



VortexRacing.com

800-440-3559

Warning: Only A Certified Mechanic
should install motorcycle chains

CHAIN CUTTER, RIVETING AND CLIP TOOL SET

PITCH 415, 420, 425, 428, 520, 525, 530, 532



CLIP PRESSURE PLATE



RIVET PRESSURE PLATE



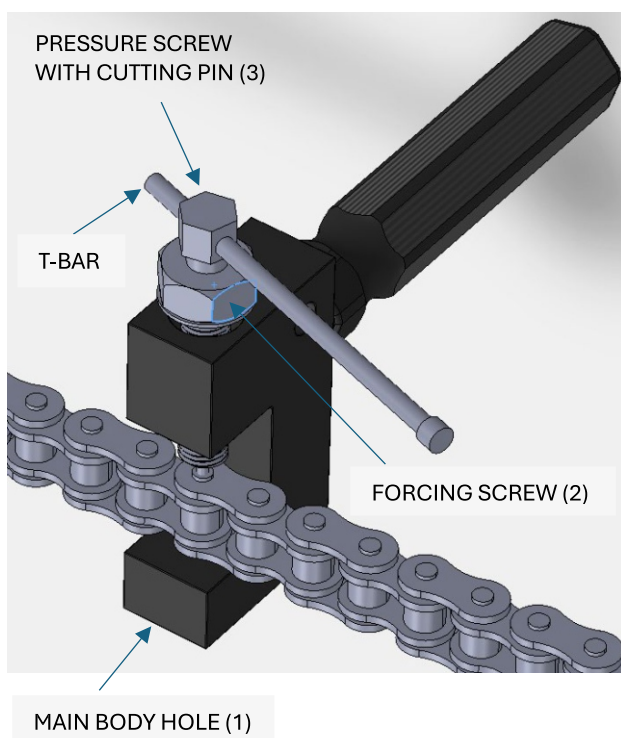
500 & 400 RIVET TIPS



TAIL PLATE

CUTTING CHAIN

1. Align the chain pin in the main body hole (1), use a 17mm wrench to tighten the forcing screw (2) over the chain pin.
 - **NOTE: Ensure the chain pin is properly centered into the main body and forcing screw.**
2. Thread the pressure screw with cutting pin (3) into the forcing screw (2), use the T-bar or 14mm wrench to force the cutting pin through the chain to break the pin free.
 - **NOTE: It is recommended when breaking the chain to turn the pressure screw with cutting pin forward and backward repeatedly. This will increase the cutting pin lifespan.**



RIVET & CLIP LINK INSTALLTION

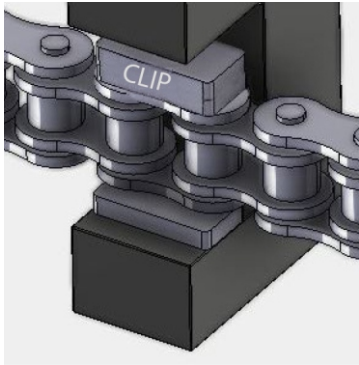
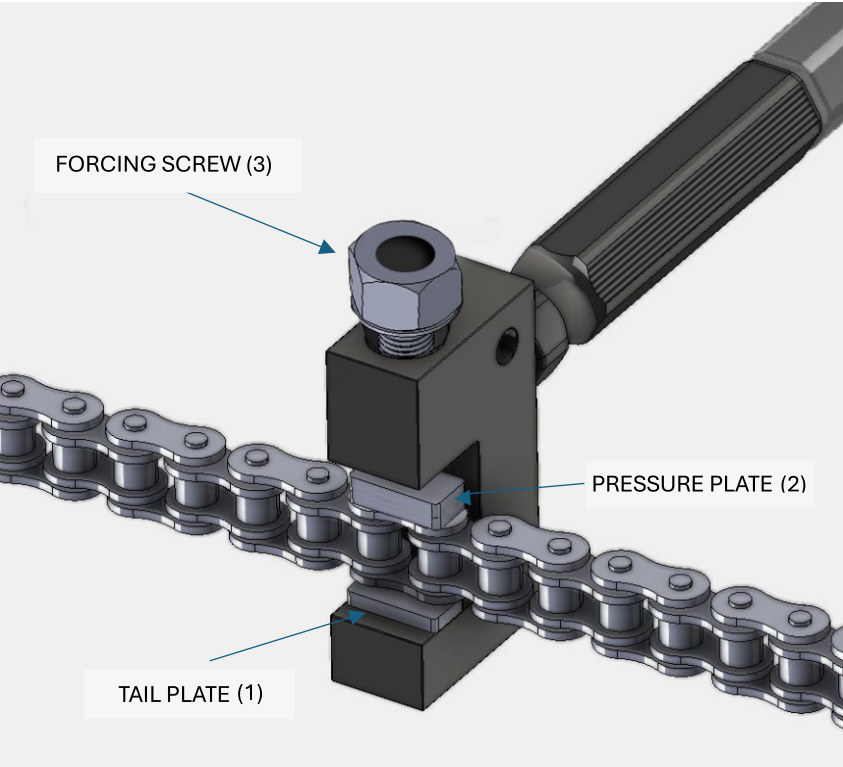


