

**Digging Chain
Selection Guide
AU105812 (Subset)
4.501" Pitch Chain**

H7F

ASTECC

HOW TO USE THIS GUIDE

The Astec Chain Guide is organized into several sections.

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Chain Selection

Whether selecting a complete chain assembly or just replacing components, first establish your Astec "Smart" Part Number Key. See page 3.

Use the information from *Sections 1* and *2* to determine the **Chain Pitch** and **Pitch Spacing**. Select the cutting station **Configuration Code** for the application. Refer to *Section 3*. Then select the **Digging Width** and **Number of Stations** required based on your machine and boom length.

These criteria will establish the **Astec "Smart" Part Number**. Find the page in the appropriate *Chain Section 4 through 13* labeled with the Smart Part Number Key you have defined. This page will show the chain configuration, and all component part numbers. Or, once defined, look up the Smart Part Number in the index in the back of this guide.

DIGGING CHAIN SELECTION GUIDE



CHAIN001

TRENCHER BOOMS

Astec utilizes a variety of trencher booms depending on machine size and application. Most trencher models offer either a sprocket boom or rock boom. Boom selection will depend on trench depth, width and ground conditions. When making a selection, the measurements given always refer to dig depth and not actual boom length.

Sprocket Booms

Sprocket booms are used in a variety of ground conditions. Their most frequent use is in nominal type soils, free of most rock and debris. Sprocket booms may have a sprocket on both the top and the bottom of the boom, while others may have only one on the bottom.

Rock Booms

Rock booms, or channel booms as they are sometimes referred to, have wear bars on the top and the bottom of the boom. Wear bars can be replaced as needed just as you would replace a sprocket on a sprocket boom. Some machines have reversible wear bars which offer double the life. Rock booms tend to be quieter and have fewer parts.

Rock booms are heavier and aid in the trenching process. The larger tail wheel aids in keeping the digging teeth at a better angle while trenching. Remember, when you select the boom you want on your trencher attachment, it will determine the split sprocket and auger drive sprocket for your machine. This is important, as it will also determine the pitch of the digging chain that you wish to install on the boom.

DIGGING CHAINS

Digging chains can be very confusing because of the variety of chain configurations available. Astec is a ready source of on-the-spot information. You can also refer to this selection guide for descriptions of the various chains that you may want to utilize.

Chain

Chain is classified first by tensile strength (i.e. a 50,000 lb. chain). The theory is that it would take 50,000 pounds of pull to pull the chain apart. If we use the old statement that a chain is only as strong as its weakest link, we can understand how important it is to maintain chain quality.

Chain Pitch

The most common description of a chain is its pitch. The pitch will determine the size of the chain and the number of cutting stations on the chain. The distance between the pins, not the bolt pattern, determines pitch. A 2-inch pitch chain tells us that the distance between the pins is 2 inches. When we count the pins on a chain, we then know how many cutting stations there are on the chain and how long the chain is. Example: A 2-inch pitch chain with 40 pins has 20 cutting stations and is 80 inches long; 40 divided by 2 equals 20, 40 times 2 equals 80.

Some machines can use either a 2-pitch or 4-pitch chain. Simply put, a 2-pitch chain has a tooth on every cutting station and a 4-pitch chain has a tooth on every other cutting station. Given the example above, if this were a 2-pitch chain it would have 20 teeth, and if it were a 4-pitch chain it would have 10 teeth.

1

CHAIN TYPES

There are a variety of chains and chain setups to choose from. When the task for the machine is defined the best chain setup can be determined for the application.

HD ABF

The standard 1.65 and 2.00 pitch digging chain works fine in most digging conditions. However, because of the design, the standard chain teeth can rotate back (backflex) when digging in heavy or rocky ground. When this backflexing action starts, the teeth do not remain at the correct digging angle and the trenching speed is reduced.

The Heavy Duty Anti-Backflex digging chain is designed for hard digging conditions. The sides of each link are close together. As the chain leaves the sprocket, each link comes together with the next and forms a solid digging channel. This action keeps each digging tooth at the correct digging angle. The HD ABF chain is available in 2.64, 3.03 and 4.08 pitch.

Cup Cutter Chain

A cupped chain has regular Cup Cutter Teeth on all the stations. Cupped chains may be widened with the aid of spreader bars (saddle blocks). Chain width limitation is governed by the size of the machine and the dig depth.

Rock/Frost Chain (Bolt-On)

This chain has all bolt-on Rock/Frost Mining Teeth, and can also be widened with the aid of spreader bars (saddle blocks). Chain width limitation is governed by the size of the machine and the dig depth.

Rock/Frost - Cup Combo Chain

This chain is an equal combination of Cup Cutter Teeth and bolt-on Rock/Frost Mining Teeth. Chain width can be altered to suit certain applications. Chain width limitation is governed by the size of the machine and the dig depth.

Shark Chain (Bolt-On)

This chain utilizes a slender tooth with a carbide tip, and can also be widened with the aid of spreader bars (saddle blocks). Chain width limitation is governed by the size of the machine and the dig depth.

Shark - Cup Combo Chain

This chain is an equal combination of Cup Cutter Teeth and bolt-on Shark Teeth. Chain width can be altered to suit certain applications. Chain width limitation is governed by the size of the machine and the dig depth.

H-Plate Chain

A flat plate is welded on each station and tooth pockets are welded to the plate. At the front of each cutting station is an angle iron to assist in cleaning the ditch. H-Plate chains are fixed as far as width. The chain is welded and there are no bolts. H-Plate chains work well in tough conditions. Productivity is sometimes compromised, but this chain is strong and will give long life in the right application.

Welded Shark Chain

This chain utilizes welded on Shark Teeth. The theory here is that the teeth last as long as the chain. When the chain wears out, you discard the chain and replace it.

BOOM, CHAIN & TOOTH RECOMMENDATIONS FOR SOIL TYPE

Soil Type	Boom Type		Chain Type			Digging Teeth			
	Sprocket Boom	Rock Boom	Standard Astec Chain	HD ABF	H-Plate	Cup Cutter	Rock/Frost Mining Bit	Shark	Mixed
Sand	X		X			X			
Sandy Loam	X		X			X			
Loose Shale	X	X	X			X			X
Top Soil	X		X			X			
Caliche (Hard)		X		X		X	X	X	X
Clay (Gumbo)	X			X		X			
Coral		X		X	X		X	X	
Rock (Loose)		X		X	X		X	X	
Asphalt		X		X	X		X	X	
Hard Clay		X		X	X	X	X	X	X
Frozen Soil		X		X	X		X	X	X

Note: A rock wheel is required to cut solid rock or concrete.

TRENCHER CHAINLINE PART NUMBERS

Chain Rating Information

A number related to pitch length serves as an aid in identifying Astec Chain. For example, the 264 chain has a pitch length of 2.64 inches. The approximate equivalent tensile strength rating for these chains is shown below.

Chain Number	Ultimate Strength Rating (approximate)
150	13,000 lb.
165	38,000 lb.
200	50,000 lb.
264	75,000 lb.
303	165,000 lb.
408	225,000 lb.
4501	330,000 lb.
4502	440,000 lb.

"Smart" Part Number Key

Astec incorporates a 12-character "Smart" Part Number key for chain assemblies. The Smart Part Number allows identifying the chain assembly configurations and lengths as detailed below.

AU 165 2 SC 04 34

Chain Pitch	Pitch Spacing	Configuration Code	Digging Width (inches)	Number of Stations
150 = 1.500"	2	CT = Cup Teeth	04 = 4 Inches	34 = 34 Stations
165 = 1.654"	4	RB = Rock/Frost Mining Bit Teeth (Full Bolt-On)		
200 = 2.00"		SB = Shark Bits (Full Bolt-On)		
264 = 2.648"		RC = Rock/Frost Mining Bit - Cup Teeth Combination		
303 = 3.034"		SC = Shark Bits - Cup Teeth Combo		
408 = 4.086"		HP = H-Plate Welded Rock/Frost Teeth		
451 = 4501		SW = Welded Shark Bits		
452 = 4502		XS = Xpandable Shark Bits		

Available bare chain is also identified by using the Smart Part Number as detailed below.

