

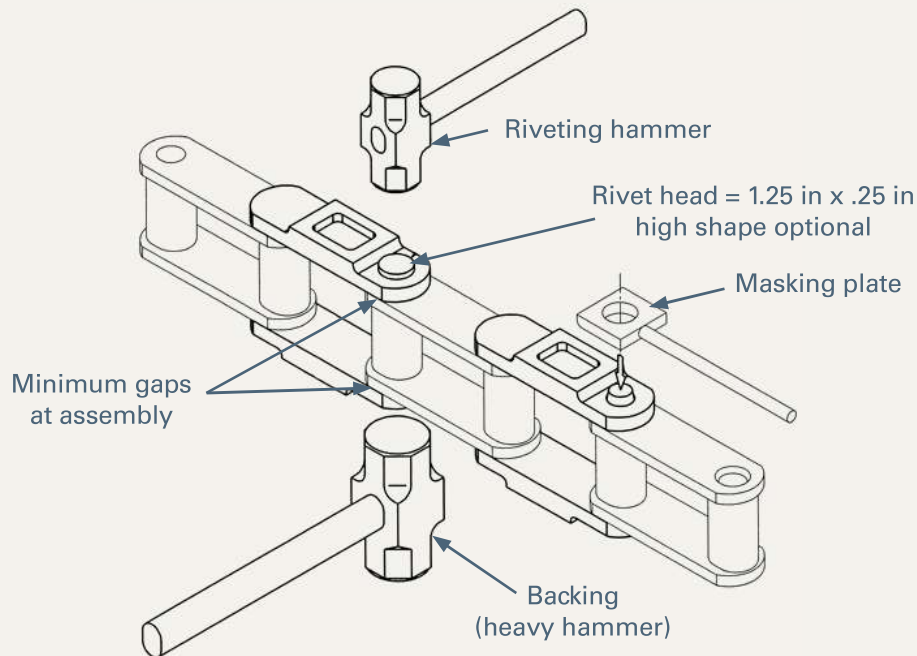
The steps for each procedure are detailed below and on the next page.

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

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: *Uniking recommends using the rivet assembly procedure for 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.*



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).



Assemble the chain components in position on the conveyor.

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



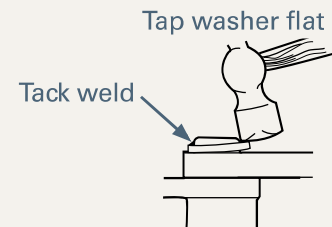
Choose the appropriate electrode for the material.

- Alloy 12M and alloy 12E: E-7016 or E-7018 low hydrogen electrode.
- 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.

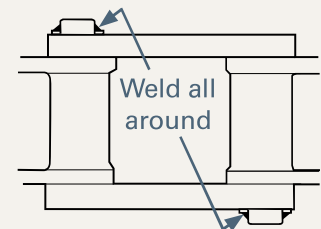
The surface of the washer and pin should be clean and dry, and any paint should be removed from the area of the pin to be welded. Use a wire brush or emery cloth. DO NOT grind the end of the pin.



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.



Weld all the way around the washer with a 5/16" fillet. Start the weld on the the chain will deliver optimum performance.