



Rivet Spinner and Chain Breaker

Owner's Manual



! **WARNING:** Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

Item #53959

SAVE THESE INSTRUCTIONS

Thank you very much for choosing a Strongway™ product!

For future reference, please complete the owner's record below:

Serial Number/Lot Date Code: _____

Purchase Date: _____

Save the receipt, warranty, and this manual. It is important that you read the entire manual to become familiar with this product before you begin using it.

This rivet spinner and chain breaker is designed for certain applications only. Northern Tool and Equipment is not responsible for issues arising from modification or improper use of this product such as an application for which it was not designed. We strongly recommend that this product not be modified and/or used for any application other than that for which it was designed.

For technical questions, please call **1-800-222-5381**.

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Intended Use

The Strongway Rivet Spinner and Chain Breaker safely breaks chain pitches and connects chain loops with a professional, factory-spun look. This 2-in-1 tool offers a complete solution for your chainsaw chain maintenance and repair needs.

Important Safety Information

⚠️WARNING

- Read and understand all instructions. Failure to follow all instructions may result in serious injury or property damage.
- The warnings, cautions, and instructions in this manual cannot cover all possible conditions or situations that could occur. Exercise common sense and caution when using this sharpener. Always be aware of the environment and ensure that the tool is used in a safe and responsible manner.
- Do not allow persons to operate or assemble the sharpener until they have read this manual and have developed a thorough understanding of how it works.
- Do not modify this sharpener in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the product. There are specific applications for which the product was designed.
- Use the right tool for the job. DO NOT attempt to force small equipment to do the work of larger industrial equipment. There are certain applications for which this equipment was designed. It will be safer and do a better job at the capacity for which it was intended. DO NOT use this sharpener for a purpose for which it was not intended.
- Industrial or commercial applications must follow OSHA requirements.

⚠️WARNING

This product may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

⚠️WARNING

WORK AREA SAFETY

- Inspect the work area before each use. Keep work area clean, dry, free of clutter, and well-lit. Cluttered, wet, or dark work areas can result in injury. Using the sharpener in confined work areas may put you dangerously close to other cutting tools and rotating parts.
- Keep children and bystanders away from the work area while operating the tool. Do not allow children to handle the sharpener.

⚠️WARNING

PERSONAL SAFETY

- Stay alert, watch what you are doing, and use common sense when operating the sharpener. Do not use the tool while you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating the sharpener may result in serious personal injury.

- Dress properly. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts. Air vents on the tool often cover moving parts and should be avoided.
- Wear the proper personal protective equipment when necessary. Use ANSIZ87.1 compliant safety goggles (not safety glasses) with side shields, or when needed, a face shield. Use a dust mask in dusty work conditions. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate. This applies to all persons in the work area.
- Do not overreach. Keep proper footing and balance at all times.
- Secure the work with clamps or a vise instead of your hand when practical. This safety precaution allows for proper tool operation using both hands.

⚠CAUTION

RIVET SPINNER AND CHAIN BREAKER USE AND CARE

- Do not force the rivet spinner and chain breaker. Products are safer and do a better job when used in the manner for which they are designed. Plan your work, and use the correct product for the job.
- Do not modify the rivet spinner and chain breaker in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the equipment.
- Check for damaged parts before each use. Carefully check that the rivet spinner and chain breaker will operate properly and perform its intended function. Replace damaged or worn parts immediately. Never operate the product with a damaged part.
- Store the rivet spinner and chain breaker when it is not in use. Store it in a dry, secure place out of the reach of children. Inspect the tool for good working condition prior to storage and before re-use.
- Use only accessories that are recommended by the manufacturer for use with your rivet spinner and chain breaker. Accessories that may be suitable for one product may create a risk of injury when used with another tool. Never use an accessory that has a lower operating speed or operating pressure than the tool itself.
- Keep guards in place and in working order. Never operate the rivet spinner and chain breaker without the guards in place.

Specific Operation Warnings

⚠WARNING

- To prevent serious injury or death, read and understand owner's manual before use.
- Wear ANSI Z87.1 compliant safety goggles.
- Keep hands clear of chain breaker during use.
- Keeps hands clear of anvil during use.
- Inspect for damaged parts before use.
- Not for use by or around children.