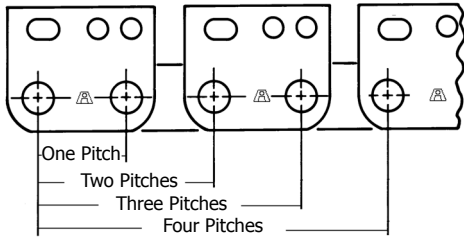
AU 303 B2 30

Chain Pitch	Configuration Code	Number of Stations
150 = 1.500"	B4 = 4-Pitch Spacing Standard Chain	30 = 30 Stations
165 = 1.654"	B2 = 2-Pitch Spacing HD A.B.F. Chain	
200 = 2.00"	BL = Low Profile 2-Pitch A.B.F. for Welded Assemblies	
264 = 2.648"		
303 = 3.034"		
408 = 4.086"		
451 = 4501		
452 = 4502		

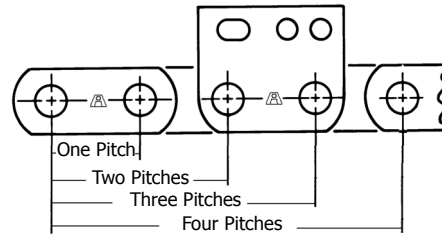
Glossary of Terms

Chain Pitch	The measurement of distance from center of one rivet to center of next rivet on a chain.
Station	Term used to identify where a tooth is mounted.
2-Pitch Spacing	There is a tooth on every station.
4-Pitch Spacing	There is a tooth on every other station.
Carbide Bit	Conical bits with carbide insertions (Mining Bit).
Cup Cutter	Standard term for trencher teeth.
Rock/Frost	Term used for a chain set up with Mining Bits.
Shark Bit	Term used for a chain set up with carbide bits (Shark Teeth).
H-Plate	A welded chain assembly (no bolts) with carbide bits and a fixed width. Used in tough conditions.
Rock Boom	Usually a solid boom with large end roller and no idler sprockets.
Sprocket Boom	Usually a boom using idler sprockets and boom end sprocket.
Repair Section	A section of chain used for repair. Can be 2-Pitch or 4-Pitch.
Connector Pin	The pin used to connect the end of chains together.
Pocket	Holders for the rock/frost bits (Mining Bits).
Spreader Bar	(Saddle Block) Term used for the bracket that allows you to change the cutting width of a chain line.
Welded Shark	Solid Welded chain using Shark teeth.

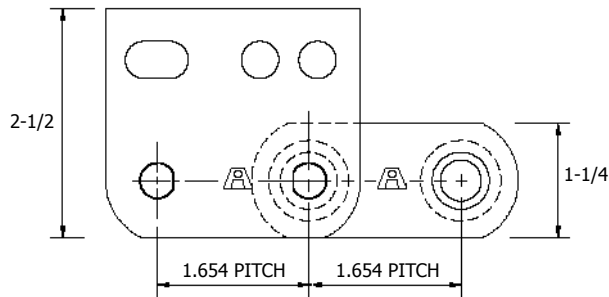
CHAIN IDENTIFICATION



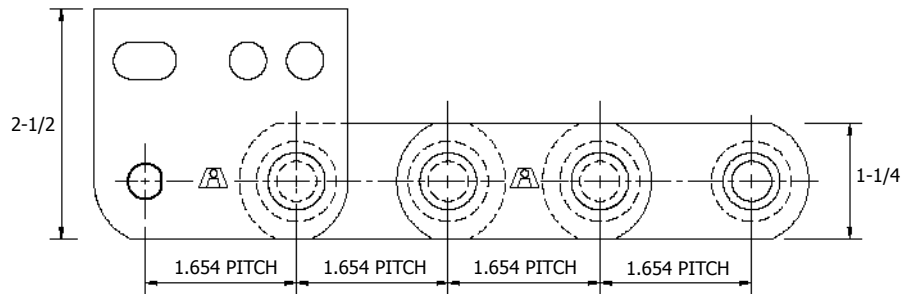
2 Pitch Chain



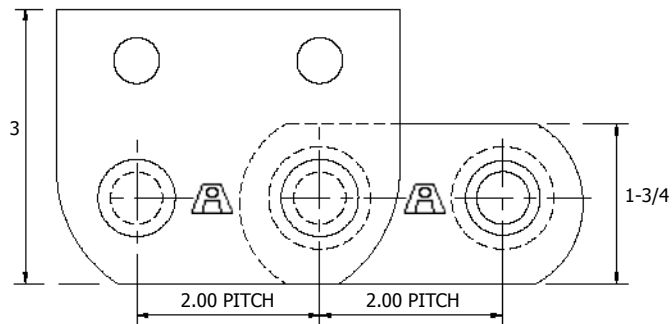
4 Pitch Chain



165 Bolt-on 2-Pitch Chain

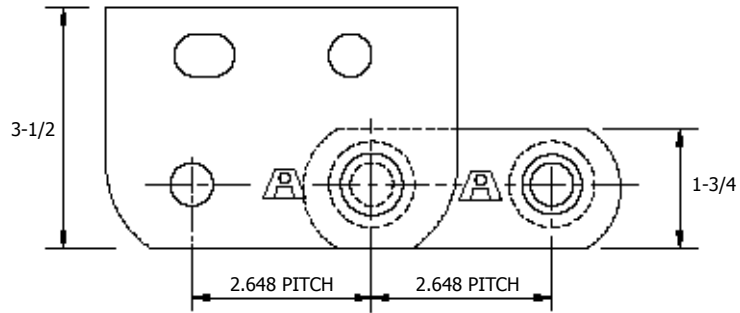


165 Bolt-on 4-Pitch Chain

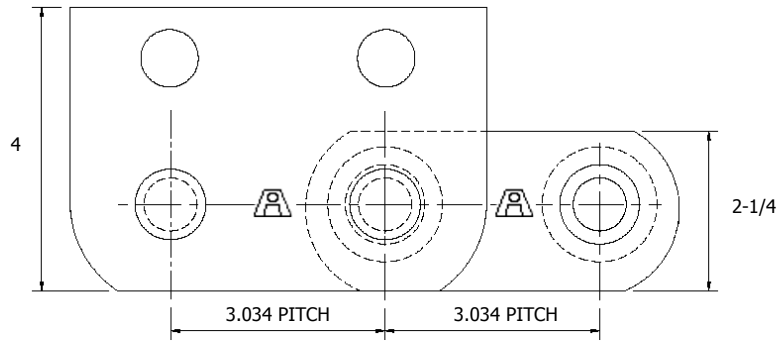


200 Bolt-on 2-Pitch Chain

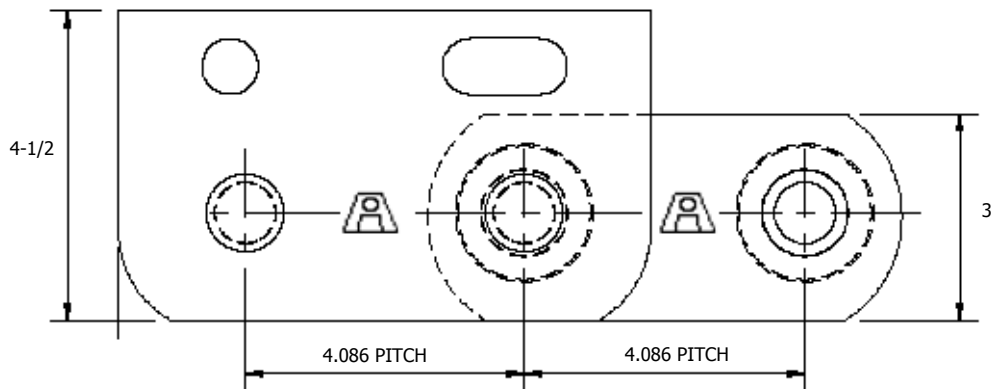
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264 Bolt-on 2-Pitch Chain



