UCT2100(50) Chain Cutting & Press-Fit Tool Instructions Ver5

The UCT2100(50) can cut 415, 420, 428, 520, 525, 530, and 532 Sealed and Non-Sealed chains.

Part #	Purpose	Chains
PH500JP	Press Fit	520, 525, 530, 532 Sealed Chain
PH500JP	Rivet	520, 525, 530, 532 Sealed & Non-Sealed Chain

***4 Series requires optional parts.**

PH428	Press Fit	428 Sealed Chain
PH428	Rivet	428 Sealed & Non-Sealed Chain

DO NOT CUT MASTER LINK!

DO NOT USE TOOL TO CUT 630 & 632 TYPE CHAIN

DO NOT USE IMPACT WRENCH OR DRIVER

Use protective gear such as safety glasses or face guard and anti-slip gloves when using the RK Chain Tool.

Scan QR Code for Tool Video Instructions

LUBRICATE WITH GREASE


CP4050HBT
Cutting Pin Holder


CP4050BT
Cutting Pin



PBS210
Small Pressure Bolt


FP500JP1
5 Series Rivet Flare Pin


FP428JP
4 Series Rivet Flare Pin *Sold Separately



TPC210
Cutting Tail Piece



TPP220
Pressing Tail Piece


FP415
415 Flare Pin
*Sold Separately



TPP415
415 Pressing Tail Piece
*Sold Separately



PH500JP
5 Series Plate Holder



PH428
4 Series Plate Holder
*Sold Separately



PBL220
Large Pressure Bolt



TB2100
Tool Body

TO BREAK A CHAIN: Lock the chain with the chain tool and push out pin from the chain.

Note: If you are cutting a new chain to length, be sure to remove the chain pin that will leave you with inner side plates as the end of the chain. A connecting link can only be installed onto inner side plates. (Figure A)

1. By default the cutting pin assembly (Figure 1A) will be assembled in the kit, but if disassembled to replace parts, follow these directions. Slide the cutting pin holder CP4050HBT onto the cutting pin CP4050BT. Thread the cutting pin holder CP4050HBT into the small pressure bolt PBS210 (Figure 1A).

2. Thread the large pressure bolt PBL220 into the tool body TB2100 (Figure 1B).

3. Insert the chain cutting tail piece TPC210 into the opposite side of the tool body TB2100 (Figure 1B).

4. Position the chain to be cut between the hole in the end of the large pressure bolt PBL220 and the hole in the tail piece TPC210 (Figure 1B).

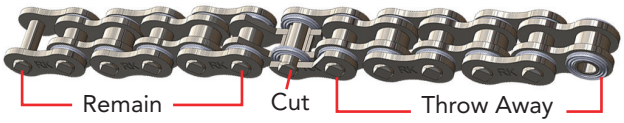
5. Using a 17mm wrench, tighten the large pressure bolt PBL220 so that the chain is held firmly in place and centered on the pin. If the large Pressure bolt PBL220 is not seated directly on the chain the cutting pin CP4050BT can break and damage your chain.

6. Thread the Cutting Pin Assembly (Figure 1A) into the large pressure bolt PBL220 (Figure 1C).

7. Using a 14mm wrench, turn the small pressure bolt PBS210 until the chain pin is pushed completely through the side plates.

8. **CAUTION: The first few turns will be very hard as the quad stake riveted edges on the chain pin are pushed through the side plate. If it seems exceptionally hard, check the alignment of the chain pin with the hole in the end of the large pressure bolt PBL220 and cutting tail piece TPC210.**

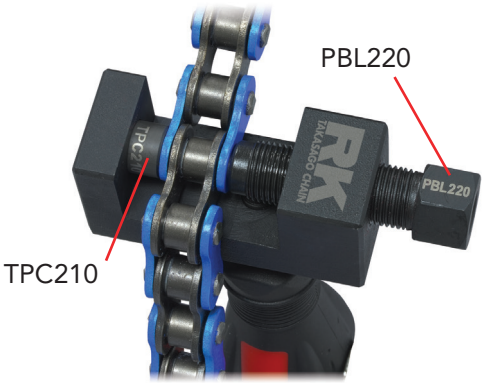
A When chain cutting, cut only outer plates.



