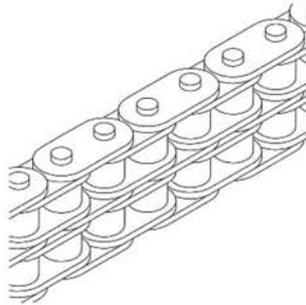


Riveting Link / Fitting Instruction

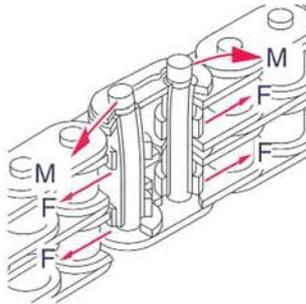
The Timing Chain



Function and advantages of roller and bush chains in automotive engines:

- High specific load bearing capacity.
- Full freedom of maintenance.
- Easy to disassemble.
- Favourable price / performance ratio.

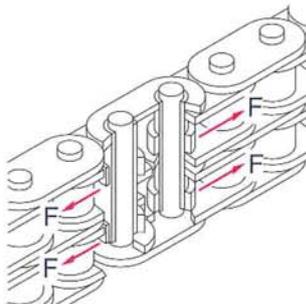
The Problem



The Connecting Link

- The security spring clip which fixes the single plate can loosen during the engine run.
- The distribution of the chain load (F) on the plates is not symmetrical.
- An undesirable torsional force (bending stress – M) occurs due to the backlash between the pin and the plate hole.

The Solution



The Riveting Link

- Here, the chain load (F) on each link are equal.
- Torsional forces do not exist because the spare part plate is pressed on the pin and consequently rivetted.

Fitting instruction for the installation of timing chains

Chain types

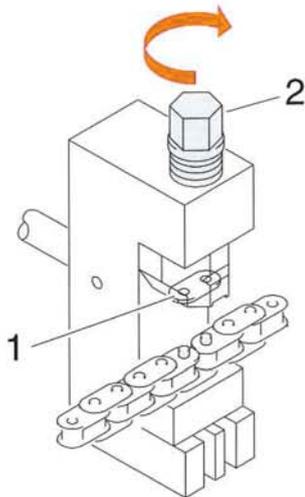
A. For Simplex chains (G68)

Operation

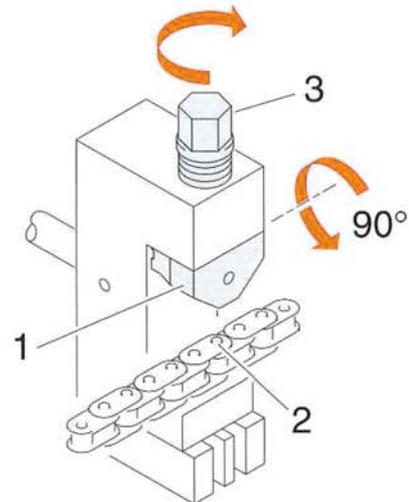
Basic tool and insert parts for the different chain types, please look at the Fitting Matrix (last page).

Procedure:

Fitting of the outer plate



Fixing the rivets



Chain types

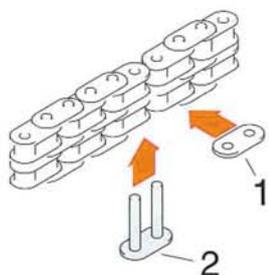
B. For Duplex chains without press fit middle plate (D67ZN, D67HRZ)

Operation

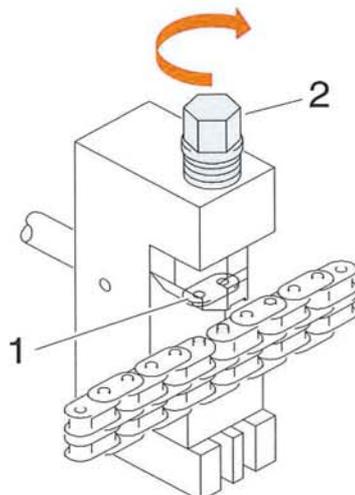
Basic tool and insert parts for the different chain types, please look at the Fitting Matrix (last page).

Procedure

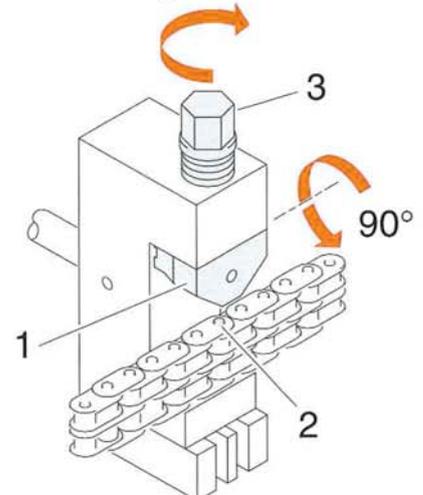
Fitting of the middle plate and the riveting link



