

ESCO® Engineered Class XHC Series Chain Maintenance Procedures

ESCO engineered class XHC series chain may be installed using either the rivet assembly procedure or weld assembly procedure. While the most commonly used is the weld assembly procedure, ESCO strongly recommends assembling chain using the rivet assembly procedure, especially for XHC series chain used in long wood applications. Weld assembly chain is susceptible to high wear to the weld which may lead to failure of the chain assembly.

The steps for each procedure are detailed below and on the next page.

Rivet Assembly Procedure

Step 1

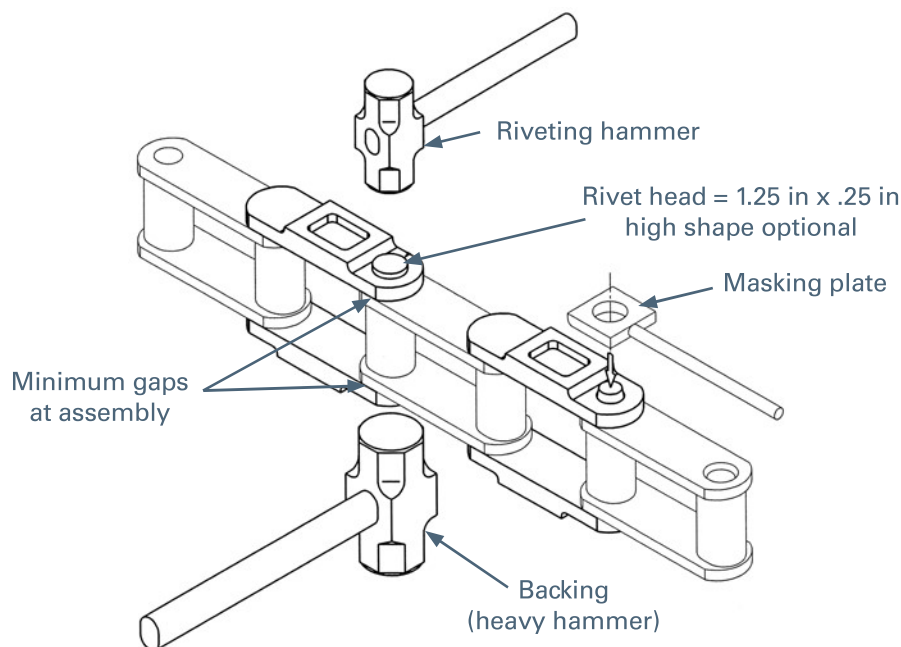
Heat pin end to forging temperature using Rosebud torch tip. Use “Masking Plate” or similar method to minimize heating of sidebar.

Step 2

Peen the pin head over using an appropriate sized riveting hammer to the size noted in the illustration. Peen the head of the chain pin until it is approximately 1.25 in wide and .25 in high above the side bar.

▲ NOTICE - DAMAGE ALERT: ESCO recommends using the rivet assembly procedure for ESCO XHC series chain systems used in long wood applications. If the rivet assembly procedure is not used, chain link failure may result.

▲ WARNING: Strike only the heated pin head. Striking the side plates may result in flying shards.

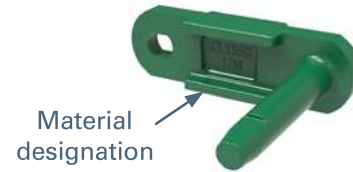


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Weld Assembly Procedure

Step 1

Determine what material your sidebar/pin components are made of. The material designation (12M, 12E, or 49K) is cast on the inside of the sidebar (along with the part number).



Step 2

Assemble the chain components in position on the conveyor.

Step 3

Slip the washers supplied with your chain over the end of the pin extending through the hole in the block links.



Step 4

Choose the appropriate electrode for the material.

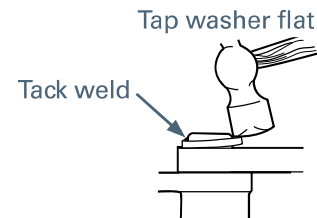
- a. Alloy 12M and alloy 12E: E-7016 or E-7018 low hydrogen electrode.
- b. Alloy 49K: Stainless steel 309 or 410 high carbon electrode.

IMPORTANT: For complete weld information and for selection of the correct weld material, refer to ESCO® Weld Procedures, literature number P6000GEN.

IMPORTANT: To obtain the proper amperage and voltage for your electrode size, refer to the electrode manufacturer's specifications.

Step 5

The surface of the washer and pin should be clean and dry, and any paint should be removed from the area of the pin to be welded. Use a wire brush or emery cloth. DO NOT grind the end of the pin.

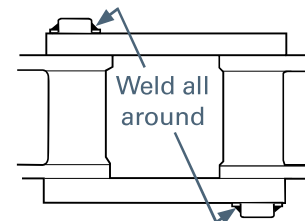


Step 6

Tack-weld the washer in place. The head of the weld may cause the opposite end of the washer to warp slightly. If so, use a dead-blow hammer to flatten it out before applying the full weld.

▲NOTICE-DAMAGE ALERT: The heat of the weld may cause the washer to warp slightly. The washer must lay flat prior to welding to ensure the link is properly assembled.

▲WARNING: Do not hammer on hardened steel which may result in dangerous flying shards. Use a dead-blow hammer to flatten the washer if it becomes warped.



Step 7

Weld all the way around the washer with a 5/16" fillet. Start the weld on the opposite side of where the tack weld is located. Proper welding will ensure the chain will deliver optimum performance.