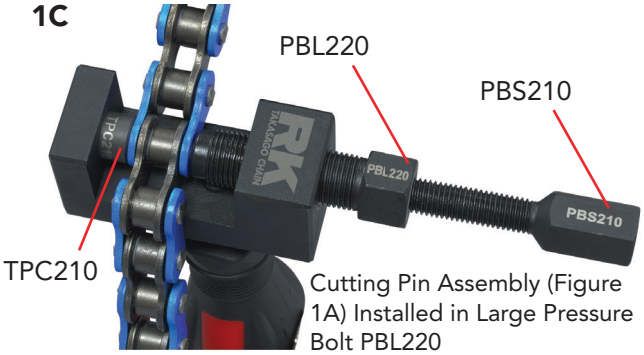
1A Cutting Pin Assembly - Complete



1B



1C



Cutting Pin Assembly (Figure 1A) Installed in Large Pressure Bolt PBL220

INSTALLATION/PRESS-FITTING OF SIDEPLATE FOR CLIP AND RIVET

1. Review the drawings for reference. Route chain over and around counter shaft sprocket (Figure 2A).

2. New RK Chain connecting link bags contain a small bag of grease. Follow the instructions on the connecting link bag. Make sure you apply the grease to all components of the connecting links including pins and if applicable O-rings (Figures 2B). If the chain is sealed (contains O-rings) put 1 greased O-ring over each connecting link pin. Slide the pins through the two ends of the chain from the back to connect the chain near the bottom of the rear sprocket (Figures 2B).

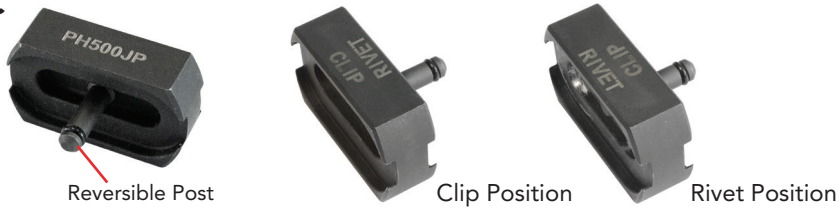
3. If applicable, put the other two greased O-rings over each pin on the other side of the chain (Figures 2B).

4. Plate Holder Selection

   PH500JP (Figure 2C)- To Press-fit Clip & Rivet sideplates for 520/525/530/532 O-ring.

   *PH428 – To Press-fit Clip & Rivet sideplates for 428 Chains
   **Sold Separately*

2C



Reversible Post — Clip Position — Rivet Position

5. Unscrew the post in Plate Holder PH500JP or PH428 to switch between clip and rivet position (Figure 2C, 2D and 2E) Insert the correct plate holder PH500JP or PH428 (see Plate Holder Selection above) into the large pressure bolt hole PBL220 and position the connecting link side plate in the plate holder PH500JP or PH428 (Figure 2D).

6. Align the pins of the chain with the indent in the PH500JP or PH428 plate holder (Figure 2D & 2E).

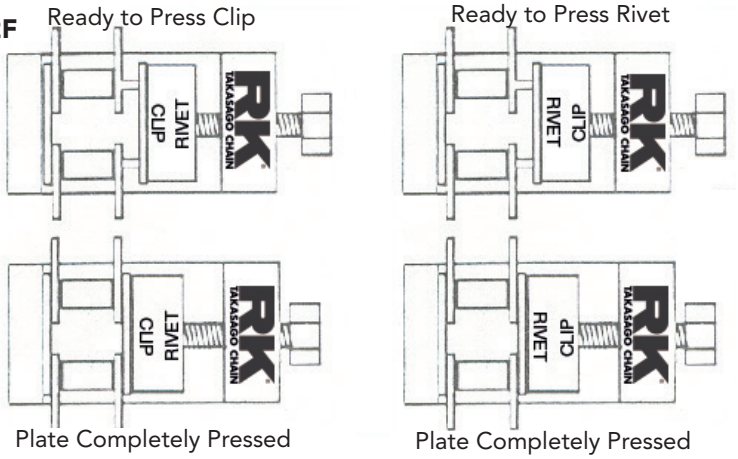
7. Turn the large pressure bolt PBL220 by hand making sure to keep the pins and side plate holes aligned until snug.

