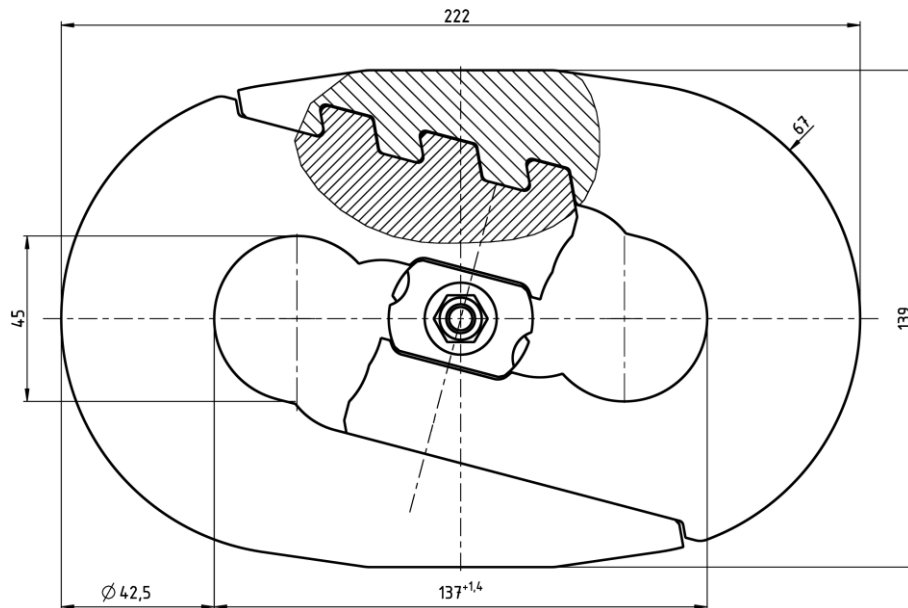


1 PRODUCT DESCRIPTION

The patented connectors have to be used only for connecting Roundsteel- and Flat-Chains in mining-conveyors and mining-plow-machinery. They meet the standard DIN 22258-1 concerning dimensions.

The connectors are able to run vertically as well as horizontally across the chain wheel.

1.1 Technical Data (Size 42 x 137)



Size	Type #	Article No.	Working Force WF _{max} [kN]	Breaking force BF _{min} ¹⁾ [kN]	Mass [kg]
42 x 137	Plowmaster S	F26274	1 380	1 920	7,0
42 x 137	Plowmaster SB	F26275	1 380	1 970	7,0

¹⁾ for self-coloured condition (NSW) #

Temperature range for use: +10 °C to +100 °C

1.2 Design

The connector consists of two forged symmetrical halves. They are be combined by a central closing system, which locks the halves against unintended opening.



Assembled connector



Connector halves

The closing system consists of two different closing halves and a safety nut.

The first closing half is completed by two pre-mounted cylinder pins and a screw. The second closing half is just a one-piece part.



The connector halves were manufactured as a tuned couple and should only be used together.

To identify the belonging parts the halves are marked by a hammered number (for example like in the picture with No. 17).



2 COMMISSIONING

Prior to using the product for the first time make sure that

- the parts comply with the order and have not been damaged,
- test certificate and operating instructions are at hand,
- markings correspond with what is specified in the documentation,
- the documentation is safely kept in an orderly manner.

3 SAFETY NOTES

Read these instructions carefully before installing and using the THIELE Plowmaster S.

When performing work make sure to wear your personal protective equipment.

Specific local provisions have to be observed.

4 ASSEMBLY

1. Check that all parts are on hand and the connector halves have the same number.
2. Loosen and remove the safety nut. Disassemble the closing system.
3. Open the connector halves by moving the parts apart. Move a pointy flat chisel alternating into each of the join patches.
4. Stop the conveyor or plow-machinery and make sure that it will not start unintended.
5. Move and turn each connector half inside each chain end.



6. Join the halves together so that the tooting grab into each other and the join patches are closed.

In case of working on different strands take care to use only matched halves.

7. Now slightly punch the closing half with the screw and the cylinder pins to the center of the connector from one side.

Take care that the screw will not be disassembled.

8. Now position the second closing half from the other side in line with the first one and punch it slightly to the center of the connector.

Make sure both closing parts meet at the center.

9. Assemble cotter safety nut and tighten it by a torque of 32 Nm. Use a torque wrench with a wrench size of 13 mm.

10. Remove all tools and disruptive parts outside the conveyor or plow machinery before switching it on again.



Important information:

Screw and associated hexagon nut with metal clamping part (ISO 7042) are for single use only.

5 DISASSEMBLY

1. Stop the conveyor or plow-machinery and make sure that it will not start unintended.
2. Untension the chain/s.
3. Loosen and remove the safety nuts.
4. Punch the closing halves by a drift pin or cross-chisel to the outside. There's a little recess on each closing half to aid you with it.
5. Move a pointy flat chisel into one of the join patches to open the halves. You may have to do this on both sides alternately.
6. Now you can remove the halves out of the chain ends.

6 STORAGE

Store connectors in dry locations at temperatures ranging between 0 °C and +40 °C.

7 MAINTENANCE

The connector has to be changed when the pitch exceeds 3 % or there is serious damage and wear.

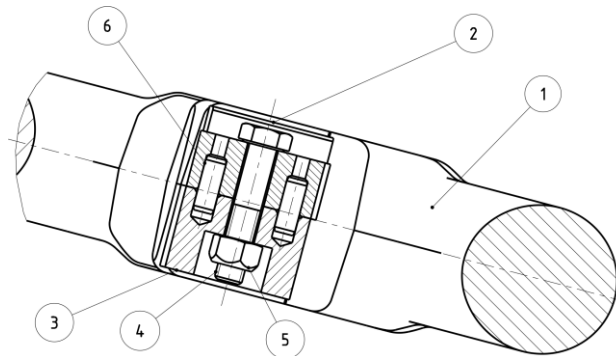
8 ENVIRONMENT AND PACKAGING

Dispose of the packaging in an environmentally compatible way according to local rules.

All components and accessories of steel taken out of service are to be scrapped in line with local regulations and provisions.

9 SPARE PARTS

Use only original THIELE spare parts.



Item	Designation	Article No.
1	Chain connector Type S completed (Size 42x137)	F26274
1	Chain connector Type SB completed (Size 42x137)	F26275
2, 3	Closing system set (including items 2 to 6)	F262740
4	Screw ISO 4014 M8 x 40 10.9	Z10699
5	Safety nut ISO 7042 M8 10	Z01393
6	Cylinder pin ISO 2338 D6 M6 x 16	Z10189