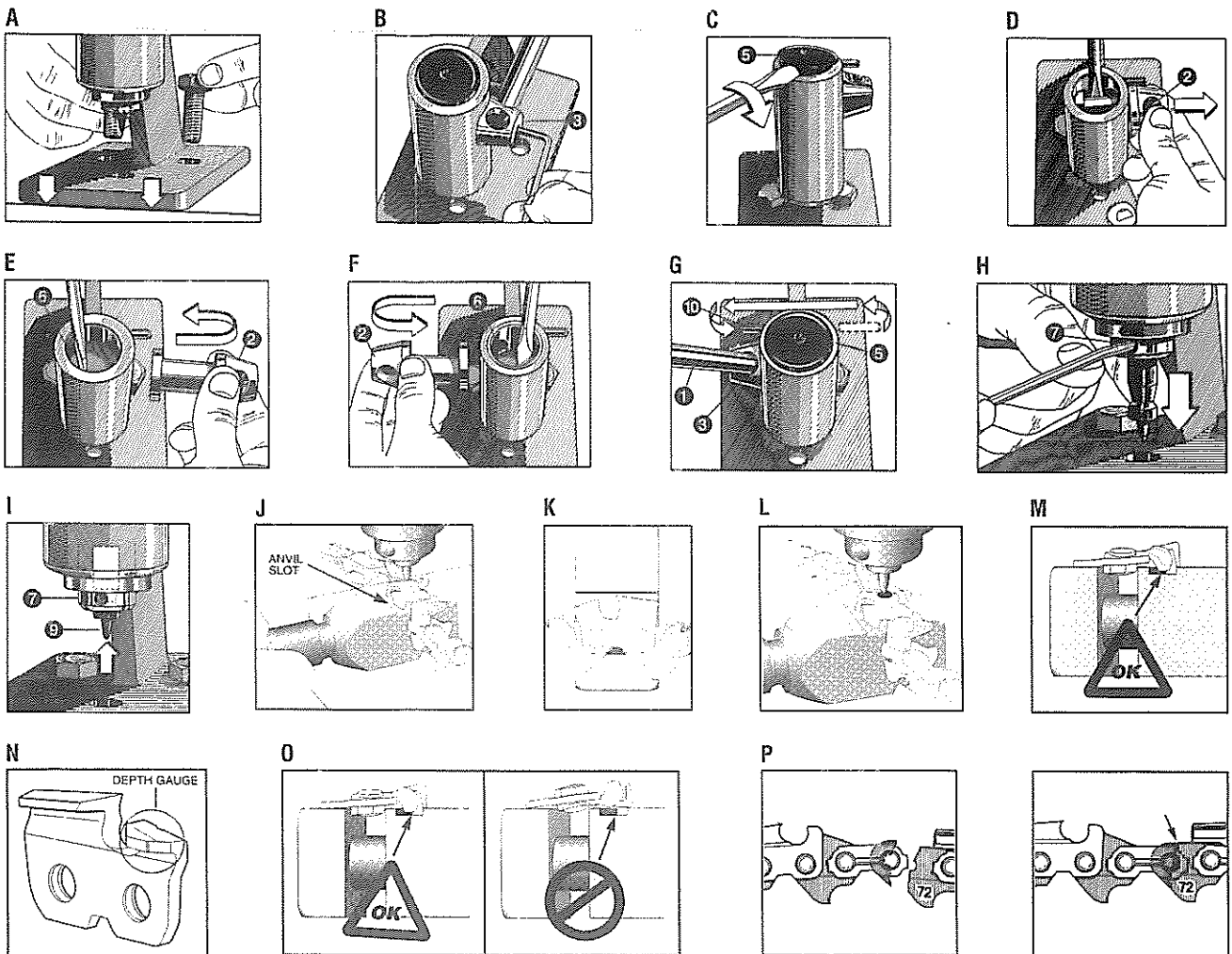
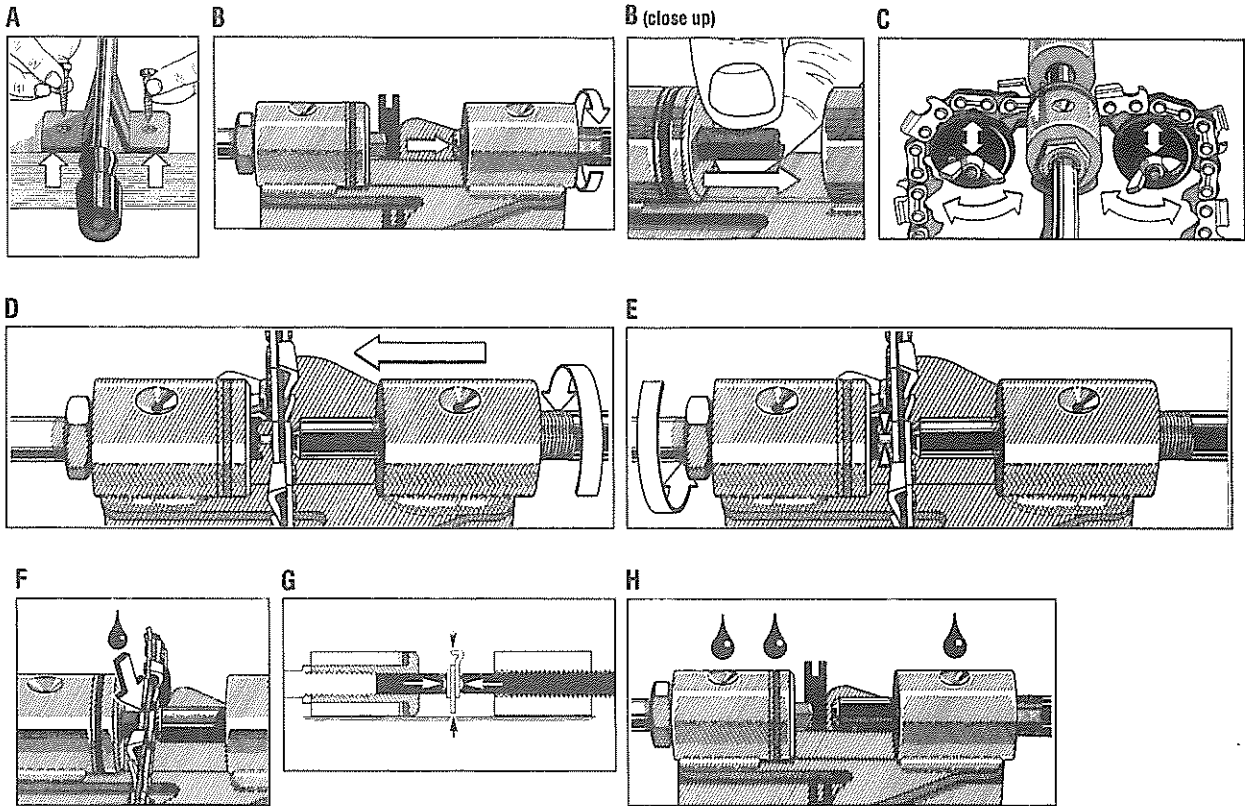
CHAIN BREAKER / SPINNER



