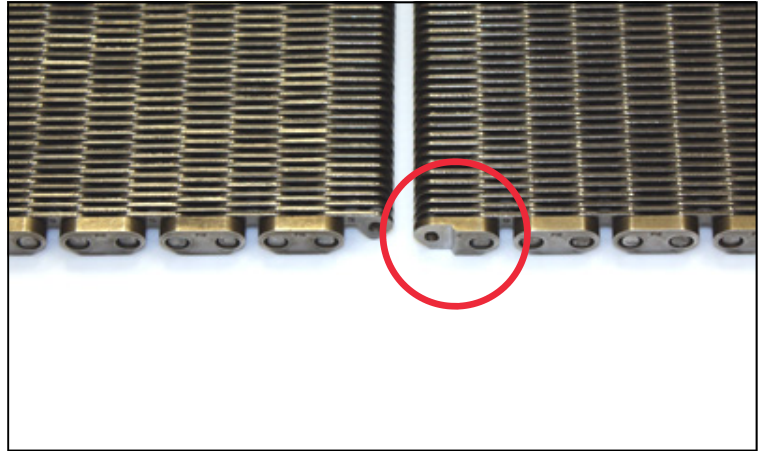


## Connecting Double Head Protector Chain (DHPL)

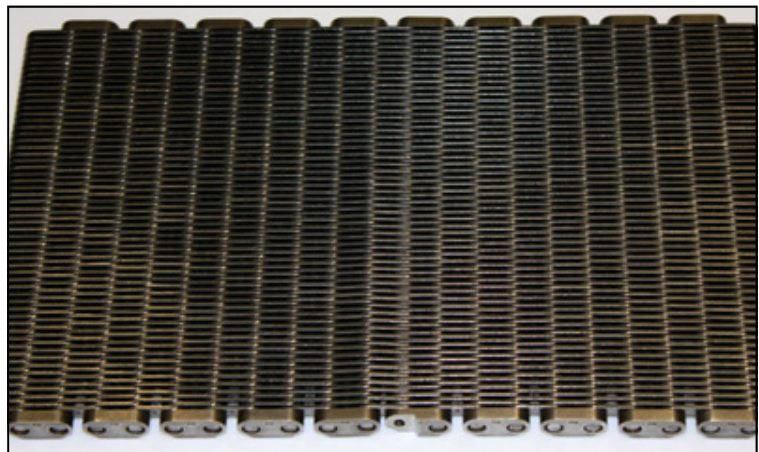
1. To connect the chain, firstly locate the special half ground **HPL™** link.



2. Bring the two ends of the chain together.

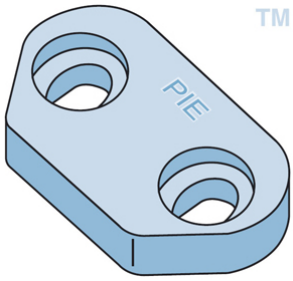


3. Ensure that the holes in both pieces of chain are aligned.



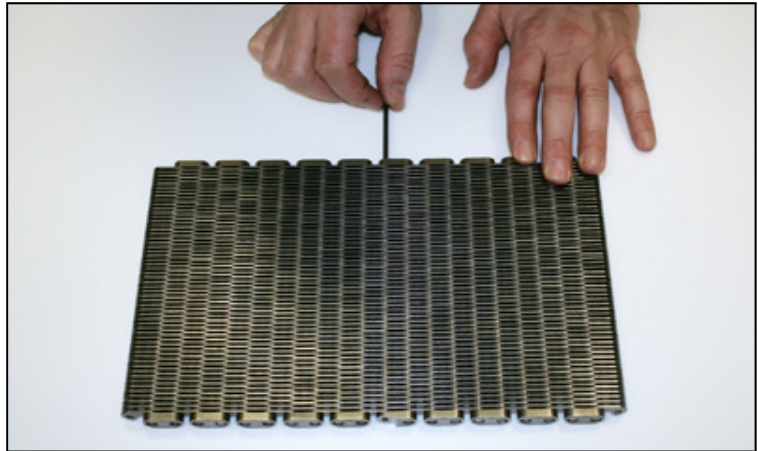
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Manor Croft House — Commercial Road — Skelmanthorpe — Huddersfield — UK — HD8 9DT  
Tel: +44 (0) 1484 864 733 — Fax: +44 (0) 1484 865 235  
sales@pennine.org — www.pennine.org