8. Use a 17mm wrench to tighten the large pressure bolt PBL220. The side plate should press-fit firmly but without difficulty.

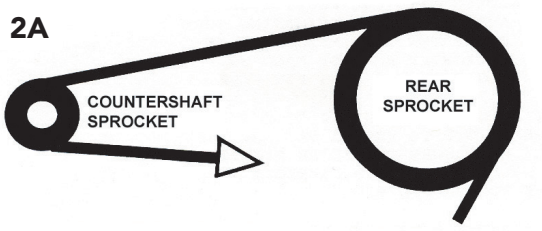
9. Tighten bolt to correct depth allowed by plate holder channel. Do not over-torque (Figure 2F). Loosen large pressure bolt PBL220 and remove tool from the chain. Remove Plate Holder PH500JP or PH428 from large pressure bolt PBL220.

10. The chain's sideplates are now press fitted to the chain. Proceed to installing the Clip or Rivet in the next section.

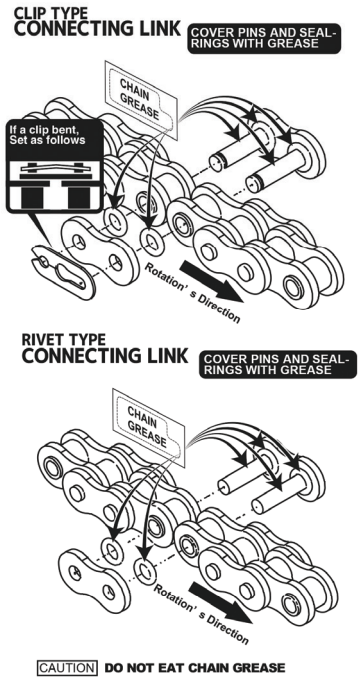
2F



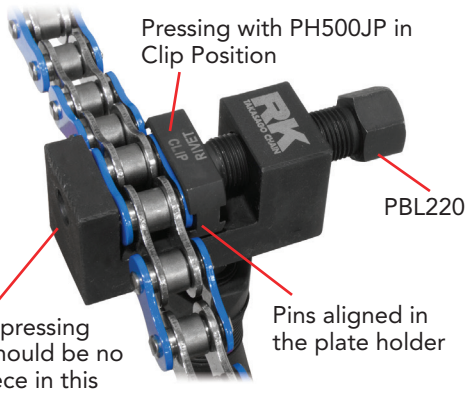
2A



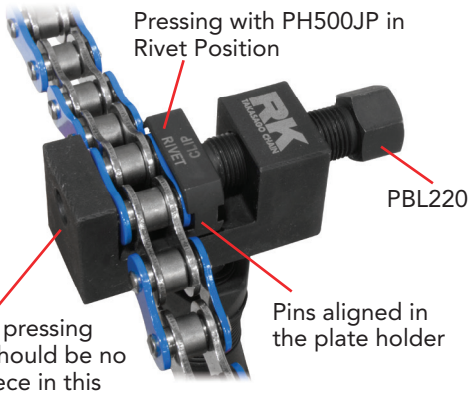
2B



2D



2E



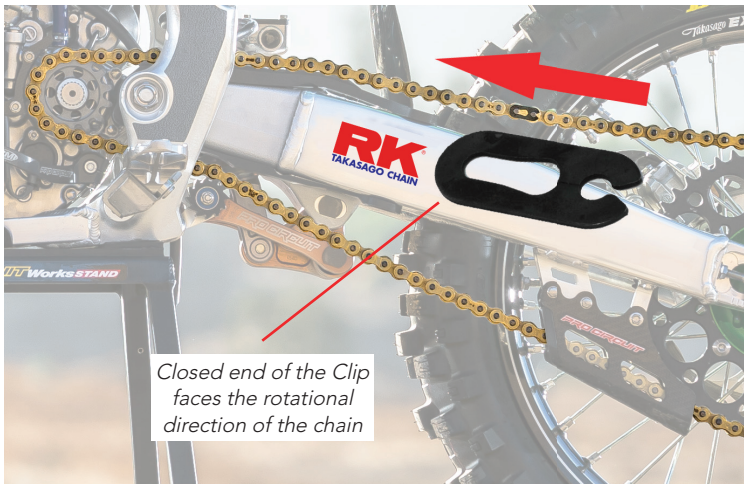
Important! RK recommends using rivet type connecting links whenever possible for the most secure connection.

