RexPro™ Engineered Steel Chain Field Connection Installation Instructions

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FORM
10513E
Revised
July 2022

⚠ WARNING Indicates a hazard which, if not avoided, could result in serious injury or death.

⚠ CAUTION Indicates a hazard which, if not avoided, could result in minor or moderate personal injury.

NOTICE Indicates information considered important, but not hazard-related (e.g. messages relating to property damage).

GENERAL SAFETY INSTRUCTIONS

⚠ WARNING

- Read and follow all instructions carefully.
- Disconnect and lock out power before installation and maintenance. Working on or near energized equipment can result in severe injury or death.
- Do not operate equipment without guards in place. Exposed equipment can result in severe injury or death.

⚠ CAUTION

- Perform periodic inspections. Equipment may fail prematurely and could become unsafe if not properly inspected and maintained.

TOOLS REQUIRED

Use only professional tools, devices, auxiliary materials, etc.

- Impact driver (750 lb-ft minimum)
- Hammer (3-5 kg / 6-12 lb)
- Cloth / shop rag (clean)
- Tape Measure

RECEIVING

Inspect for damage which may have occurred during shipping.

INSTALLATION

WARNING! Improperly assembled chain may result in chain failure. Falling chain can result in severe injury or death.

WARNING! Chain segments should not be connected under tension or loaded. Field Connection Link should not take any load until assembly process is complete. Failure to do so could result in severe injury or death.

Step 1: Remove Nuts, Washers, and C.S. Sidebar.
Field Connection Link is shipped loosely assembled. Loosen nuts and remove from pins. Remove washers and C.S. sidebar (stamped with a "C") from pins.

Step 2: Inspect Pins and Nuts:
Parts should be free of nicks, burrs, and damage to threads.

Step 3: Clean and prepare components:
Using a clean cloth, wipe clean the connecting Pins, Washers, Nuts, and internal diameter of the bushings of the chain segments to be joined. Components should be clean and free of debris or contaminants.

When chain includes seals:

- Wipe clean the outer area of the sidebar which the seals will come in contact with, including the seal retaining feature on the end of the bushings.
- Install the seals and seal housings into the seal retaining feature of the bushings.
- Spread lubricant from the tube into the bushing internal diameters and along the surfaces of the sidebars where the seal comes in contact.

Step 4: Install Pin Link
Position the block (bushing) link ends of the chain segments to be joined. Align the bushing internal diameters with the Pins of the pin link.

Insert each Pin of pin link by hand through the block (bushing) link end of chain segments to be joined.

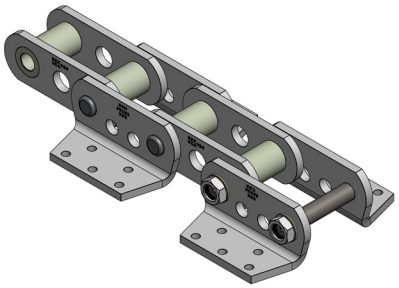

Figure 1

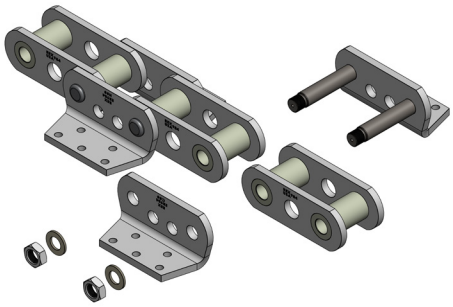

Figure 2

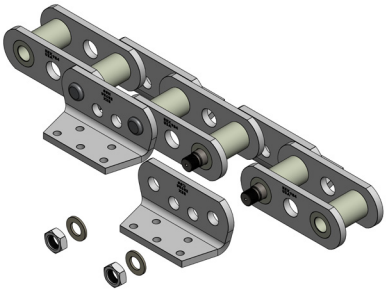

Figure 3

REXPRO™ FIELD CONNECTION LINK

Step 5: Lubricate Pins
To aid installation, generously apply lubrication from the tube to the Pin shoulder, Pin threads, and exposed diameter.

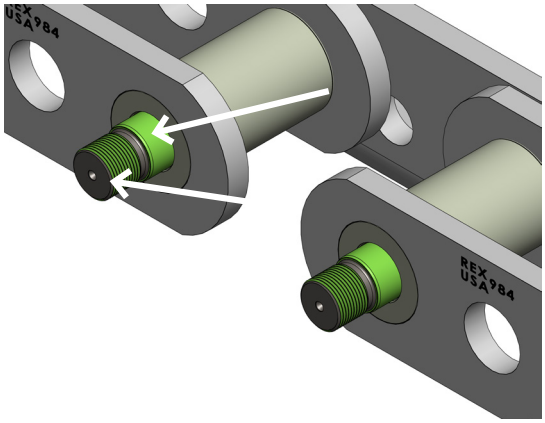

Figure 4

Step 6: Clean and Prepare C.S. Sidebar
Using a clean cloth, wipe clean the pitch holes of the C.S. Sidebar. Pitch holes should be clean and free of debris or contaminants.

When chain includes seals:
- Wipe clean the outer area of the sidebar which the seals will contact.