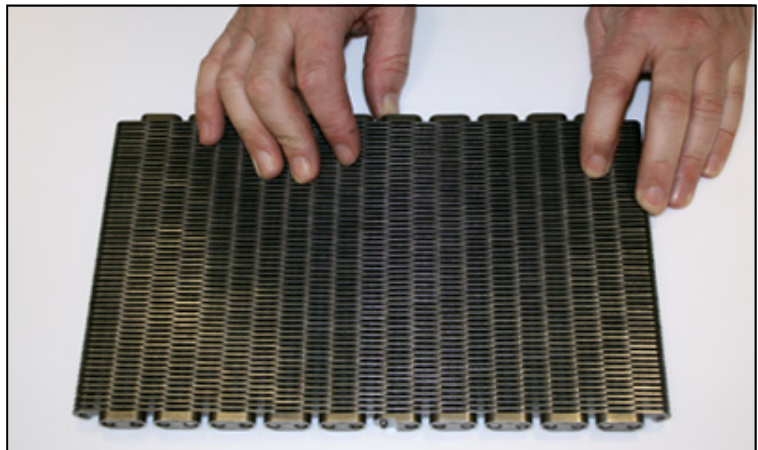


## Connecting Double Head Protector Chain (DHPL)

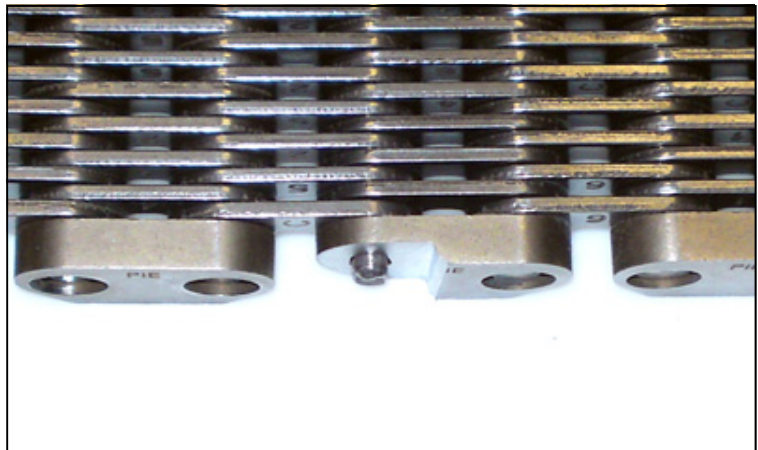
4. Once the ends are lined up then join both ends of the chain using a new connecting pin with a softened end. Insert the pin through the back of the chain.



5. Ensure that the riveted end of the pin is fully inside the **HPL™** link.



6. You should be able to see the soft end of the connecting pin protrude through the special half ground **HPL™** link

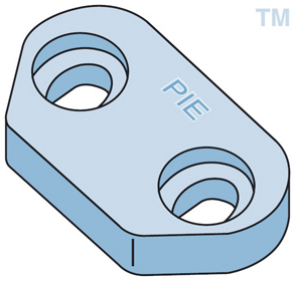


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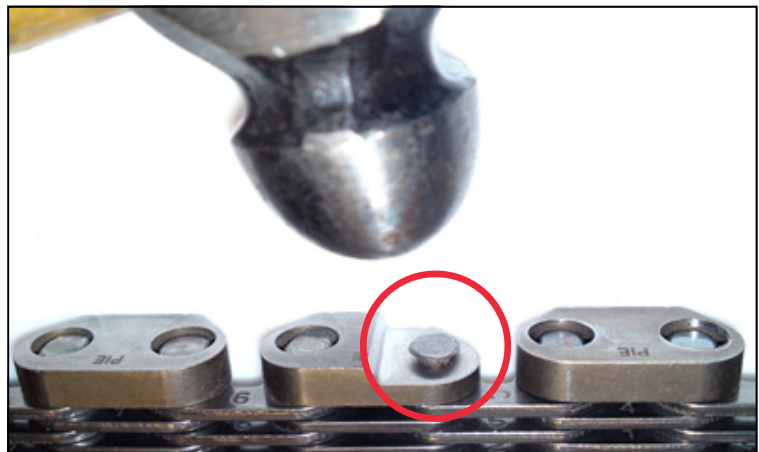


## Connecting Double Head Protector Chain (DHPL)

7. With the chain supported at the rivet end, use a small ball peen hammer to produce a large good rivet at the half ground **HPL™** link end. This should be large enough to prevent the connecting pin from being able fall out of the chain.



8. The pin has now been peened over.



9. To assist with joining link and spacer chain then please consider using a 'Pennine Chain Connecting Block'. Contact our Sales team for further details.



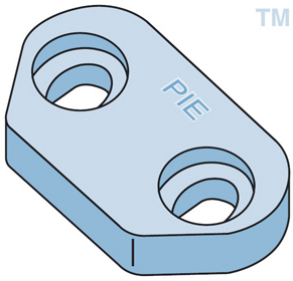
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## **Disconnecting Double Head Protector Chain (DHPL)**

**Important note:** In any length of chain there could be up to **4** special half ground **HPL™** links; the chain must be disconnected at one of these links.

**Do not remove the HALF GROUND HPL™ link; always remove any excess chain from the other end.**

1. To disconnect the chain, locate any one of the special half ground HPL links.
2. Grind off the pin head at the half link, taking care not to damage the half link Head Protector.
3. Once the pin head has been removed from the half ground link; use the long punch pin to drive the connecting pin out through the chain. The chain should be kept flat at all times to assist with the original pin removal.
4. Carefully count the number of links to be removed, select the correct 2<sup>nd</sup> pin for removal and break the chain as previously described. Always break the pin furthest from the front of the chain; this will leave an inner link for direct connection to the original half ground HPL link.
5. To re-join the chain follow the procedure as described in the chain connection paragraphs, (see page 1).
6. In the event of the chain being broken at an unspecified link. The customer will have to use a fully ground link as show on the image below, this will allow the riveting of both pins as shown in point 8 on page 3 of this instruction manual.



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sales@pennine.org — www.pennine.org