

Chain Breaker and Riveting Tool

User Manual

[Revision 4.0 October 2018]

READ THIS MANUAL CAREFULLY BEFORE USE – FAILURE TO DO SO MAY RESULT IN INJURY, PROPERTY DAMAGE AND MAY VOID WARRANTY. • KEEP THIS MANUAL FOR FUTURE REFERENCE. • Products covered by this manual may vary in appearance, assembly, inclusions, specifications, description and packaging.

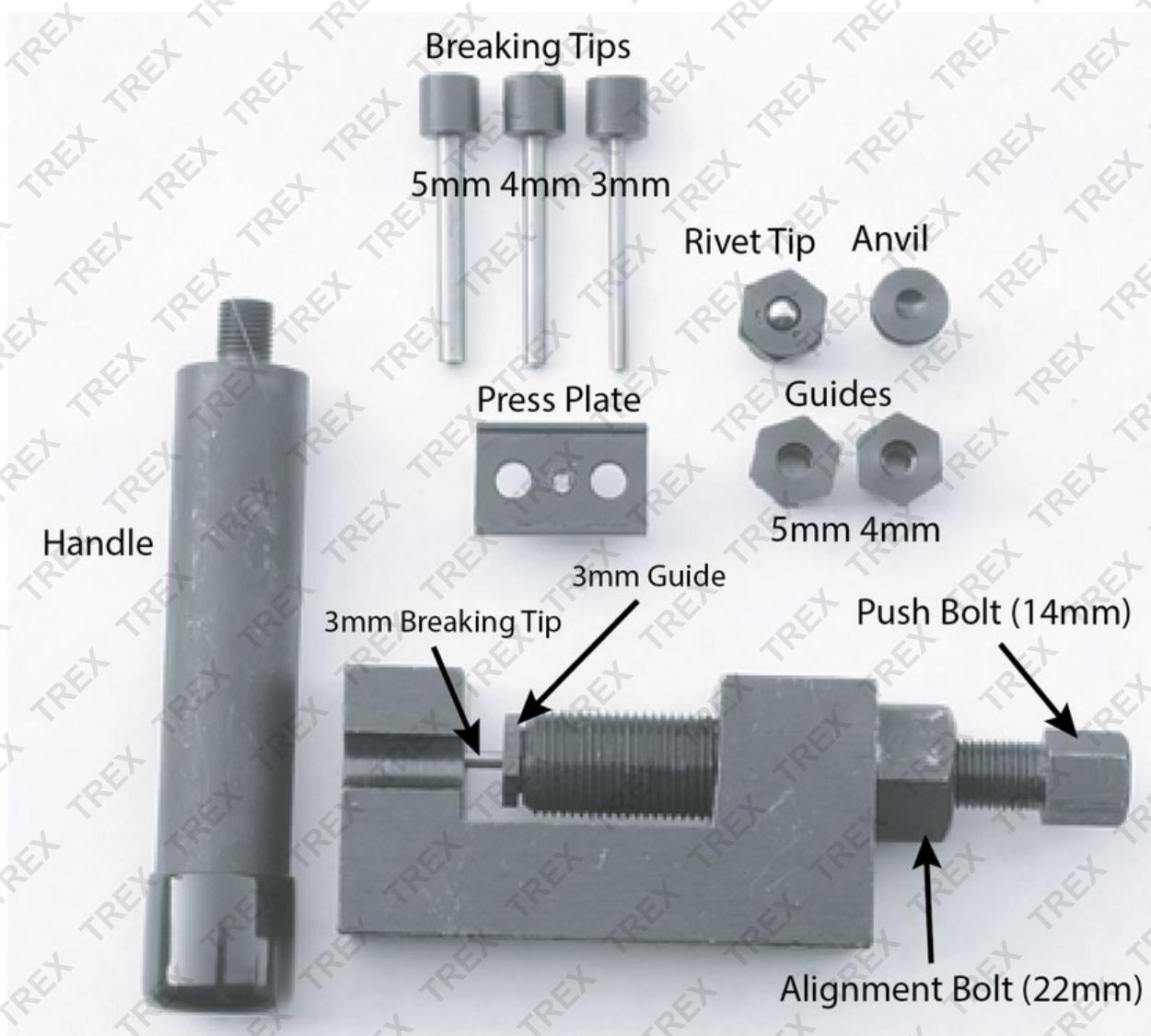
Table of Contents

Safety Reminders	1
Item Details	1
Breaking Chains.....	2
Riveting Chain Pins.....	2
Pressing Side Plate.....	3

Safety Reminders

1. Read all instructions for each procedure before beginning. Improper use of the tool can cause breakage.
2. Ensure handle is attached, fastened and secured before using
3. Ensure 14mm socket or wrench is used when turning the Push Bolt.
4. Make sure the tool is clean and apply a liberal amount of grease to all threads before assembling and using for improved functionality and feel.
5. When breaking #520 or larger drive chain, it is recommended to grind off the rivet heads first. This will significantly reduce the load on the tool and help prevent premature wear or damage to the breaking tips.
6. All tightening procedures are recommended to be performed by hand only, using a 14mm or 22mm wrench. Using power tools of any kind offers a higher likelihood of damaging the tool.

Item Details



Breaking Chains

Use only the correct size breaking tip for your application, or it can be damaged.

The tip that is closest to the chain link pin size, only slightly smaller is the correct one.

Assemble the tool by removing the push bolt from the alignment bolt, installing the spring over the appropriate breaking tip and inserting it into the alignment bolt. You will notice a ball bearing (see photo). Be sure to place the ball bearing on top of the breaking tip before installing the Push Bolt as shown. Thread the appropriate guide into the end of the Push Bolt.

