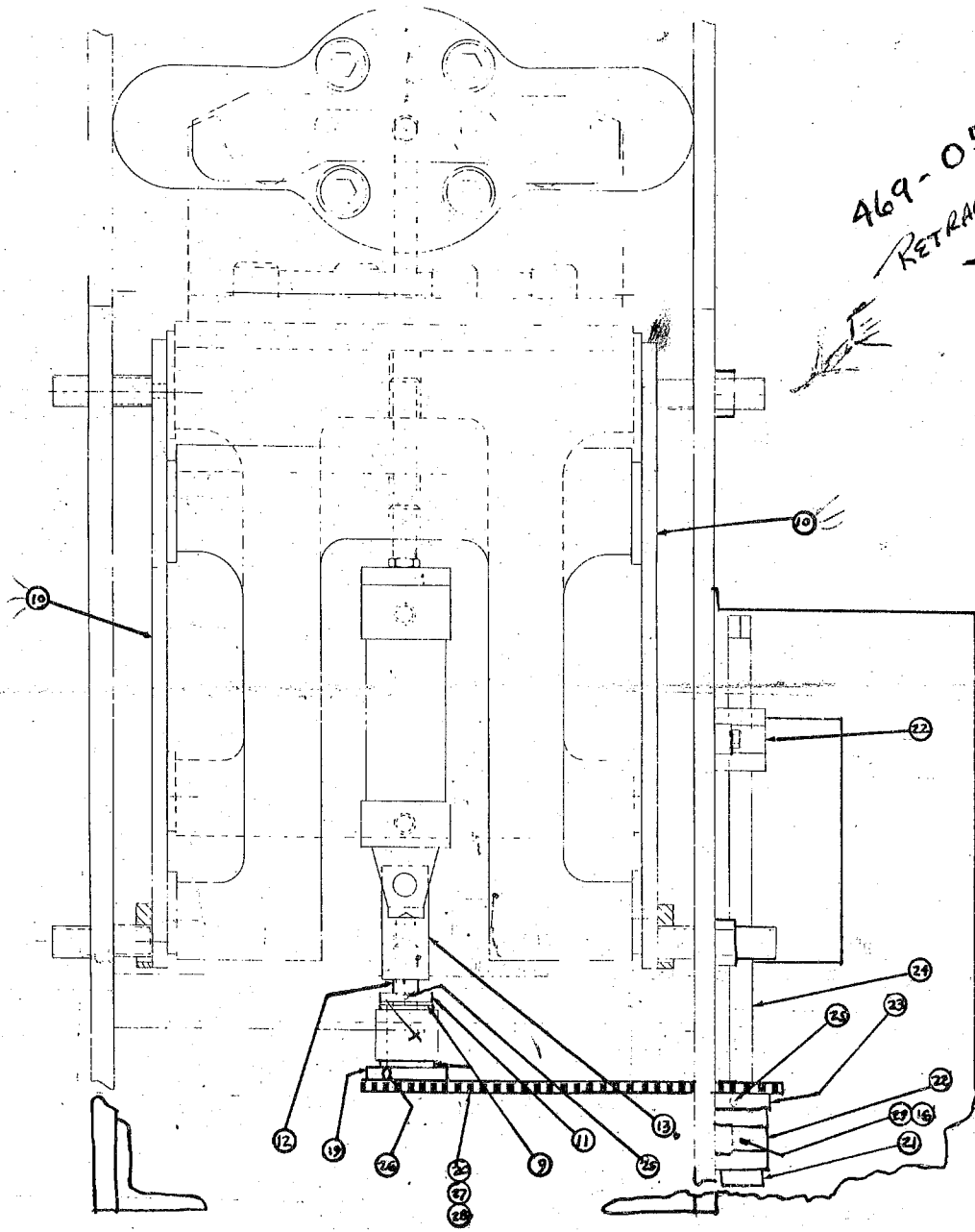
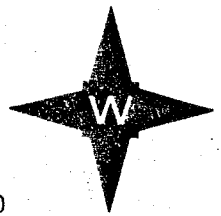


