

RK219 CHAIN CUTTING & RIVET TOOL

Tool for 219 Seal Chain Instruction Manual



WARNING : Use protective gear such as safety glasses or face guard and anti-slip gloves when using the RK Chain Tool.

SET CONTENTS & REQUIRED PARTS

Set Contents

- **TB2100** : Tool Body
- **RK-219T-8** : Pressure Bolt
- **RK-219T-9** : Chain Holder
- **RK-219T-A1** : Guide Plate (Cut)
- **RK-219T-A2** : Guide Plate (Rivet)
- **RK-219T-A3** : Flare Rivet Jig
- **RK-219T-A4** : Cutting Jig
- **RK-219T-A5** : Plate Holder

Required Parts

- **For Cut :**
RK-219T-A1, RK-219T-A4, RK-219T-9
- **For Press-Fit :**
RK-219T-A2, RK-219T-A5, RK-219T-9
- **For Rivet :**
RK-219T-A2, RK-219T-A3, RK-219T-9



TB2100 : Tool Body



RK-219T-8 : Pressure Bolt



RK-219T-9 : Chain Holder



RK-219T-A1 : Guide Plate (Cut)



RK-219T-A2 : Guide Plate (Rivet)



RK-219T-A3 : Flare Rivet Jig



RK-219T-A4 : Cutting Jig



RK-219T-A5 : Plate Holder

 **LUBRICATE WITH GREASE**

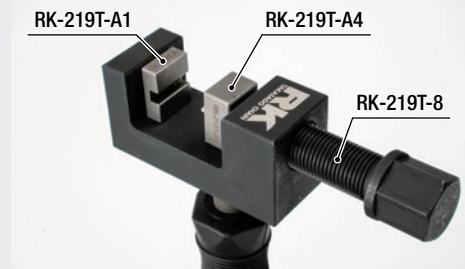


DO NOT CUT MASTER LINK !
DO NOT USE IMPACT WRENCH OR DRIVER

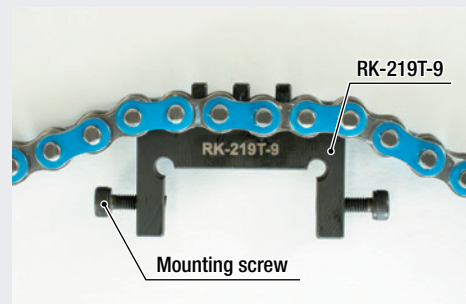
1. CUT

1-1. Set guide plate **RK-219-T-A1**.

Insert cutting jig **RK-219T-A4** into the pressure bolt **RK-219T-8**.



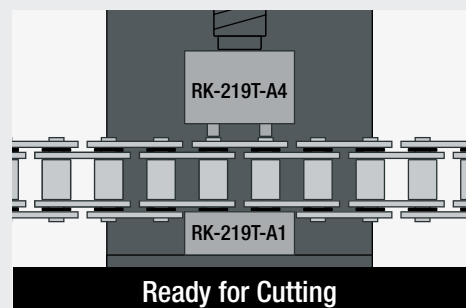
1-2. Set the chain on chain holder **RK-219T-9**.



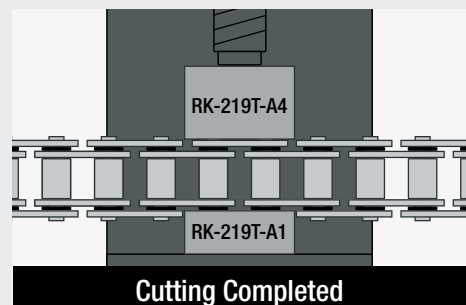
1-3. Fit "1-2" onto the Tool Body until fully seated, then secure it with the **mounting screws** attached to the **RK-219T-9**.



1-4. Tighten the pressure bolt **RK-219T-8** by hand until it stops.

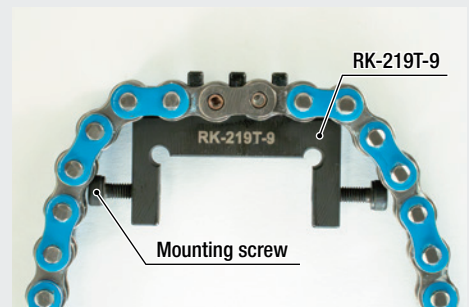
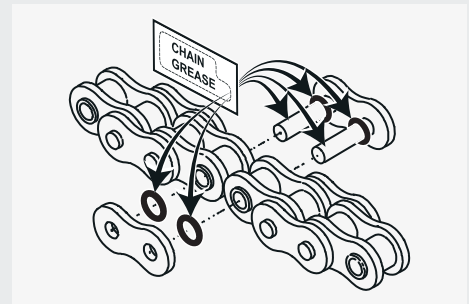


1-5. Tighten the pressure bolt **RK-219T-8**, using a **17mm wrench** until pins are pushed completely through the plates.