Main Parts of Product

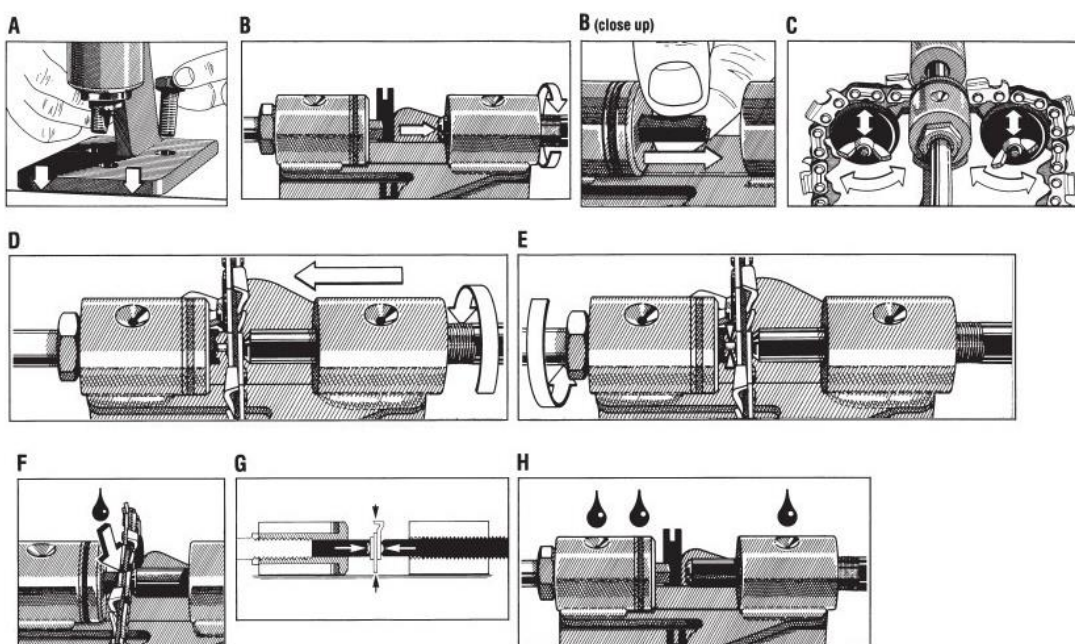
Reference	Subassembly
1	Base
2	Anvil
3	Handle
4	Thrust

Assembly Instructions

Bench Mounting

The rivet spinner and chain breaker is equipped with two holes for mounting. Lag screws or bolts (not supplied) may be used to hold the unit into position (A).

Mount with rivet spinner and chain breaker flush with the side or front of the bench area. (Mounting rivet spinner flush to the bench allows chains to clear for spinning.)



Spinner Anvil/Take-up Handle Chart

Take-Up Handle Marking	"B"	"A"	"B"	"A"
Spinner Anvil Marking	"B"	"A"	"B"	"A"
Chain Pitch	1/4	3/8	.325	.404
Drive Link Number	25	72 73 75 76 77 78 91	20 21 22 33 34 35	16 18 26 27 28 50 51 52 57 58 59

Replacing the Spinner/Anvil

To remove a worn or damaged spinner/anvil, unscrew the take-up handle until the spinner anvil can be easily removed (B). Replace it with a new or repaired anvil and take-up handle.

Note: The unit is supplied with two spinner anvils marked "A" "B" and two take-up handles to match the spinner anvils.

Before Each Use

⚠WARNING

Check for damaged or worn parts.