303 Bolt-on 2-Pitch Chain



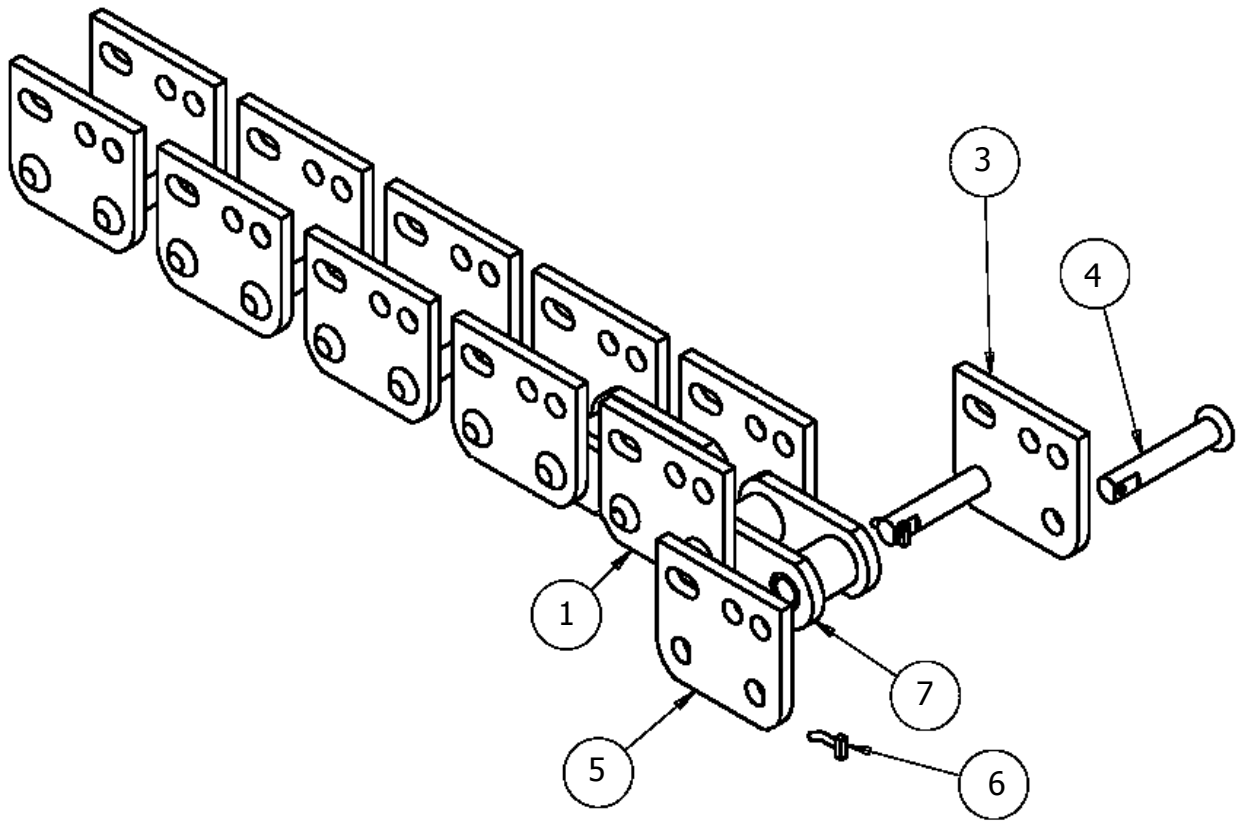
408 Bolt-on 2-Pitch Chain

1.654" 2-Pitch Bare Chain

2

ITEM	QTY	P/N	DESCRIPTION
1	UAR	NSS	Assembly, Link - Riveted, 1.654"
2	1	AU105370	Assembly, Sidebar - 1.654"
3	1	AU105364	Sidebar, Station - Round Holes
4	2	AU105366	Pin, Master - 1.654"
5	1	AU105363	Sidebar, Station - "D" Holes
6	2	AU105367	Keeper, Pin - Master
7	UAR	NSS	Assembly, Link - Inner, 1.654"

LENGTHS AVAILABLE	
Stations	P/N
1	AU165B201
2	AU165B202
6	AU165B206
8	AU165B208
26	AU165B226
28	AU165B228
38	AU165B238

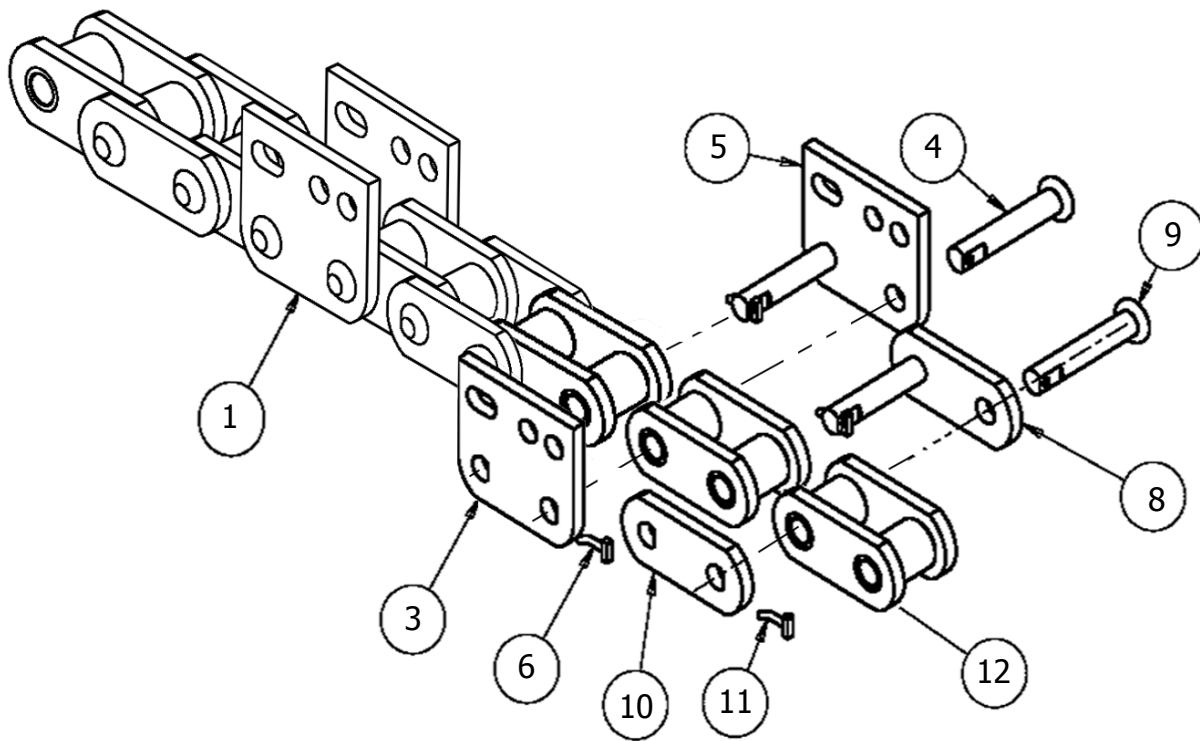


1.654" 4-Pitch Bare Chain

2

ITEM	QTY	P/N	DESCRIPTION
1	UAR	NSS	Assembly, Link - Riveted, 1.654"
2	1	AU105370	Kit, Sidebar - Master, 1.654"
3	1	AU105363	Sidebar, Station - "D" Holes
4	2	AU105366	Pin, Master - 1.654"
5	1	AU105364	Sidebar, Station - Round Holes
6	2	AU105367	Keeper, Pin - Master
7	1	AU105393	Kit, Sidebar - Mid
8	1	AU105390	Sidebar, Link - Inner
9	2	AU105366	Pin, Master - 1.654"
10	1	AU105391	Sidebar, link - Inner
11	2	AU105367	Keeper, Pin - Master
12	UAR	NSS	Assembly, Link - Inner, 1.654"