1. Place the tool over the chain with one end of the chain pin held in position by the hole in the body and the other end held by the alignment bolt guide. Be sure the breaking tip is adjusted slightly back into the guide for proper during installation.
2. Tighten the alignment bolt by hand securing the guide against the side chain, be sure not to overtighten. It is not necessary to use a wrench, using your hand will give sufficient tension. It is important to be sure alignment bolt is secured to the side plate as it keeps the breaking pin aligned and supported. Attempting to tighten the press pin while bolt is backed away from side plate can cause damage to the tool.
3. Tighten the push bolt using a 14mm wrench until the chain pin is completely out and through the hole in the tool body. You will feel some initial tension as the chain pin is sheared, but afterwards the breaking tip should push smoothly through the chain link as the pin presses out the other side.

If the pin does not begin to break free, or you don't feel the tip pressing into the chain link smoothly, back out the alignment bolt enough to confirm that the breaking tip is lined up with the chain pin. Once proper alignment is confirmed, adjust the alignment bolt back down to press on the side plate and begin again. Do not use power tools or you may damage the tool.

Riveting Chain Pins

Prepare the tool for riveting by threading the rivet tip into the alignment bolt and inserting the anvil into the hole in the tool body. You will not use the push bolt, or any other accessories for this procedure.

1. The new master link side plates should already be pressed according to the "pressing side plates" instructions and specs. **Do not re-use broken master links, or a clip on type master link.** Position the tool with the hollow end of the chain pin facing the rivet tip, and the solid end facing the anvil in the body.
2. Make sure the alignment bolt is withdrawn enough for the rivet tip to clear the end of the chain pin.
3. Using a 22mm wrench, tighten the alignment bolt tightly until the rivet tip spreads the hollow nose of the chain pin. The end of the chain pin should be flared over the side plate just enough so that the side plate is solidly held in place. Repeat this procedure on the other chain pin. **The amount of flare of a rivet -type master link can vary from as little as 0.006" to no more than 0.028" but please get the specifics from your particular chain manufacturer.** This is a very small amount of flare. Attempting to flare the pin too much can crack and weaken it as well as potentially damaging the tool. Use a calliper to measure the pin before flaring and check it often to ensure you are achieving the proper amount when finished. One rotation of the push bolt equals one millimetre of travel, or 0.039, so a typical finished flare will require less than a full revolution.



It is very important that chain master links be clipped or riveted properly. Improper installation can lead to bodily harm or even death. If you are unfamiliar or uncomfortable with this procedure, please have your work supervised by a qualified technician or bring your vehicle to a qualified facility for repair.

4. After removing the tool from the chain, check to be sure both chain pins show the same size flares. Check that the riveted-on side plate is in line with adjacent links.



Pressing Side Plate

The tool will be assembled using the body, alignment bolt, large guide and press plate. You will not use the push bolt, breaking tip, ball bearing or spring. The press plate will be installed in the guide in the alignment bolt. The base of the tool will support the other side of the chain, but there is no alignment guide, so be sure to visually inspect that you have it straight.

1. Assemble the new chain master link, side plate and O-rings (if applicable) as specified by the chain manufacturer. Place the assembled master link in the tool with the side plate with pins resting on the base of the tool body, and chain link side plate with holes will be placed against the press plate.
2. Tighten by hand only, the alignment bolt until the press plate rests against the master-link side plate. Ensure the master link pins are properly aligned with the groove as well as the holes in the press plates before tightening. The holes in the press plate will help you verify alignment.
3. Measure the width of the chain on a link using a calliper if possible. This will give you the correct dimension for your finished master link side plates and should be confirmed with the link you are working on, to ensure it is correct. Use a 22mm wrench and tighten the alignment bolt until the master link pins protrude past the face of the side plate. For clip-type master links, the pins should protrude enough to install the clip into the grooves in the chain pin. For rivet type master links, the chain pins should protrude enough to be properly flared over the side plate.



Please refer to the chain manufacturer's specifications for the measurements of chain pin protrusion, as well as installation of master link clips. We cannot provide this information as they can all be different.



Some experts believe that the incorrect or prolonged use of almost any product may cause serious injury or death. To help reduce your risk of serious injury or death, refer to the information below. For more information, see www.datastreamserver.com/safety

- Consult all documentation, packaging and product labelling before use. Note that some products feature documentation available online. It is recommended to print and retain the documentation.
- Before each use, check the product for loose/broken/damaged/missing parts, wear or leaks (if applicable). Never use a product with loose/broken/damaged/missing parts, wear or leaks.
- Products must be inspected and serviced (if applicable) by a qualified technician every 6 months. This is based on average residential use by persons of average size and strength, and on a property of average metropolitan size. Use beyond these recommendations may require more frequent inspections/servicing.
- Ensure that all users of the product have completed a suitable industry recognised training course before being allowed access to the product.
- The product has been supplied by a general merchandise retailer that may not be familiar with your specific application or description of application. Be sure to attain third-party approval from a qualified specialist for your application before use, regardless of any assurances from the retailer or its representatives.
- This product is not intended for use where fail-safe operation is required. As with any product (for example, automobile, computer, toaster), there is the possibility of technical issues that may require the repair or replacement of parts, or the product itself. If the possibility of such failure and the associated time it may take to rectify could in any way inconvenience the user, business or employee, or financially affect the user, business or employee, then the product is not suitable for your requirements. This product is not intended for use where incorrect operation or a failure of any kind, including but not limited to, a condition requiring product return, replacement, parts replacement or service by a technician may cause financial loss, loss of employee time or an inconvenience requiring compensation.
- If this product has been purchased in error when considering the information presented here, contact the retailer directly for details of their returns policy, if required.