Operating Instructions

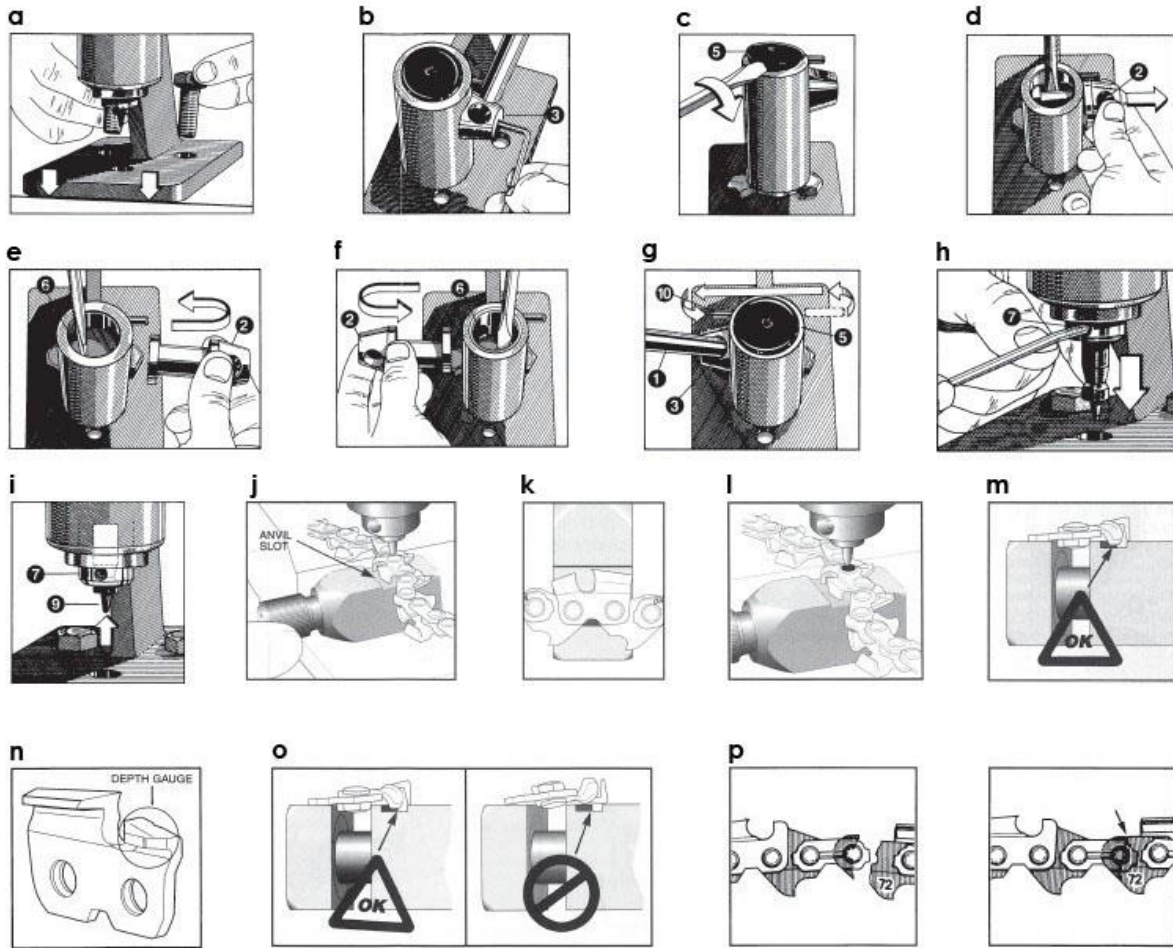
Right or Left Hand Use

The rivet spinner and chain breaker arrives assembled for right-hand use. If left-hand use is preferred, follow the instructions below:

1. Unscrew the set screw and remove the handle (b).
2. Remove the plastic cap with a screwdriver and depress the spring-loaded punch holder to free up the cam (c-d).
3. Slide the cam out by the right side of the unit (e).
4. Reinsert the cam into the opposite side of the unit. Depress the punch holder and insert the cam (f).
5. Replace the plastic cap and reinsert the handle. Tighten the set screw with an Allen wrench.
6. Remove the stop pin from the right side of the unit and reinsert it into the left side (g).

Rivet Spinning

1. Lay the chain across plastic chain supports (c).
2. Rotate the chain supports so that the rivet head is centered between the take-up handle pocket and the spinner anvil (c).
3. Turn the take-up handle until the chain is secured against the spinner anvil (d).
4. Turn the spinner crank a few times to center the rivet hub in the spinner anvil (e).
5. Apply a few drops of oil to the rivet hub (f).
6. Turn the spinner crank and at the same time, slowly turn the take-up handle inward (approximately one full revolution) until the rivet head is formed. The take-up handle will provide pressure while the spinner anvil will form a rivet head (g).