LENGTHS AVAILABLE	
Stations	P/N
1	AU165B401
2	AU165B402
3	AU165B403
4	AU165B404
13	AU165B413
14	AU165B414
19	AU165B419

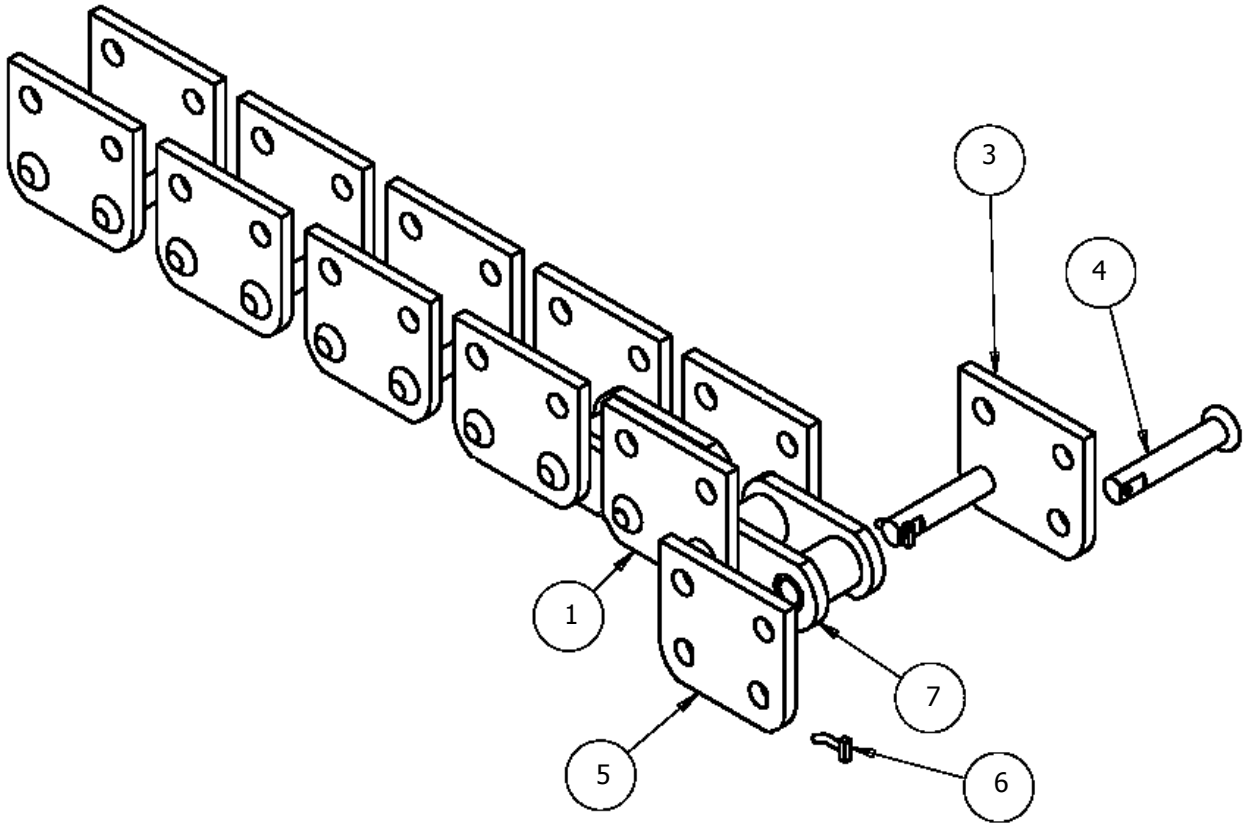


2.00" 2-Pitch Bare Chain

2

ITEM	QTY	P/N	DESCRIPTION
1	UAR	NSS	Assembly, Link - Riveted, 2.00"
2	1	AU105470	Assembly, Sidebar - 2.00"
3	1	AU105461	Sidebar, Station - Round Holes
4	2	AU105460	Pin, Master - 2.00"
5	1	AU105462	Sidebar, Station - "D" Holes
6	2	AU105463	Keeper, Pin - Master
7	UAR	NSS	Assembly, Link - Inner, 2.00"

LENGTHS AVAILABLE	
Stations	P/N
1	AU200B201
3	AU200B203
6	AU200B206
14	AU200B214
32	AU200B232
34	AU200B234
36	AU200B236
42	AU200B242

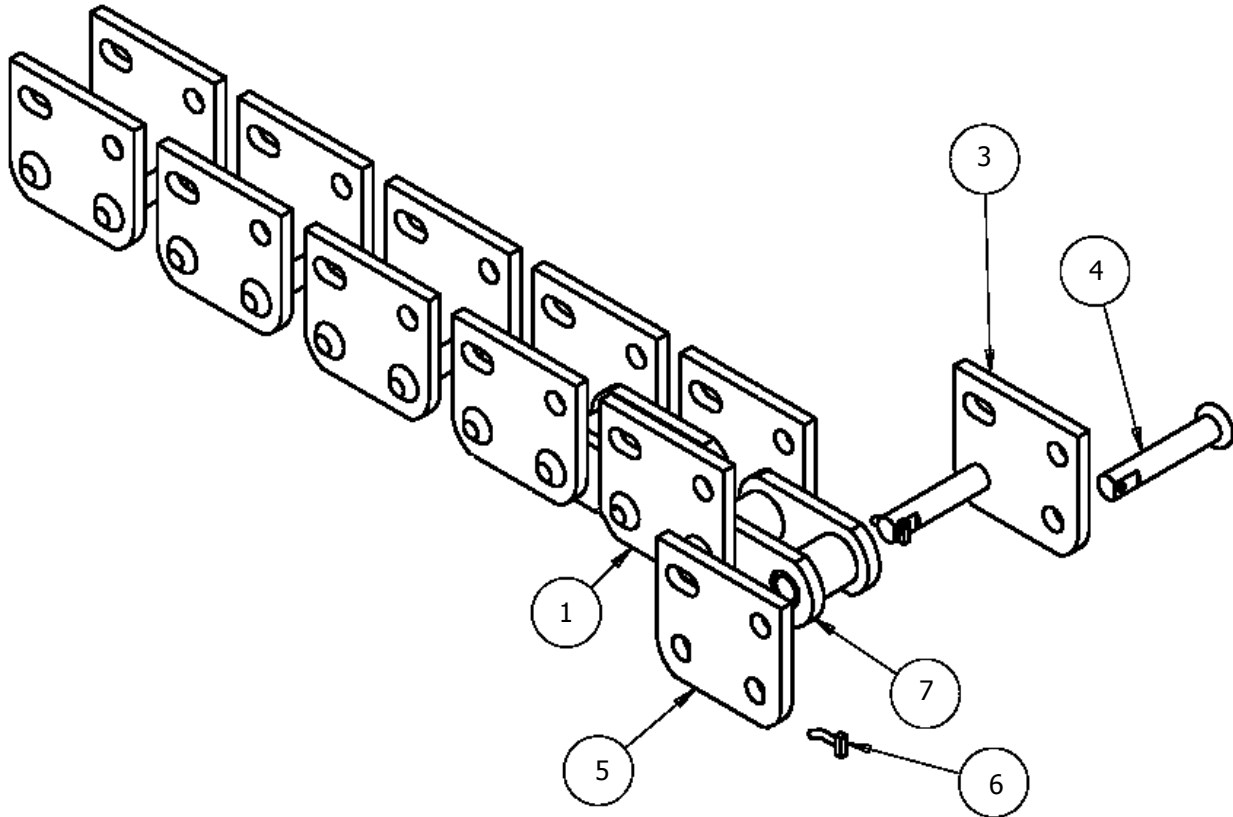


2.648" 2-Pitch Bare Chain

2

ITEM	QTY	P/N	DESCRIPTION
1	UAR	NSS	Assembly, Link - Riveted, 2.648"
2	1	AU105398	Assembly, Sidebar - 2.648"
3	1	AU105397	Sidebar, Station - Round Holes
4	2	AU105396	Pin, Master - 2.648"
5	1	AU105399	Sidebar, Station - "D" Holes
6	2	AU105400	Keeper, Pin - Master
7	UAR	NSS	Assembly, Link - Inner, 2.648"

