





MAXCUT 1 and MAXCUT 3 CHAIN REPAIR FIXTURE P/N: CRF-E

PROCEDURE TYPE	MC1 and MC3 Chains
PROCEDURE NUMBER	Rev 1 2016-11
DESCRIPTION:	Economy Chain Repair Procedure

REQUIRED TOOLS: MaxCut Economy Chain Repair Fixture (P/N CRF-E), Angle Grinder, Drill Press, Flat Blade Screw Driver

REQUIRED PARTS: Chain Link Kit (P/N CLK-MC1 or CLK-MC3), Oil

PROCEDURE

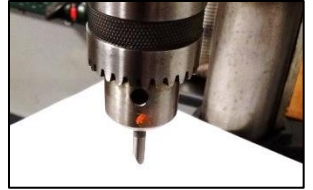
- 1) Insert the Grinding Stone provided with the Repair Kit into an angle grinder.
- 2) Use the angle grinder to grind the rivet heads on the (2) Side Plates connected to the broken Drive Link being replaced.
- 3) After all four (4) rivet heads are ground off, use a flat blade screw driver to pry the (2) Side Plates open. Discard the damaged Drive Link and Side Plates.
- 4) Obtain a Side Plate Sub-Assembly  from the MaxCut Chain Link Kit (P/N CLK-MC1 or CLK-MC3). Join the two Drive Links using the Side plate Sub-Assembly. Orient it with the MaxCut logo toward the top of the chain with the rivet bodies facing upward.
- 5) Place the Side Plate  from the MaxCut Link Kit over the rivets.
- 6) When placing the Clamping Plate over the Side Plate to be riveted ensure that the part is fully seated in the pocket as shown in the figure to the right. Use the holes on the Clamping Plate that correspond to the chain that you are repairing;
 - Use the MC1 holes for the MaxCut MC1 Chain (0.375" pitch).
 - Use the MC3 holes for the MaxCut MC3 Chain (0.456" pitch).
- 7) Place the Side Plate to be riveted onto the Chain Repair Fixture Base. Align the riveting holes in the Chain Repair Fixture Clamping Plate over the rivets on the new Side Plate. Tighten the Allen head screw to hold the link securely in the fixture.





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8) Install the Riveting Bit into a drill press.



9) The picture on the right shows the unformed rivet and the chamfer around it.



10) Put a few drops of oil in the riveting holes. Align the bit with the first riveting hole and begin riveting.



11) Check periodically until the rivet has formed over and is covering the chamfer on the Side Plate. Move to the second riveting bushing and repeat the process.



12) The picture on the right shows a repaired chain section.