**Read this material before using this product.
Failure to do so can result in serious injury.
SAVE THIS MANUAL.**



Part #	Description	QTY	Part #	Description	QTY
1	Base	1	11	Spinner Die	2
2	Anvil	1	12	Thrust Die	2
3	Breaker Lever	1	13	Thrust Handle	1
4	Guide Wheel	2	14	Spring Pin	1
5	Wheel Locking Screw	2	15	Breaker Cam	1
6	Spinner Grip	1	16	Cam Holder Cover	1
7	Spinner Handle	1	17	Spring	1
8	Hex Nut	1	18	Hex Screw m5	2
9	Flat Bearing	1	19	Breaker Punch	1
10	Spinner Sleeve	1	20	Hex Wrench m2.5	1
			21	Tool Holder	1



ENGLISH

Safety Information

- To avoid possible injury to operator and/or bystanders, carefully read all instructions concerning assembly, operation, and maintenance of this tool.
- Make certain that rivet spinner has been mounted securely on flat, clean working surface. Check mounting screws/bolts regularly.
- Check components on rivet spinner regularly for wear and general condition.
- Always wear approved safety accessories for face and hands when using this tool.

Assembly Instructions

Rivet spinner comes supplied already assembled excluding take-up handle (6) and spinner crank (1). See exploded view of product.

BENCH MOUNTING

- Step 1. Rivet spinner is equipped with two holes for mounting. Lag screws or bolts (not supplied) may be used to hold the unit into position. (Illustr. A)
- Mount rivet spinner *flush* with side or front of bench area (Illustr. A). (Mounting rivet spinner flush to bench allows chain to clear for spinning.)

REPLACING SPINNER/ANVIL

- Step 1. To remove worn or damaged spinner/anvil (5), unscrew take-up handle (6) until spinner anvil can be removed easily. (Illustr. B)

Replace with new or correct anvil (5) and take-up handle (6).

NOTE: Unit is supplied with two (2) spinner anvils (5) marked "A" "B" and two (2) take-up handles (6) marked "A" & "B" to match spinner anvils. (See exploded view and chart for correct chain pitch application.)