Fig A

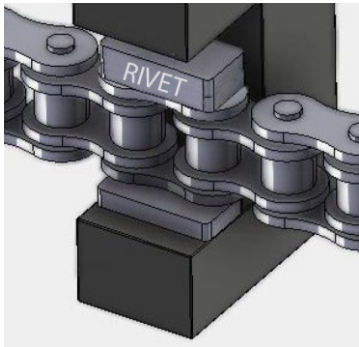
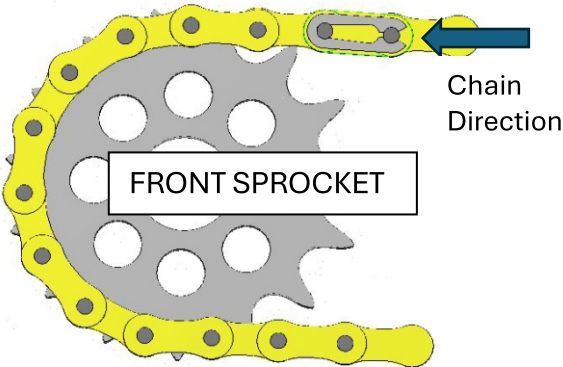


Fig B

1. Insert the tail plate (1) into the main body hole and put the correct pressure plate (2) for your chain pitch onto the end of the forcing screw. If you are riveting the link the word rivet should be as shown as in Fig A. If you are using a clip link the word clip should be as shown as in Fig B.
2. Connect the chain using the master link (if the chain has O-rings be sure to install them) and insert the chain into the tool as shown.
3. Use a 17mm wrench to tighten the forcing screw down until the plate is pressed onto the chain.
4. If you have a rivet master link the next step is to remove the pressure plate and insert the correct rivet tip. Note: 400-rivet tip is for 415, 420, 425, 428 chain pitches and the 500-rivet tip is used for 520, 525, 530, 532 chain pitches.
5. You will line up one master link pin at a time with the rivet tip and tighten. Use calipers to confirm you have achieved the correct flare. It is better to slowly flare the pin which may take multiple attempts. Do not exceed the recommended pin flare (EK & Vortex chains, see chart below. For all other chain brands confirm manufacturers specs). **Caution: Over flaring the pin can damage the link and create an unsafe condition. Be sure to flare both master link pins.**
6. For clip style master links after step#3 you will install the clip using needle nose pliers. Caution: The clip should be installed in the correct direction – see pic below.



Pin Diameter (mm)	EK & Vortex Chains	Flare (mm)
3.96	415RR,415RRX,420SRO,420SX3,420SRX	4.15 to 4.25
4.5	428SROZ,428SRX2,428ZVX	4.7 to 4.8
5.38	All 520/525/530 except 530Z/3D,525SPR/3D	5.6 to 5.8
5.64	530Z/3D,525SPR/3D	5.8 to 5.9