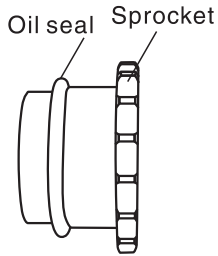
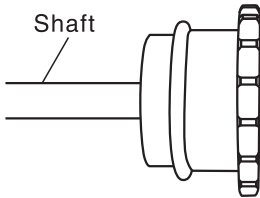


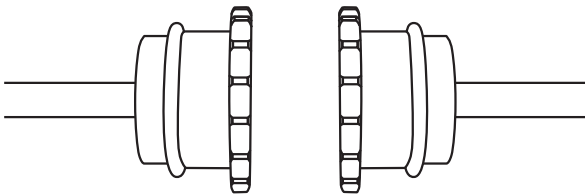
Step one: Place the o-ring oil seals over each of the sprocket hubs.



Step two: Place the sprockets onto the shaft with the sprocket teeth facing each other.

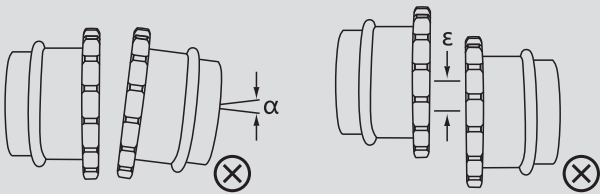


Step three: Slide the sprocket faces together and check for angular and offset misalignment.

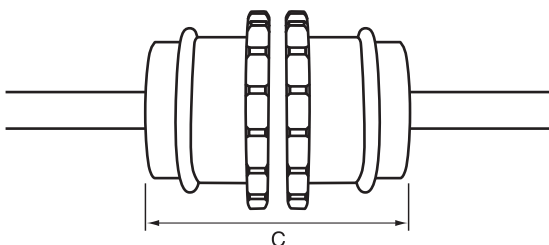


Note:

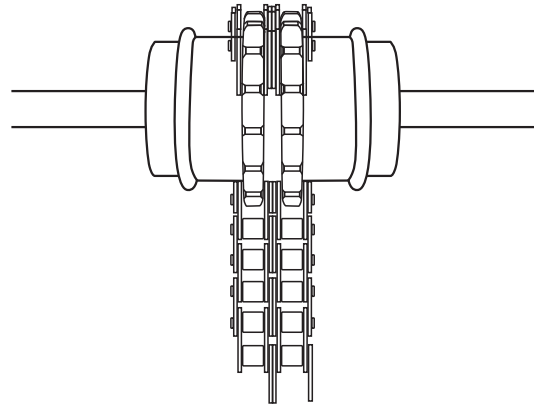
- Angular misalignment (α) must not exceed 1° .
- Offset misalignment (ϵ) must not exceed 2% of the chains pitch. Use a straight edge and feeler gauges in the root of the teeth.



Step four: Measure the distance C and ensure that this is equal to the assembled width in Table 1.



Step five: Test the sprockets position by wrapping the chain around both sprockets.



Step six: Adjust the sprocket and/or shaft positions and repeat step 5 if the chain does not wrap easily or squarely around both sprockets.

Step seven: Remove the chain and lock both sprockets to the shaft in the correct position.

Step eight: Remove the locking clip and locking pin from the end of the chain.

Step nine: Apply grease to the chain, wrap the chain around both sprockets and secure the chain with the locking pin and clip.

Step ten: Fill the space between the cover and the chain with a soft to medium grease.

Step eleven: Fit the coupling casing while making sure that the o-ring seals are fitted into the correct position/groves within the casing. Tighten case bolts alternately.

Table1. Chain Coupling Data

Coupling Size	Chain Size	Assembled Width (mm) C
3012	35-2R	65
4012	40-2R	78
4014	40-2R	80
4016	40-2R	80
5014	50-2R	100
5016	50-2R	100
5018	50-2R	100
6018	60-2R	122
6020	60-2R	123
6022	60-2R	123
8018	80-2R	140
8020	80-2R	144
8022	80-2R	155
10020	100-2R	176
12018	120-2R	198
12022	120-2R	218