INSTALLING THE CLIP

1. Using thin-nose pliers, snap clip into pin grooves with closed end of clip facing rotational direction of chain (Figure 3A).

2. **WARNING!** Make sure the clip is properly tension-seated in the groove of the pins. If the clip is loose, adjust the side plate up the pins with pliers until it is snug against the clip. **NEVER REUSE A CONNECTING LINK.**

3A



3AA



NOTE: After installing the clip or rivet, inspect the connected links to make sure there are no links that are bound or stiff (Figure 3AA).

INSTALLING THE RIVET: Lock the chain together using a rivet link. Chain tool flares the two open holes on the sideplate pins to secure plate to the connecting link.

First, follow procedures 1-10 in the Installation/Press-fitting of Sideplate for Clip and Rivet section above on page 2.

1. Thread the large pressure bolt PBL220 into the tool body TB2100. Once threaded partially into the tool, insert flare pin FP500JP1 into the large pressure bolt PBL220 (Figure 3B). Insert tail piece TPP220 into hole in tool wall opposite the large pressure bolt PBL220 (Figure 3C)

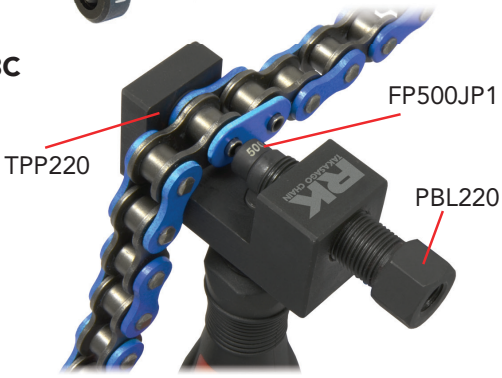
2. Align the flare pin FP500JP1 with the hole in the end of the connecting link pin. Make sure the other end of the connecting link pin is seated in the tail piece TPP220 (Figure 3C). Tighten the large pressure bolt PBL220 by hand so that the flare pin FP500JP1 is snug against the connecting link pin hole (Figure 3C).

3. Use a 17mm wrench to tighten the large pressure bolt PBL220 until the pin hole is flared out sufficiently to keep the side plate from coming off. The flare pin FP500JP1 will correctly flare the rivet to the correct depth/width (Figure 3D). Repeat this procedure for the second pin.

3B

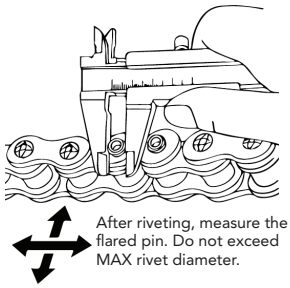


3C



3D

Rivet Tool Diameters		
Rivet Flare Pin Type	4 Series FP428JP	5 Series FP500JP1
Plate Holder Type	4 Series PH428	5 Series PH500JP
MAX Rivet Diameter	4.65mm +0.1-0mm	5.55mm +0.1-0mm



*415HRU MAX Rivet Diameter is 4.10 +0.1-0mm
*525XRE MAX Rivet Diameter is 5.6 +0.2-0mm
**Flare dimensions according to RK Chain

WARNING! Tighten the large pressure bolt PBL220 only until firm resistance is felt, then loosen the large pressure bolt PBL220 and inspect the connecting link pin for complete, even flaring. Do not over-tighten the bolt – you may bend or damage the link pins or bind the link entirely. A pronounced, even flare will securely connect the chain links together.

Check to make sure there is no crack on the flare.



See below for complete chart of Min/Max rivet diameters

US / CANADA

EUROPE / ASIA

CHAIN WARNING SIGNS

RK TAKASAGO CHAIN

WARNING:
Failure to address the warning signs shown on this page can result in reduced chain life and/or can cause a very dangerous situation.