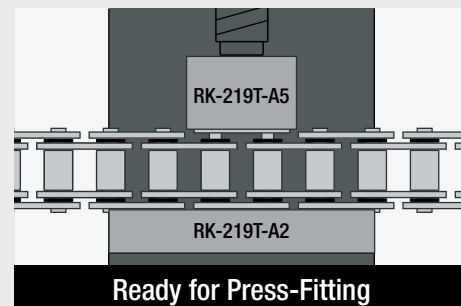
2. PRESS-FITTING

- 2-1.** Set guide plate **RK-219T-A2**. Insert plate holder **RK-219T-A5** into the pressure bolt **RK-219T-8**.
- 2-2.** New RK Chain connecting link bag contains a small bag of grease.
- 2-3.** Follow the instructions on the connecting link bag. Make sure to **apply the grease** to all components of the connecting link including **Pins and O-rings**.
- 2-4.** Set the chain on chain holder **RK-219T-9**.
- 2-5.** Fit "2-4" onto the Tool Body until fully seated, then secure it with the **mounting screws** attached to the **RK-219T-9**.



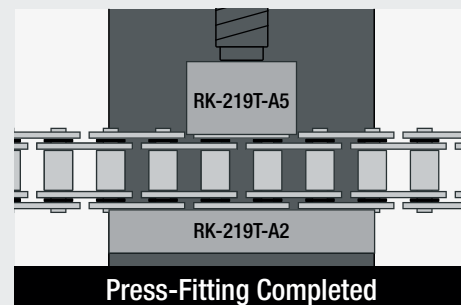
» CONTINUED ON NEXT PAGE

2-6. Tighten the pressure bolt **RK-219T-8** by hand until it stops.



2-7. Use a **17mm wrench** to tighten the pressure bolt **RK-219T-8**. The side plate should press-fit firmly. Tighten the bolt to the correct depth allowed by the plate holder channel.

*** Do not over-torque.**

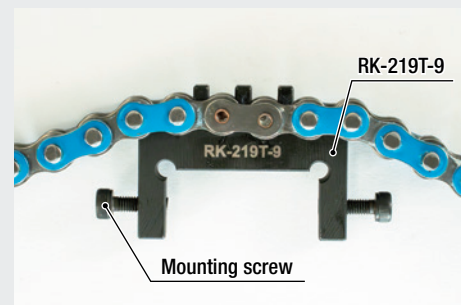


3. RIVET

3-1. Set guide plate **RK-219T-A2**.
Insert rivet jig **RK-219T-A3** into the pressure bolt **RK-219T-8**.



3-2. Set the chain on chain holder **RK-219T-9**.



3-3. Fit "3-2" onto the Tool Body until fully seated, then secure it with the **mounting screws** attached to the **RK-219T-9**.



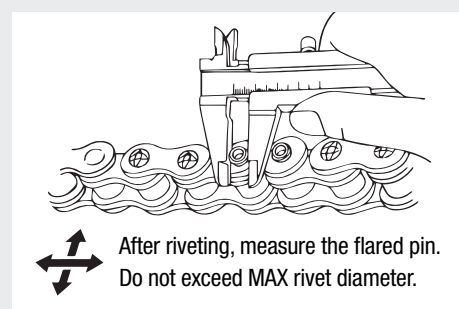
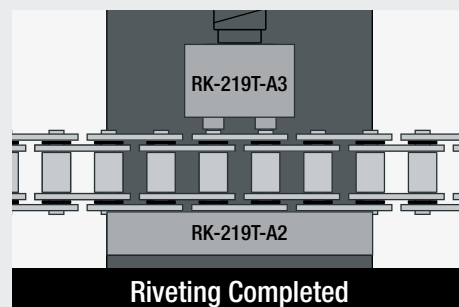
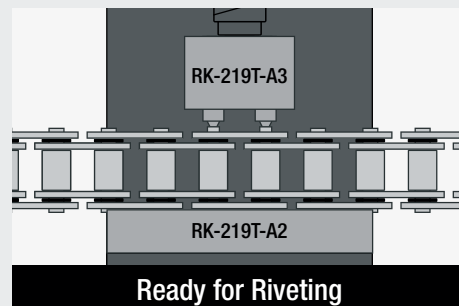
» CONTINUED ON NEXT PAGE

3-4. Tighten the pressure bolt **RK-219T-8** by hand until it stops.

3-5. Use a **17mm wrench** to tighten the pressure bolt **RK-219T-8** until pin ends are flared sufficiently to prevent the side plate from coming off.

3-6. The flare rivet jig **RK-219T-A3** will correctly flare the rivet to the correct depth / width.

Rivet diameter : $\varnothing$ 3.2 ~ 3.4mm



Check to make sure there is no crack on the flare.

GOOD Rivet Flare



BAD Rivet Flare



COMPANY INFORMATION

Manufacturer



RK JAPAN Co., Ltd.

URL : global.rk-japan.co.jp

Authorized Sales & Support



X.A.M JAPAN, Inc.

MAIL : info@xam-japan.co.jp