Replacing the Punch

1. To remove a worn or damaged punch, loosen the set screw with an Allen wrench (h).
2. Insert a new punch into the punch holder. (Push the punch up with the unit fully seated.) Tighten the set screw (i).

Replacing a Broken Drive Link

The point of breakage usually occurs at or near the rivet hole. To replace:

1. First, remove the cutter or the strap and half of the broken drive link. Connect the two broken sections back to the original position prior to the breakage (p).
2. Center the breaker punch over the rivet head and pull the handle down just enough to push the rivet out. Repeat with the other rivet. Do not use excessive force.

Chain Breaking

1. Insert the chain portion to be broken into the slot of the adjustable anvil (j). Tighten the adjustment knob unit until the chain is securely positioned. Position the cutter as shown k).

Note: It is not necessary to re-adjust the anvil when breaking multiple loops of chain of the same chain type.

2. Position the rivet head directly under the punch and pull the handle down just far enough to push the rivet out. Do not use excessive force (i).

Note:

- A. When breaking a chain at the cutter, make sure the cutter is in the correct position (illustration m, previous page).
- B. For cutters with depth gauges, as in illustration n, make sure to position the cutter properly, shown in illustration o, using the side of the adjustable anvil with the slot.

After Each Use

⚠WARNING

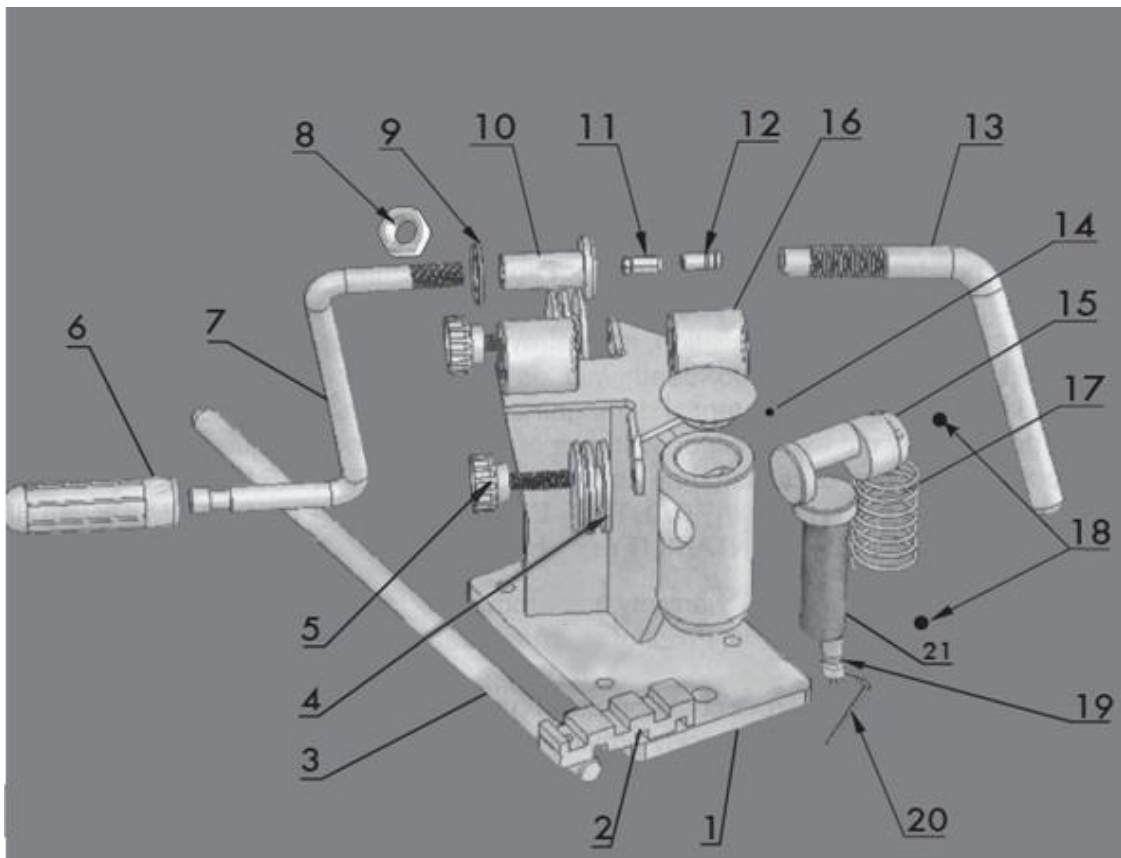
Keep the rivet spinner and chain breaker away from children.

