



## ASSEMBLY INSTRUCTIONS

### Connecting Links

Special connecting links are supplied with Diamond o-ring chain. These connecting links have longer than standard pins to accommodate the o-rings and must be used with the special lubricant and o-rings to seal in lubrication.

*Note: For best results, use only Diamond Chain connecting links and the provided lubricant when replacing chain and chain links.*

### Connecting Link Assembly Steps

1. Generously coat the entire surface of the connecting link pins with the Diamond-furnished lubricant.
2. Lightly coat the outside ends of each bushing with lube.
3. Divide the remaining lube in two and put these portions into one side of the two bushings at the ends of the chain.
4. Place one o-ring over each of the connecting link pins. Slide each o-ring down the pins so they are touching the back of the connecting linkplate.
5. Place your fingers over the opposite side of the chain bushing and insert the connecting link through the greased side of the bushings. Push the connecting link through until the pin ends are protruding through the bushings.
6. Slide one o-ring over each of the connecting link pins protruding through the bushings.
7. Place the cover linkplate over the pin ends and press it on until the cotter holes or spring clip groove is visible.
8. Install cotters, spreading each leg 30-45 degrees (60-90 degrees included angle) or install the spring clip with the open end facing away from the direction of travel. A slight tap on the ends of the connecting link pins will position the cover linkplate snugly against the cotter pins or spring clip.

*Note: Use only the cotters or spring clips supplied by Diamond Chain. Do not reuse cotters or spring clips – always install new ones.*

### Maintenance Instructions

A lightweight oil (i.e. SAE 30W motor oil) should be applied manually to the external surfaces of the chain and o-ring on a periodic basis.

The lubrication frequency only needs to be often enough to keep the o-ring from drying out and cracking, and to keep rust from forming on the surface of the parts. The frequency would need to be increased as the operating temperature of the chain increases.

### CAUTION

*This product contains a specially formulated Polytetrafluoroethylene (PTFE) impregnated grease. When heated above 500° F it may produce fumes which are irritating to the eyes and which may cause flu-like symptoms and/or nausea.*

*PROVIDE ADEQUATE VENTILATION WHEN GRINDING PINS TO DISASSEMBLE CHAIN! USE OIL RESISTANT GLOVES! DO NOT SMOKE WHEN HANDLING THIS PRODUCT! DO NOT CONTAMINATE CIGARETTES OR CIGARS WITH LUBRICATION FROM THIS PRODUCT!*

*For further information contact Diamond Chain Company at [applicationengineering@diamondchain.com](mailto:applicationengineering@diamondchain.com) or 317-638-6431.*