LENGTHS AVAILABLE	
Stations	P/N
1	AU264B201
2	AU264B202
6	AU264B206
7	AU264B207
24	AU264B224
29	AU264B229
34	AU264B234
35	AU264B235

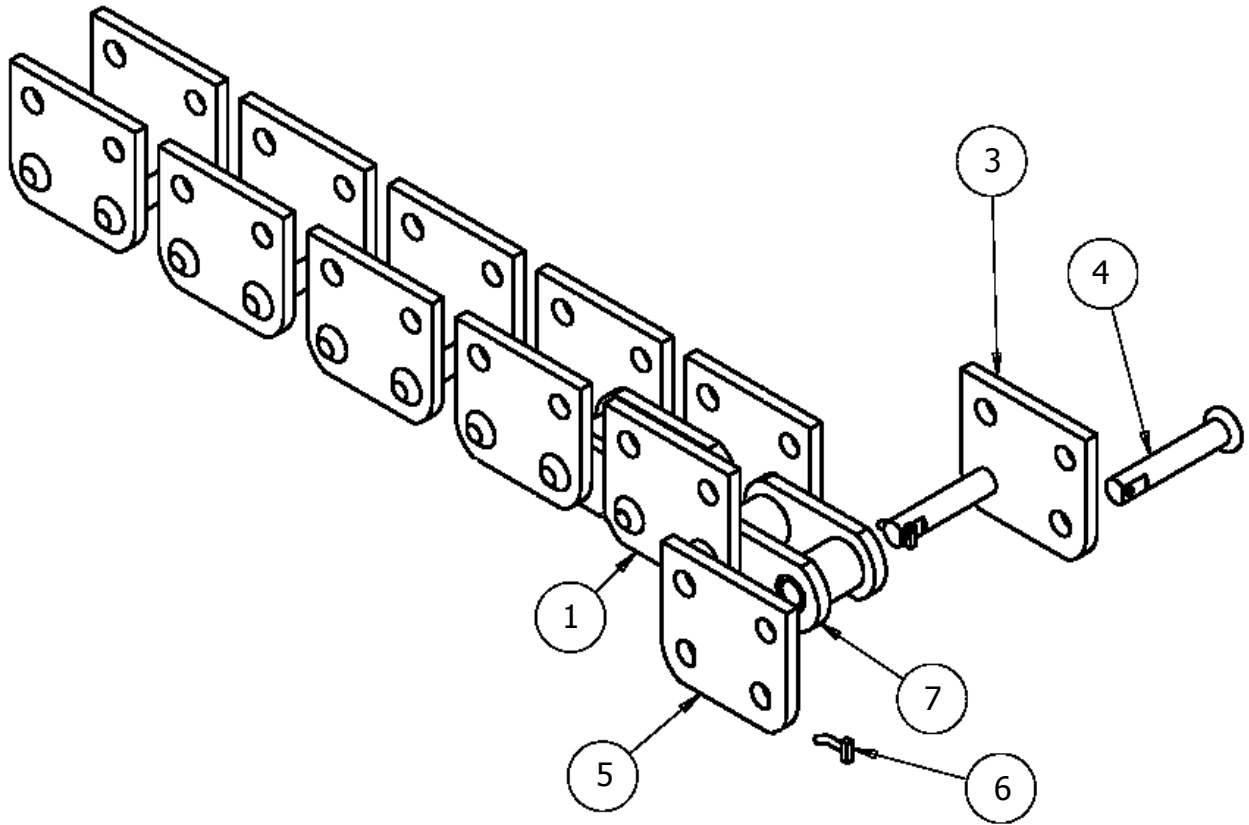


3.034" 2-Pitch Bare Chain

2

ITEM	QTY	P/N	DESCRIPTION
1	UAR	NSS	Assembly, Link - Riveted, 3.034"
2	1	AU105420	Assembly, Sidebar - 3.034"
3	1	AU105412	Sidebar, Station - Round Holes
4	2	AU105413	Pin, Master - 3.034"
5	1	AU105414	Sidebar, Station - "D" Holes
6	2	AU105400	Keeper, Pin - Master
7	UAR	NSS	Assembly, Link - Inner, 3.034"

LENGTHS AVAILABLE	
Stations	P/N
1	AU303B201
2	AU303B202
4	AU303B204
8	AU303B208
30	AU303B230
31	AU303B231
34	AU303B234
42	AU303B242

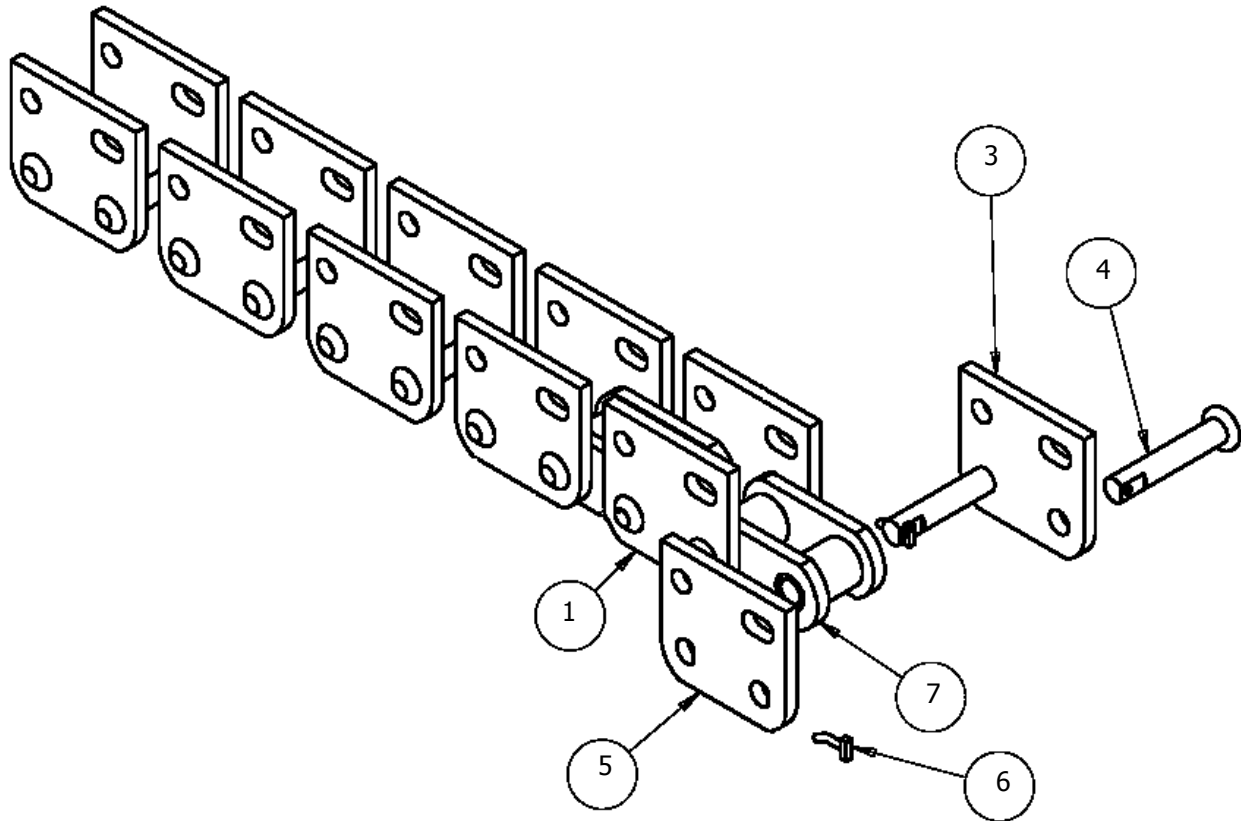


4.086" 2-Pitch Bare Chain

2

ITEM	QTY	P/N	DESCRIPTION
1	UAR	NSS	Assembly, Link - Riveted, 4.086"
2	1	AU105495	Assembly, Sidebar - 4.086"
3	1	AU105487	Sidebar, Station - Round Holes
4	2	AU105489	Pin, Master - 4.086"
5	1	AU105488	Sidebar, Station - "D" Holes
6	2	AU105490	Keeper, Pin - Master
7	UAR	NSS	Assembly, Link - Inner, 4.086"