SECTION 9 JAW LIFT ASSEMBLY

REF.530-391

03/80



ITEM	PART NO.	QTY.	DESCRIPTION
16	529-393	4	SPLIT LOCKWASHER, 5/16"
17	527-327	1	ELBOW
18	527-328	2	STRAIGHT
19	510-065	1	SPROCKET, LARGE
20	511-032	1	CHAIN, 1/2" PITCH x 39 1/2" LG.
21	529-026	1	COLLAR, 3/4"
22	508-113	2	BEARING, CAST IRON
23	510-066	1	SPROCKET, SMALL
24	503-259	1	ADJUSTMENT SHAFT
25	529-372	2	ROLL PIN 5/16" x 2" LG.
26	529-373	1	ROLL PIN 5/16" x 2 1/2" LG.
27	171019		CONNECTOR LINK
28	171020		OFFSET LINK
29	529-440	4	HEX NUT, 5/16" - 18 NC
30	527-317	1	ELBOW

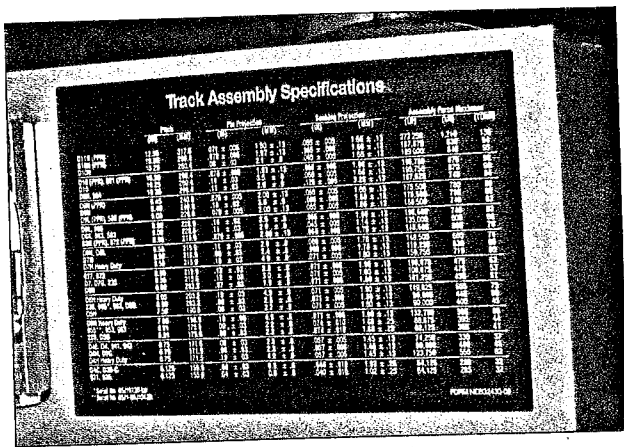


Illustration 33. Track press conversion and assembly specification decals for setting correct gauge pressure.

NOTICE

The correct press force (pressure) must be used each time a joint is assembled. Use of a press force setting higher than the specification may result in damaged track components and/or tooling.

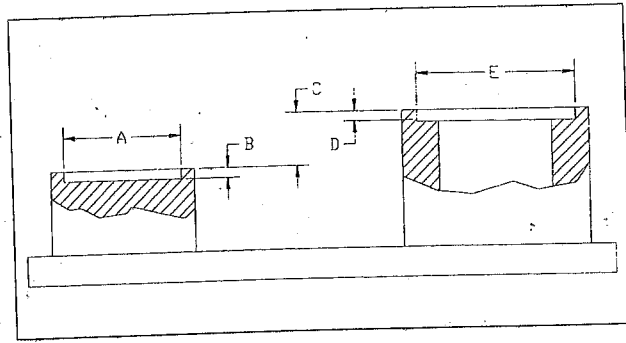


Illustration 34. Tooling Dimensions (B = pin projection; C = link offset; D = bushing projection).

Periodically check the calibration of the track press gauge. Use a calibrated gauge for this procedure. Refer to the track press operation manual for instructions.

Make sure that the conveyor is perpendicular and level with the track press for the full length of the conveyor. Improper conveyor alignment will cause the track to become twisted as more of the links are assembled. As the track twists, the weight of the chain assembly causes misalignment at the press. This can cause damage to the tooling as well as the link assembly.

Positive Pin Retention Track — Tooling Dimensions

Dimension	D11N, D11R	D10, 591	D10N, D10R	D9L, 589	D9N, D9R	D8N, D8R, 578
B¹ mm ± 0.25 (in.) ± 0.010 NOMINAL	1.78 (0.070) (0.070)	2.03 (0.080)	2.03 (0.080)	2.03 (0.080)	2.03 (0.080)	2.03 (0.080)
B² mm (in.) OTHER SIDE	B ¹ (nominal) plus 0.76 (0.030)	B ¹ (nominal) plus 0.76 (0.030)	B ¹ (nominal) plus 0.76 (0.030)	B ¹ (nominal) plus 0.76 (0.030)	B ¹ (nominal) plus 0.76 (0.030)	B ¹ (nominal) plus 0.76 (0.030)
C³ mm ± 0.76 (in.) ± 0.030	56.4 (2.22)	46.7 (1.84)	46.7 (1.84)	42.9 (1.69)	44.2 (1.74)	40.9 (1.61)
D⁴ mm ± 0.25 (in.) ± 0.010	1.66 (0.065)	1.66 (0.065)	1.66 (0.065)	1.66 (0.065)	1.66 (0.065)	1.66 (0.065)