Maintenance

It is recommended that the general condition of any tool be examined before it is used. Keep your rivet spinner and chain breaker in good repair by adopting a program of conscientious repair and maintenance. Have necessary repairs made by qualified service personnel.

This rivet spinner and chain breaker is equipped with oiling chambers and should be maintained periodically with lightweight oil (illustration h, on previous page).

Parts Diagram



Parts List

Part#	Description	Qty.	Part#	Description	Qty.
1	Base	1	11	Spinner Die	2
2	Anvil	1	12	Thrust Die	2
3	Breaker Lever	1	13	Thrust Handle	1
4	Guide Wheel	2	14	Spring Pin	1
5	Wheel Locking Screw	2	15	Breaker Cam	1
6	Spinner Grip	1	16	Cam Holder Cover	1
7	Spinner Handle	1	17	Spring	1
8	Hex Nut	1	18	Hex Screw m5	2
9	Flat Bearing	1	19	Breaker Punch	1
10	Spinner Sleeve	1	20	Hex Wrench m2.5	1
			21	Tool Holder	1

Replacement Parts

- For replacement parts and technical questions, please call Customer Service at **1-800-222-5381**.
- Not all product components are available for replacement. The illustrations provided are a convenient reference to the location and position of parts in the assembly sequence.
- When ordering parts, the following information will be required: item description, item model number, item serial number/item lot date code, and the replacement part reference number.
- The distributor reserves the rights to make design changes and improvements to product lines and manuals without notice.

Limited Warranty

Northern Tool and Equipment Company, Inc. ("We" or "Us") warrants to the original purchaser only ("You" or "Your") that the Strongway product purchased will be free from material defects in both materials and workmanship, normal wear and tear excepted, for a period of **one year** from date of purchase. The foregoing warranty is valid only if the installation and use of the product is strictly in accordance with product instructions. There are no other warranties, express or implied, including the warranty of merchantability or fitness for a particular purpose. If the product does not comply with this limited warranty, Your sole and exclusive remedy is that We will, at our sole option and within a commercially reasonable time, either replace the product or product component without charge to You or refund the purchase price (less shipping). This limited warranty is not transferable.

Limitations on the Warranty

This limited warranty does not cover: (a) normal wear and tear; (b) damage through abuse, neglect, misuse, or as a result of any accident or in any other manner; (c) damage from misapplication, overloading, or improper installation; (d) improper maintenance and repair; and (e) product alteration in any manner by anyone other than Us, with the sole exception of alterations made pursuant to product instructions and in a workmanlike manner.

Obligations of Purchaser

You must retain Your product purchase receipt to verify date of purchase and that You are the original purchaser. To make a warranty claim, contact Us at 1-800-222-5381, identify the product by make and model number, and follow the claim instructions that will be provided. The product and the purchase receipt must be provided to Us in order to process Your warranty claim. Any returned product that is replaced or refunded by Us becomes our property. You will be responsible for return shipping costs or costs related to Your return visit to a retail store.

Remedy Limits

Product replacement or a refund of the purchase price is Your sole remedy under this limited warranty or any other warranty related to the product. We shall not be liable for: service or labor charges or damage to Your property incurred in removing or replacing the product; any damages, including, without limitation, damages to tangible personal property or personal injury, related to Your improper use, installation, or maintenance of the product or product component; or any indirect, incidental or consequential damages of any kind for any reason.

Assumption of Risk

You acknowledge and agree that any use of the product for any purpose other than the specified use(s) stated in the product instructions is at Your own risk.

Governing Law

This limited warranty gives You specific legal rights, and You also may have other rights which vary from state to state. Some states do not allow limitations or exclusions on implied warranties or incidental or consequential damages, so the above limitations may not apply to You. This limited warranty is governed by the laws of the State of Minnesota, without regard to rules pertaining to conflicts of law. The state courts located in Dakota County, Minnesota shall have exclusive jurisdiction for any disputes relating to this warranty.



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