LENGTHS AVAILABLE	
Stations	P/N
1	AU408B201
2	AU408B202
6	AU408B206
20	AU408B220
25	AU408B225
28	AU408B228
30	AU408B230



CHAIN PITCH - MACHINE QUICK REFERENCE

2

Chain Pitch	Used on Machines	Teeth Available
1.654" 4P	RT60, RT160, Maxi-C, TF300B	Cup Cutter Teeth
1.654" 2P	RT60, RT160, Maxi-C, TF300B	Cup Cutter Teeth Rock/Frost Mining Bit Rock/Frost Mining Bit - Cup Cutter Combo Bolt-on Shark Bolt-on Shark - Cup Cutter Combo Solid Weld Shark
2.00" 4P	RT360	Cup Cutter Teeth
2.00" 2P	RT360	Cup Cutter Teeth Rock/Frost Mining Bit Rock/Frost Mining Bit - Cup Cutter Combo Bolt-on Shark Bolt-on Shark - Cup Cutter Combo Solid Weld Shark Expandable Shark
2.648" 2P	RT360, RT460, RT560, RT660 Quad	Cup Cutter Teeth Rock/Frost Mining Bit Rock/Frost Mining Bit - Cup Cutter Combo Bolt-on Shark Bolt-on Shark - Cup Cutter Combo Solid Weld Shark Expandable Shark
3.034" 2P	RT560, RT660, RT960	Cup Cutter Teeth Rock/Frost Mining Bit Rock/Frost Mining Bit - Cup Cutter Combo Bolt-on Shark Bolt-on Shark - Cup Cutter Combo Solid Weld Shark H-Plate Welded
4.086" 2P	RT960, T560	Cup Cutter Teeth Rock/Frost Mining Bit Rock/Frost Mining Bit - Cup Cutter Combo H-Plate Welded
4501 4502	T560	Cup Cutter Teeth Rock/Frost Mining Bit

SECTION 2 - CHAIN IDENTIFICATION - DIGGING CHAIN SELECTION GUIDE

Chain/Tooth Selection by Machine

2

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Full Bolt-on Rock/Frost Mining Bit	H-Plate Welded Rock & Frost		
RT60	24"	4", 6"	4", 6"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		24"	
	26"										26"	
	36"	4", 6"	4", 6"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		36"	
	40"										40"	
	1.654" Pitch	45"										45"
		48"										48"
		60"										60"
		72"										72"
84"										84"		

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Full Bolt-on Rock/Frost Mining Bit	H-Plate Welded Rock & Frost		
RT160	24"	4", 6", 8"	4", 6", 8"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		24"	
	26"										26"	
	36"	4", 6", 8"	4", 6", 8"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		36"	
	40"										40"	
	1.654" Pitch	45"										45"
		48"	4", 6", 8"	4", 6", 8"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		48"
		60"										60"
		72"										72"
84"										84"		

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Full Bolt-on Rock/Frost Mining Bit	H-Plate Welded Rock & Frost		
TF300B	24"										24"	
	26"	4" to 16"	4" to 16"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		26"	
	36"										36"	
	40"	4" to 12"	4" to 12"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		40"	
	1.654" Pitch	45"	4", 6", 8"	4", 6", 8"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		45"
		48"										48"
		60"										60"
		72"										72"
84"										84"		

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Full Bolt-on Rock/Frost Mining Bit	H-Plate Welded Rock & Frost		
MAXI-C	24"	4", 6"	4", 6"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		24"	
	26"										26"	
	36"	4", 6"	4", 6"	4", 6"	4", 6"	4", 6"		4", 6"	4", 6"		36"	
	40"										40"	
	1.654" Pitch	45"										45"
		48"										48"
		60"										60"
		72"										72"
84"										84"		

DIGGING CHAIN SELECTION GUIDE - CHAIN IDENTIFICATION - SECTION 2

2

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost	
RT360	24"										24"
	26"										26"
	36"	6" to 12"	6" to 12"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		36"
	40"										40"
	45"										45"
	48"	6" to 12"	6" to 12"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		48"
	60"	6", 8"	6", 8"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		60"
	72"										72"
	84"										84"

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost	
RT360	24"										24"
	26"										26"
	36"		6" to 14"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		36"
	40"										40"
	45"										45"
	48"		6" to 12"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		48"
	60"		6", 8"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		60"
	72"										72"
	84"										84"

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost	
RT460	24"										24"
	26"										26"
	36"										36"
	40"										40"
	45"										45"
	48"		6" to 12"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		48"
	60"		6", 8"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		60"
	72"										72"
	84"										84"

Model		Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost	
RT560	24"										24"
	26"										26"
	36"										36"
	40"										40"
	45"										45"
	48"		6" to 12"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		48"
	60"		6" to 12"	6", 8"	6", 8"	6", 8"	8" - 12"	6", 8"	6", 8"		60"
	72"										72"
	84"										84"

SECTION 2 - CHAIN IDENTIFICATION - DIGGING CHAIN SELECTION GUIDE

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Model	Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost		
RT560	24"									24"	
	26"									26"	
	36"									36"	
	40"									40"	
	45"									45"	
	48"		7" to 12"					7" to 12"	7" to 12"	7" to 12"	48"
	60"		7" to 12"					7" to 12"	7" to 12"	7" to 12"	60"
	72"										72"
	84"										84"

Model	Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost		
RT660	24"									24"	
	26"									26"	
	36"									36"	
	40"									40"	
	45"									45"	
	48"		7" to 16"	7" to 16"	7" to 16"	7" to 12"		7" to 16"	7" to 16"	7" to 16"	48"
	60"		7" to 14"	7" to 14"	7" to 14"	7" to 12"		7" to 14"	7" to 14"	7" to 14"	60"
	72"		7" to 10"	7" to 10"	7" to 10"	7" to 10"		7" to 10"	7" to 10"	7" to 10"	72"
	84"										84"

Model	Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost		
RT960	24"									24"	
	26"									26"	
	36"									36"	
	40"									40"	
	45"									45"	
	48"		7" to 16"	7" to 16"	7" to 16"	7" to 12"		7" to 16"	7" to 16"	7" to 16"	48"
	60"		7" to 14"	7" to 14"	7" to 14"	7" to 12"		7" to 14"	7" to 14"	7" to 14"	60"
	72"		7" to 10"	7" to 10"	7" to 10"	7" to 10"		7" to 10"	7" to 10"	7" to 10"	72"
	84"		7", 8"	7", 8"	7", 8"	7", 8"		7", 8"	7", 8"	7", 8"	84"

Model	Cup Tooth 4 Pitch Spacing	Cup Tooth 2 Pitch Spacing	Bolt-on Shark/Cup Combo	Full Bolt-on Shark	Full Welded Shark	Xpandable Shark	Rock/Frost Mining Bit Combo	Rock/Frost Mining Bit Combo	H-Plate Welded Rock & Frost		
RT960	24"									24"	
	26"									26"	
	36"									36"	
	40"									40"	
	45"									45"	
	48"		8" to 16"					8" to 16"	8" to 16"	8" to 16"	48"
	60"		8" to 14"					8" to 14"	8" to 14"	8" to 14"	60"
	72"		8" to 10"					8" to 10"	8" to 10"	8" to 10"	72"
	84"		8"					8"	8"	8"	84"

