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## ...Magnet chain installation instructions:

1. Position stick tip over the magnet with the terminal box nearest the crane.
2. Hang the chain by the master link on a hook, clevis or yoke pin so that the legs hang freely above magnet. **Installing a chain while it is lying on top of the magnet is not recommended.**
3. The master link should be oriented as follows:
  - A. Oval master link – either end is acceptable.
  - B. D-master link is positioned with the “D” flat side down.
  - C. Pear master link with the larger radius at the bottom.
4. Position the three chain legs so that the leg with the certification tag is in the center. Note: The center leg on pear master link assemblies is longer than the other two.
5. The middle leg is to be attached to the lifting lug opposite the terminal box.
6. Attach remaining legs to the lifting lug they are closest to, right is attached to the right lug and left to the left lug. Note: Chain legs should easily reach the lugs; if they are twisted or kinked they will seem to be too short.
7. Lift the magnet from the ground, it should hang level, if it is dipping to one side look to see if the opposite side leg is twisted or kinked.
8. The chain links will line up straight every other link and not curl or twist when properly installed (**see drawing #1**). The chain will not twist on its own if hung from the crane properly.
9. A chain assembly **should not** be oiled or greased to prevent it from rusting or provide less friction. A layer of oil or grease will cause dirt, sand, metal fines, etc. to stick and may act as an abrasive that can lead to premature wear.
10. Any time the magnet chain is removed from the magnet this procedure should be followed.
11. Scrap magnets rarely encounter a load that exceeds the chains capacity / working load limit, however shock loading a chain can multiply by two, three or more times the weight of the material being lifted. This “shock loading” or jerking of the magnet chains can stretch links which can lead to premature wear or snap them.

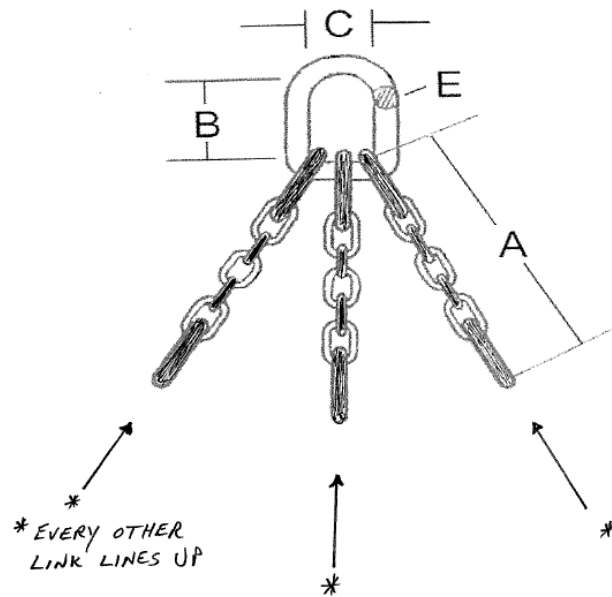
See the following examples of an **improperly** installed chain: **Picture #1**: The chain legs are twisted; you can see it best on the left leg. Also the chain was hooked on the magnet correctly but the master link was hooked up at a 90 degree angle to the material handlers yoke causing binding. Being attached to a yoke style hanger limits the ability to self-correct like a swivel hook allows. **Picture #2**: A close-up of the wear on the connecting link is shown. The right leg is twisted causing binding, notice the fourth body link compared to the orientation of the second link above it. They do not line up in a straight line.



PICTURE 1



PICTURE 2



DRAWING 1