Step 7: Install C.S. Sidebar
Insert C.S. Sidebar by hand onto the pins. The pitch holes should align with the pin diameters. Pin shoulder should be partially inserted into the C.S. Sidebar pitch holes.

NOTICE: Make sure the stamp faces outward and the attachment orientation of the connection link matches links in the chain segment.

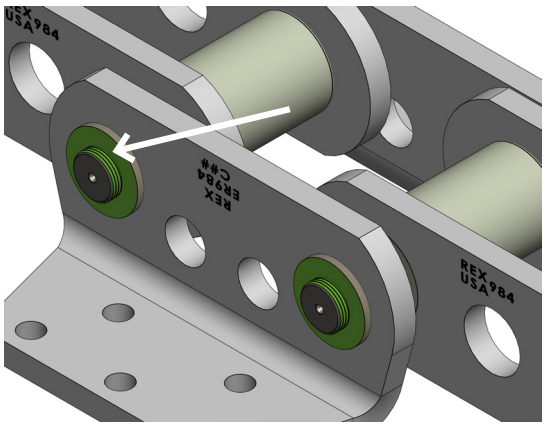

Figure 5

Step 8: Install and Lubricate Washers.
Slide washers onto pins until they rest against the C.S. Sidebar.

Apply lubricant from the tube to outward-face of Washers

Step 9: Install Nuts.
Tighten Nuts until finger-tight. Confirm C.S. Sidebar alignment with Pins.

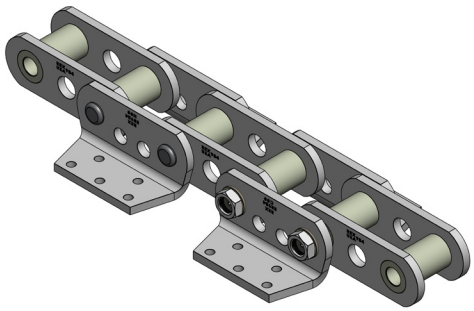

Figure 6

Step 10: Tighten Nuts to secure connection.
Alternating between Nuts every 1 revolution, tighten Nuts with an impact driver until the Washer hits the hard-stop and the C.S. Sidebar is fully seated on the Pin.

Using a tape measure, confirm distance between C.S. and H.S. Sidebars matches dimension listed in Table 1.

WARNING! Failure to tighten Nuts in an alternating pattern could result in misalignment, premature chain failure, severe injury, or death.

Step 11: Confirm articulation.
All articulation points shall be flexible and free of obstruction.

If the joint does not flex, loosen Nuts by ½ turn and firmly strike the threaded end of the Pin with a 3-5 Kg (6-12 lb) hammer to loosen the joint.

CAUTION! Failure to loosen the chain joint will cause erratic chain action and could result in damaged equipment and personal injury. The chain must flex freely.

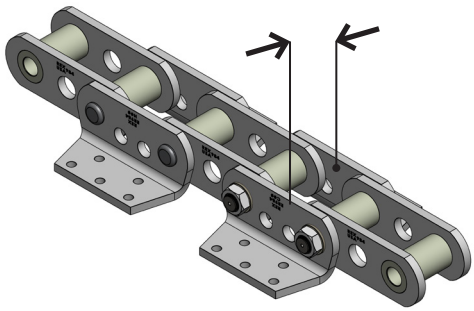

Figure 7

REXPRO™ FIELD CONNECTION LINK

Chain	Between H.S. and C.S. Sidebars	Nut Size (Grade 5 or higher)	Socket Size
R2296ML- G165	3.313″ ±0.030	5/8″ – 18 UNF Thin Hex Nut	15/16″
ER856ML-K3, -K23, -K24,-K26,-K35,-K66	4.062″ ±0.030	7/8″ – 14 UNF Thin Hex Nut	1-5/16″
ER857ML-K3, -K44	4.062″ ±0.030		
ER859ML-K44	5.120″ ±0.030		
ER864ML-K443	5.120″ ±0.030		
ER956ML-K24	4.062″ ±0.030		
R4004ML-G5, -G5 AYE, -G6	3.687″ ±0.030		
SJM857ML	4.438″ ±0.030		
SJM859ML-K44	5.592″ ±0.015		
SJM864ML-K443, K443 HT	5.542″ ±0.015		
SJM956ML-K24	4.062″ ±0.030		
2864ML-G4	3.813″ ±0.030	1″ – 14 UNS Thin Hex Nut	1-1/2″
ER958ML-K44	4.190″ ±0.030		
ER979ML-K44	5.125″ ±0.030		
ER984ML-K443	5.125″ ±0.030		
ER2866ML-K443	5.875″ ±0.030		
ER7984ML	5.120″ ±0.030		
SJM958ML-K45	4.720″ ±0.030		
SJM984ML-K443, -K443 HT	5.542″ ±0.015		
R3250ML-G6	4.875″ ±0.030	1-1/4″ – 12 UNF Thin Hex Nut	1-7/8″
R4037ML-G5, -G6	4.625″ ±0.030		
R4010ML-G16	4.625″ ±0.030		