NOTES

2

SECTION 2 - CHAIN IDENTIFICATION - DIGGING CHAIN SELECTION GUIDE

2

Competitor Chain/Tooth

Ditch Witch	18" boom	24" boom	30" boom	36" boom	42" boom	48" boom	60" boom
1030	n/a	26 stations	30 stations	33 stations	n/a	n/a	n/a
1230	n/a	26 stations	30 stations	33 stations	n/a	n/a	n/a
1330	n/a	26 stations	30 stations	33 stations	n/a	n/a	n/a
1820	n/a	26 stations	30 stations	33 stations	n/a	41 stations	n/a
410SX	n/a	26 stations	30 stations	33 stations	n/a	n/a	n/a
HT25	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
3500	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
3610	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
RT36	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
3700	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
RT40	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
5110	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
5110	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
RT55	n/a	n/a	n/a	n/a	n/a	42 stations	48 stations
RT55	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
5700	n/a	n/a	n/a	34 stations	n/a	42 stations	48 stations
5700	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
RT70	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
7020	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
7610	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
RT75	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
8020	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
RT95	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
RT95	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
RT115	n/a	n/a	n/a	n/a	n/a	31 stations	35 stations
<hr/>							
Vermeer	18" boom	24" boom	30" boom	36" boom	42" boom	48" boom	60" boom
1150	22 stations	26 stations	30 stations	34 stations	n/a	n/a	n/a
1350	22 stations	26 stations	30 stations	34 stations	n/a	n/a	n/a
2050	22 stations	26 stations	30 stations	34 stations	38 stations	n/a	n/a
RT100	22 stations	26 stations	30 stations	34 stations	n/a	n/a	n/a
RT200	22 stations	26 stations	30 stations	34 stations	38 stations	n/a	n/a
3550	n/a	n/a	n/a	33 stations	n/a	39 stations	45 stations
RT350	n/a	n/a	n/a	33 stations	n/a	39 stations	45 stations
4150	n/a	n/a	n/a	33 stations	n/a	39 stations	45 stations
RT450	n/a	n/a	n/a	33 stations	n/a	39 stations	45 stations
4150	n/a	n/a	n/a	26 stations	n/a	30 stations	34 stations
RT450	n/a	n/a	n/a	26 stations	n/a	30 stations	34 stations
5750	n/a	n/a	n/a	26 stations	n/a	30 stations	34 stations
RT650	n/a	n/a	n/a	26 stations	n/a	30 stations	34 stations
8550	n/a	n/a	n/a	n/a	n/a	30 stations	34 stations
RT850	n/a	n/a	n/a	n/a	n/a	30 stations	34 stations
8550	n/a	n/a	n/a	n/a	n/a	22 stations	26 stations

2

Competitor Chain/Tooth

Barreto	18" boom	24" boom	30" boom	36" boom	42" boom	48" boom	60" boom
1324	n/a	26 stations	30 stations	34 stations	n/a	n/a	n/a
1624	n/a	26 stations	30 stations	34 stations	38 stations	n/a	n/a
1636	n/a	26 stations	30 stations	34 stations	38 stations	n/a	n/a
Toro							
Toro	18" boom	24" boom	30" boom	36" boom	42" boom	48" boom	60" boom
Dingo	n/a	24 stations	n/a	32 stations	n/a	n/a	n/a
Bobcat							
Bobcat	18" boom	24" boom	30" boom	36" boom	42" boom	48" boom	60" boom
LT112	n/a	26 stations	n/a	n/a	n/a	n/a	n/a
LT113	n/a	n/a	n/a	33 stations	n/a	n/a	n/a
LT213	n/a	n/a	n/a	30 stations	n/a	n/a	n/a
LT313	n/a	n/a	n/a	30 stations	n/a	n/a	n/a
LT413	n/a	n/a	n/a	30 stations	n/a	n/a	n/a
Cat							
Cat	18" boom	24" boom	30" boom	36" boom	42" boom	48" boom	60" boom
T9	n/a	n/a	n/a	30 stations	n/a	36 stations	n/a

Selection by Machine

2

72" boom	84" boom	96" boom	Chain Size	Widths	2CT	4CT	RB	RC	SB	SC	SW	HP	XS
n/a	n/a	n/a	1.654	4-8	8	8	6	6	6	6	6	n/a	n/a
n/a	n/a	n/a	1.654	4-8	8	8	6	6	6	6	6	n/a	n/a
n/a	n/a	n/a	1.654	4-8	8	8	6	6	6	6	6	n/a	n/a
72" boom	84" boom	96" boom	Chain Size	Widths	2CT	4CT	RB	RC	SB	SC	SW	HP	XS
n/a	n/a	n/a	1.6540	4-8	8	8	6	6	6	6	6	n/a	n/a
72" boom	84" boom	96" boom	Chain Size	Widths	2CT	4CT	RB	RC	SB	SC	SW	HP	XS
n/a	n/a	n/a	1.654	4-8	8	8	6	6	6	6	6	n/a	n/a
n/a	n/a	n/a	1.654	4-8	8	6	6	6	6	6	6	n/a	n/a
n/a	n/a	n/a	2.000	6-12	12	12	8	8	8	8	8	n/a	n/a
n/a	n/a	n/a	2.000	6-12	12	12	8	8	8	8	8	n/a	n/a
n/a	n/a	n/a	2.000	6-12	12	12	8	8	8	8	8	n/a	n/a
72" boom	84" boom	96" boom	Chain Size	Widths	2CT	4CT	RB	RC	SB	SC	SW	HP	XS
n/a	n/a	n/a	2.000	6-12	12	12	12	8	8	8	8	8	n/a

2

Astec Trencher Chain And Sprockets Guidance Chart

Maxi-Sneaker	
Chain Pitch	1.65"
Split Drive Sprocket 10T	H404004
Idler Sprocket 10T	H33563
Boom End Sprocket 10T	H33563
24" Dig Depth	36 Stations
36" Dig Depth	44 Stations

RT60	
Chain Pitch	1.65"
Drive Sprocket 10T	H404004
Boom End Sprocket 10T	H33563
24" Dig Depth	26 Stations
24" Rock Boom (304181A1) *	28 Stations
24" Channel Boom (H939227) *	28 Stations
30" Dig Depth (S/N < RT060X50317)	31 Stations
36" Dig Depth	36 Stations

RT160	
Chain Pitch	1.65"
Drive Sprocket 10T	H69773
24" Dig Depth	28 Stations
30" Dig Depth	31 Stations
36" Dig Depth	36 Stations
42" Dig Depth	40 Stations

RT460 Direct Drive	
Chain Pitch	2.64"
Split Drive Sprocket 14T	122432A1
Idler Sprocket (Early) 9T	113117A1
Idler Sprocket (Late) 9T	139794A1
Boom End Sprocket (Early) 13T	113118A1
Boom End Sprocket (Late) 13T	139796A1
48" Dig Depth	29 Stations
60" Dig Depth	34 Stations

RT560 Direct Drive	
Chain Pitch	2.64"
Split Drive Sprocket 14T	122432A1
Idler Sprocket (Early) 9T	113117A1
Idler Sprocket (Late) 9T	139794A1
Boom End Sprocket (Early) 13T	113118A1
Boom End Sprocket (Late) 13T	139796A1
48" Dig Depth	29 Stations
60" Dig Depth	34 Stations

TF300	
Chain Pitch	1.65"
Split Drive Sprocket 10T	H69773
Auger Sprocket (Flush Dig) 11T	H68494
Idler Sprocket 10T	H33563
Boom End Sprocket 10T	H33563
26" Dig Depth	28 Stations
40" Dig Depth	38 Stations
45" Dig Depth	42 Stations

RT130	
Chain Pitch	1.65"
Drive Sprocket 10T	H69773
24" Dig Depth	28 Stations
30" Dig Depth	31 Stations
36" Dig Depth	36 Stations

RT360	
Chain Pitch	2.64"
Split Drive Sprocket 9T	H148569
Idler Sprocket 7T	H115683
36" Dig Depth	24 Stations
48" Dig Depth	29 Stations
60" Dig Depth	34 Stations