RK recommends that you inspect your chain prior to each ride and follow proper chain maintenance procedures to get the longest life out of your chain.

MAINTENANCE:
All Chains require maintenance and lubrication. For off-road use, clean and lube the chain after every ride. For street chains, clean and lube the chain every 200 miles or 300 km for non-sealed chains and 300 miles or 500 km for sealed chains.

Clean the chain with a mineral oil based cleaner and a soft cloth to remove excess dirt and grit. **Do not** use any cleaner that contains acid, caustic chemicals or brake cleaner to maintain your chain. **Do not** use coarse brushes to clean your chain as they could damage the rubber seals. **Avoid** steam cleaning and high pressure water on both sealed and non-sealed chains. These actions can contaminate the internal lubricant which can cause premature chain wear.

LUBRICATION:
Keeping your chain clean and generously lubricated with a quality motorcycle specific chain lube will ensure the long life and performance of the chain. If the chain has seals, be sure to use an O-Ring safe chain lubricant.

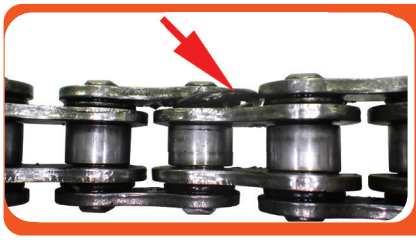
If you have any questions please visit our website for FAQ and contact information.

Being the Best is a Commitment

web: global.rk-japan.co.jp
web: rk-europe.com
web: RKExcelAmerica.com



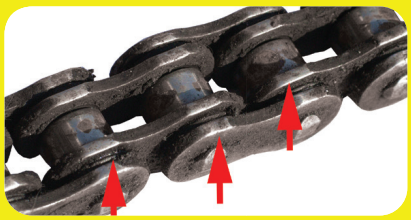
SEVERE
Cracks
Cracks can be caused by age or too much load. If you see any cracks, stop riding immediately and replace the chain. Continuing to ride on a chain with cracks can be very dangerous!



URGENT
Missing or Damaged Seals
Using improper cleaning chemicals and/or use of improper cleaning tools can result in the installed seals being damaged. Chain wear life will be reduced, stop riding and replace the chain immediately.



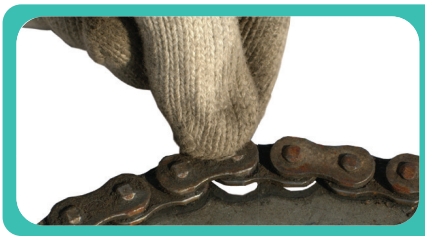
CRITICAL
Pin Rotation
RK's quad-staked pins should look square when looking at the chain. Rotated pins are a sign of worn pins and bushings. If some pins have rotated with points facing up, replace the chain immediately.



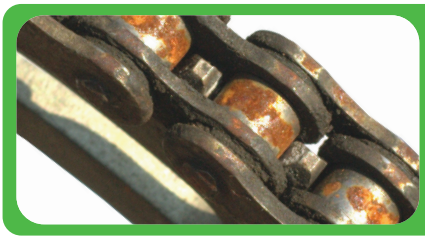
SERIOUS
Wear Marks
When the side plates on the top and bottom show worn flat spots, replace the chain as soon as possible. Flat spots indicate the wearing away of metal and chain strength has been reduced.



CAUTION
Kinks
As chains age they can become stiff and kinked. This can occur from not properly maintaining the chain. Kinks will prevent the chain from moving normally. Replace the chain as soon as possible.



ALERT
Chain Flotation
If the chain can be pulled away from the rear sprocket, it is a sign of elongation. Elongation occurs as chains age and the internal pins wear. The chain should be replaced soon.



ATTENTION
Rust
Chains that show signs of rust indicate improper maintenance and/or neglect. Rust will prevent normal chain movement and will reduce the life of the chain. Clean and lube your chain immediately.



NOTICE
Dirt and Debris
Chains that are allowed to accumulate excess amounts of dirt and debris will have a reduced wearlife. Follow proper chain cleaning procedures. Clean and lube the chain every 300 miles or 500 km. Don't allow dirt to build up.