Fitting of the outer plate



Fixing the rivets



Fitting instruction for the installation of timing chains

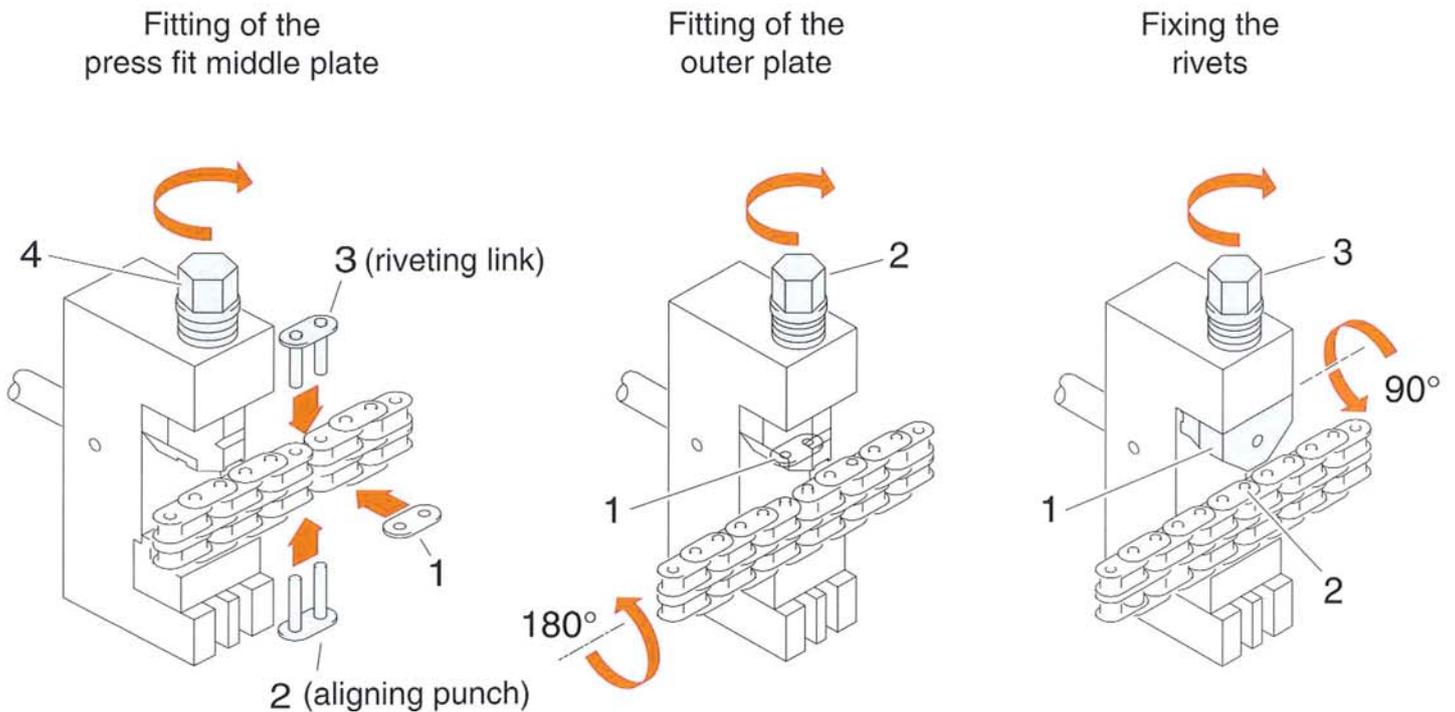
Chain types

C. For Duplex chains with press fit middle plate (D67HP)

Operation

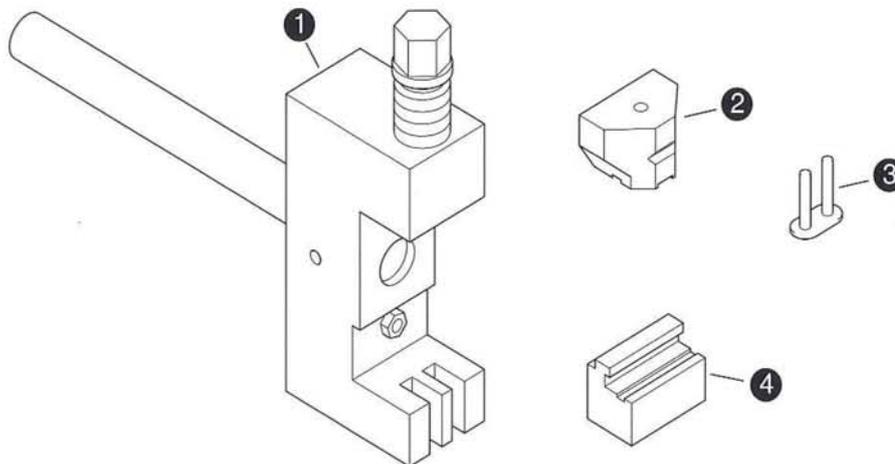
Basic tool and insert parts for the different chain types, please look at the Fitting Matrix (last page).

Procedure:



Fitting instruction for the installation of timing chains

Basic tool



Fitting Matrix

Procedure	Fitting the outer plate and riveting link		Fitting the riveting link block and the press fit middle plate		
	chain guide ④	synchronizing key ②	chain guide ④	synchronizing key ②	aligning punch ③
simplex roller chain G68WN-3	Nr. F2 E29-17,0-202-04	Nr. D2 E29-17,0-203-04			
duplex roller chain D67ZN-10	Nr. F1 E29-80,0-102-04	Nr. D4 E29-24,0-203-04			
duplex roller chain D67ZN-15	Nr. F1 E29-80,0-102-04	Nr. D4 E29-24,0-103-04			
duplex bush chain D67HRZ-13	Nr. F1 E29-80,0-102-04	Nr. D6 E29-78,0-103-04			
duplex bush chain D67HP-2	Nr. F1 E29-80,0-102-04	Nr. D8 E29-80,0-103-04	Nr. F5 E29-80,0-103-04	Nr. D9 E29-80,0-103-04	E29-80,0-103-04

Insert parts for basic tool E29-80,0-210-04 ①