Operating Instructions

HOW TO SPIN RIVETS

- Step 1. Lay chain across plastic chain supports (8). (Illustr. C)
- Step 2. Rotate plastic chain supports (8) so that the rivet head is centered between the take-up handle pocket (6) and spinner anvil (5). (Illustr. C)
- Step 3. Turn take-up handle (6) until chain is secured against spinner anvil (5). (Illustr. D)
- Step 4. Turn spinner crank (1) a few times to center the rivet hub in the spinner anvil (5). (Illustr. E)
- Step 5. Apply a few drops of oil to rivet hub. (Illustr. F)
- Step 6. Turn spinner crank (1) and, at the same time, slowly turn take-up handle (6) inward (approximately one full revolution) until rivet head is formed. Take-up handle (6) provides pressure while spinner anvil (5) forms rivet head. (Illustr. G)

Maintenance

- Step 1. This unit is equipped with oiling chambers and should be maintained periodically with a lightweight oil. (Illustr. H)

SPINNER ANVIL/TAKE-UP HANDLE CHART

TAKE-UP HANDLE MARKING	"B"	"A"	"B"	"A"	"A"
SPINNER ANVIL MARKING	"B"	"A"	"B"	"A"	"A"
CHAIN PITCH	1/4	3/8	.325	.404	1/2
DRIVE LINK NUMBER	25	72 73 75 76 77 78 91	20 21 22 33 34 35	16 18 26 27 28 50 51 52 57 58 59	9 10

INSTRUCTIONS

Safety Information

- To avoid possible injury to operator and/or bystanders, carefully read all instructions concerning assembly, operation, and maintenance of this tool.
- Make certain that chain breaker has been mounted securely on flat, clean working surface. Check mounting regularly.
- Check components on chain breaker regularly for wear and general condition.
- Always wear approved safety accessories for hands and face when using this tool.

Assembly Instructions

Chain breaker comes supplied already assembled excluding handle portion (1). See exploded view of product.

BENCH MOUNTING

- Step 1. Chain breaker is equipped with two holes for mounting. Lag screws or bolts (not supplied) may be used to hold the unit in position. (Illustr. A)
- Mount chain breaker unit *flush* with side or front of bench area. (Illustr. A)

RIGHT OR LEFT HAND USE

Chain breaker comes ready for right-handed use. If left-handed use is preferred, follow the instructions below.

- Step 1. Unscrew set screw (3) and remove handle (1). (Illustr. B)
- Step 2. Remove plastic cap (5). With screwdriver, depress spring-loaded punch holder (6) to free up cam (2). (Illustr. C-D)
- Step 3. Slide cam (2) out right side of chain breaker unit. (Illustr. E)
- Step 4. Reinsert cam (2) into opposite side of chain breaker unit. Depress punch holder (6) and insert cam. (Illustr. F)
- Step 5. Replace plastic cap (5) and reinsert handle (1). Tighten set screw (3) with Allen wrench (4).
- Step 6. Remove stop pin (10) from right side of unit and reinsert into left side. (Illustr. G)

REPLACING PUNCH

- Step 1. To remove worn or damaged punch (9), loosen set screw (7) with Allen wrench (4). (Illustr. H)
- Step 2. Insert new punch (9) into punch holder (6) (push punch up until fully seated). Tighten set screw (7). (Illustr. I)

Operating Instructions

HOW TO BREAK CHAIN

Step 1. Insert chain portion to be broken into the slot of the adjustable anvil. (Illustr. J) Tighten adjustment knob until chain is securely positioned. Position cutter as shown. (Illustr. K) IMPORTANT: It is not necessary to re-adjust anvil when breaking multiple loops of chain of the same chain type.

- Step 2. Position rivet head directly under punch and pull handle (1) down just far enough to push rivet out (do not use excessive force). (Illustr. L)

NOTE: A. Important - when breaking chain at cutter, make sure cutter is in correct position. (Illustr. M)
B. For cutters with depth gauges as shown in (Illustr. N), make sure to position cutter properly as shown in (Illustr. O) using the side of the adjustable anvil with the slot.

REPLACING BROKEN DRIVELINKS

(Point of breakage usually occurs at or near the rivet hole.)

- Step 1. To remove a cutter or the strap and half of broken driveline, join the two broken sections back to the original position prior to breakage. (Illustr. P)

Step 2. Center breaker punch over rivet head, pull handle down just enough to push rivet out. Repeat with other rivet (do not use excessive force).

Adjustable anvil for use on chains up to 1/2" pitch. Use retrofit kit PN 102616 for 3/4" pitch chain.

Item No. Part No. Description

	24548A	BENCH-MODEL CHAIN BREAKER
1	38592	HANDLE
2	*	CAM
3	*	SET SCREW
4	*	ALLEN WRENCH
5	38595	CAP
6	*	PUNCH HOLDER
7	*	SET SCREW
8	38593	SPRING
9	38594	PUNCH
10	*	STOP PIN
11	105530	ADJUSTABLE ANVIL FOR: 1/4", .325", 3/8" & .404" PITCH CHAIN

* This part is not sold as a replacement part.