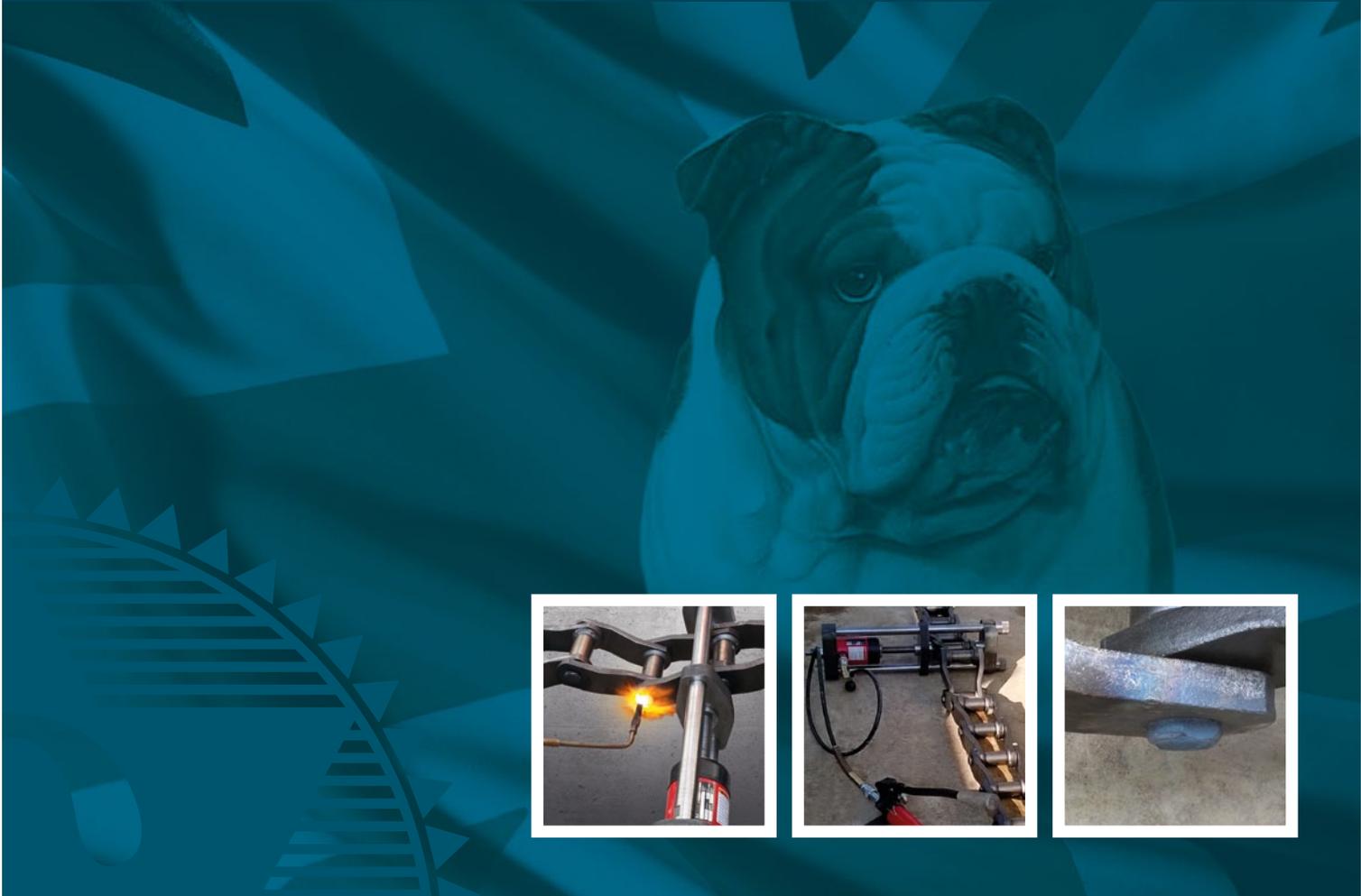




# JOHN KING

CONVEYOR CHAINS & SPROCKETS WORLDWIDE



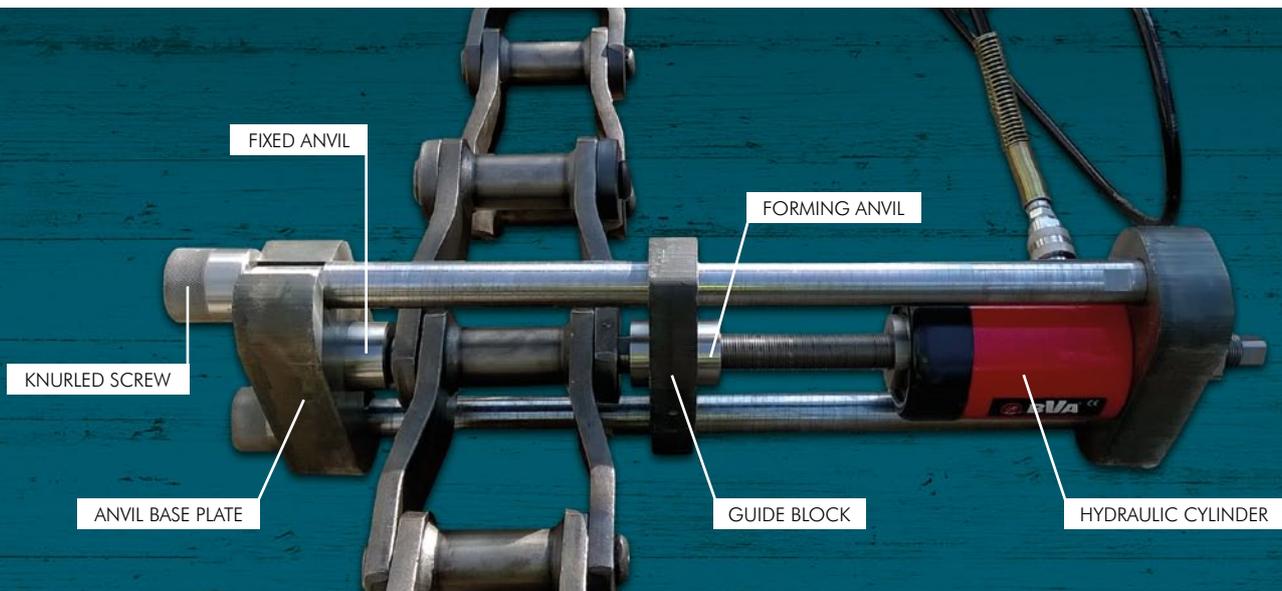
## THE BULLDOG ON SITE RIVETING TOOL

Method statement for the safe use of hand operated riveting tool

  
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## Method statement for the safe use of hand operated riveting tool

1. Insert the appropriate anvil on the fixed end of the tool, this should fit the head of the chain pin securely but not as to interfere with the pin on completion of the riveting operation.
2. Insert the appropriate forming anvil onto the threaded bar which is screwed into the hollow cylinder.
3. Ensure the hydraulic cylinder is in its retracted position.
4. Screw back the threaded bar into the hollow cylinder of the ram far enough to ensure that the chain in question can be easily inserted into the working area.
5. Unscrew the two knurled locking nuts and disconnect one end of the anvil base. Rotate this anvil base allowing the chain to be inserted into the working area. Once the chain has been inserted rotate the anvil base back into position and tighten the locking nuts.
6. Screw out the cylinder screw leaving a gap of approximately 5-8 mm between the forming anvil and the chain pin.
7. Insert the fixing bolt through the forming anvil and the guide block.
8. Pull the chain slightly to one side. Using an appropriate method heat up the end of the chain pin until it becomes "cherry red" (Methods of heating may include oxygen and acetylene or oxygen and propane).
9. Whilst the pin is glowing quickly line up the chain with the anvil and pump the hydraulic unit forcing the anvil to swage the pin head, this procedure may need to be repeated to achieve the desired form.
10. When the desired form is achieved release the hydraulic valve and retract the hydraulic ram, unscrew the anvil screws and rotate the anvil out of the way. Remove the tool and move to the next connecting pin.



## WARNING

Our customers safety is important to us. Take care at all times to avoid personal injury when working with this unit.

- Eye protection must be worn at all times whilst using this equipment
- Wear protective clothing including gloves and safety shoes/boots.
- Handle the chain with care to prevent uncontrolled movement of chain and components.
- Tools should be maintained in a good condition and correctly applied.
- Determine correct direction for pin/rivet insertion before proceeding.

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