RT460 Planetary Drive (Heavy Duty)	
Chain Pitch	2.64"
Split Drive Sprocket 15T	104152A1
Auger Sprocket 14T	126170A1
Idler Sprocket (Early) 9T	113117A1
Idler Sprocket (Late) 9T	139794A1
Boom End Sprocket (Early) 13T	113118A1
Boom End Sprocket (Late) 13T	139796A1
48" Dig Depth	35 Stations
60" Dig Depth	40 Stations

RT560 Planetary Drive (Heavy Duty)	
Chain Pitch	2.64"
Split Drive Sprocket 15T	104152A1
Auger Sprocket 14T	126170A1
Idler Sprocket (Early) 9T	113117A1
Idler Sprocket (Late) 9T	139794A1
Boom End Sprocket (Early) 13T	113118A1
Boom End Sprocket (Late) 13T	139796A1
48" Dig Depth	35 Stations
60" Dig Depth	40 Stations

*** No Longer A Factory Installed Option**

Astec Trencher Chain And Sprockets Guidance Chart

RT660 Quad	
Chain Pitch	2.64"
Split Drive Sprocket 15T	104152A1
Auger Sprocket 14T	126170A1
Idler Sprocket (Early) 9T	113117A1
Idler Sprocket (Late) 9T	139794A1
Boom End Sprocket (Early) 13T	113118A1
Boom End Sprocket (Late) 13T	139796A1
48" Dig Depth	35 Stations
60" Dig Depth	40 Stations

RT660	
Chain Pitch	3.03"
Split Drive Sprocket 14T	186255A1
Auger Sprocket 12T	186252A1
Idler Sprocket 9T	186265A1
Boom End Sprocket 15T	199342A1
48" Dig Depth	34 Stations
60" Dig Depth	38 Stations
72" Dig Depth	42 Stations

RT960	
Chain Pitch	3.03"
Split Drive Sprocket 14T	186255A1
Auger Sprocket 12T	186252A1
Idler Sprocket 9T	186265A1
Boom End Sprocket 15T	199342A1
48" Dig Depth	34 Stations
60" Dig Depth	38 Stations
72" Dig Depth	42 Stations
84" Dig Depth	46 Stations

RT960	
Chain Pitch	4.08"
Split Drive Sprocket 11T	186276A1
Auger Sprocket 9T	186277A1
Idler Sprocket 7T	199346A1
Boom End Sprocket 11T	199343A1
48" Dig Depth	25 Stations
60" Dig Depth	28 Stations
72" Dig Depth	31 Stations
84" Dig Depth	34 Stations

Obsolete Factory Installed Chain And Sprocket Options

RT560 And RT660	
Chain Pitch *	3.07"
Split Drive Sprocket 12T *	186249A1
Auger Sprocket 11T *	186247A1
Idler Sprocket 8T *	H433989
Boom End Sprocket 15T *	199342A1

RT660	
Chain Pitch *	2.64"
Split Drive Sprocket 15T *	104152A1
Auger Sprocket 14T *	126170A1

Case Heritage Chain And Sprocket Information

DH4 And DH5	
Chain Pitch *	3.07"
Split Drive Sprocket 10T *	H427468
Auger Sprocket 8T *	H375881

760	
Chain Pitch *	3.25"
Split Drive Sprocket (1/2" Bolts) 13T *	H433264
Split Drive Sprocket (7/16" Bolts) 13T *	H438347
Idler Sprocket 8T *	H433989
48" Boom *	31 Stations
60" Boom *	35 Stations
72" Boom *	39 Stations
84" Boom *	43 Stations

DH4 And DH5	
Chain Pitch *	2.60"
Split Drive Sprocket 9T *	H427450
Auger Sprocket 8T *	H375899

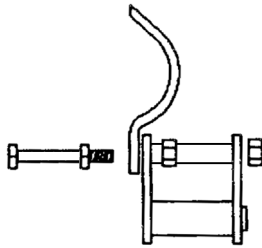
* No Longer A Factory Installed Option

NOTES

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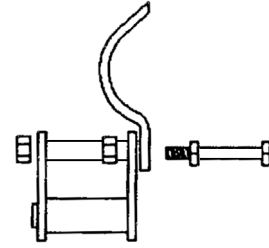
CUP CUTTER TEETH

LCT



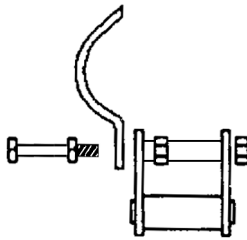
LEFT CENTER CUP TOOTH

RCT



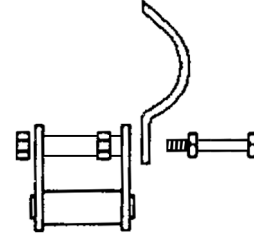
RIGHT CENTER CUP TOOTH

LOT



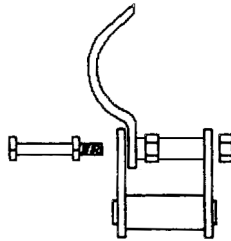
LEFT OUTER CUP TOOTH

ROT



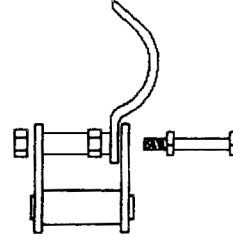
RIGHT OUTER CUP TOOTH

LIT



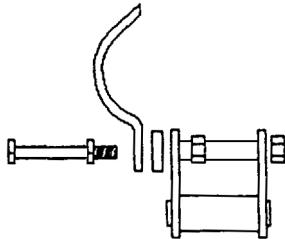
LEFT INNER CUP TOOTH

RIT



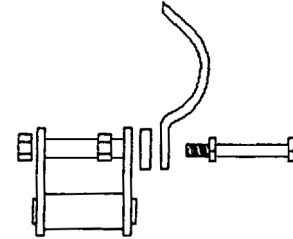
RIGHT INNER CUP TOOTH

**L5T
L6T
L8T**



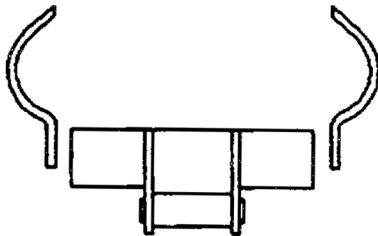
LEFT OUTER CUP TOOTH (5", 6", OR 8")

**R5T
R6T
R8T**



RIGHT OUTER CUP TOOTH (5", 6", OR 8")

**L8TR
L10TR
L12TR
L14TR
L16TR**



LEFT AND RIGHT OUTER CUP TEETH
(8", 10", 12", 14", OR 16")

NOTE: Tube spacers and longer bolts are used in leading holes when using 1.65" pitch chain. This substantially strengthens the chain.

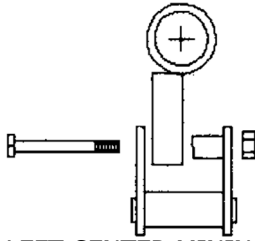
3

L8TR

ROCK AND FROST MINING TEETH

3

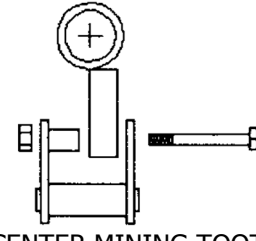
LCR



LEFT CENTER MINING TOOTH

LCR

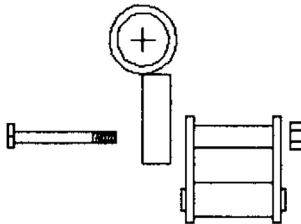
RCR



RIGHT CENTER MINING TOOTH

RCR

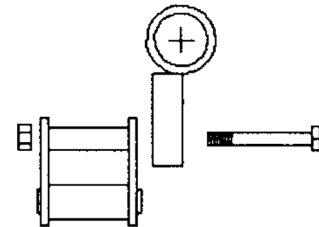
LOR



LEFT OUTER MINING TOOTH

LOR

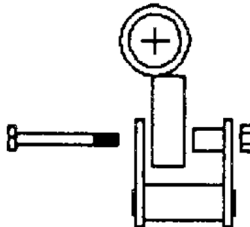
ROR



RIGHT OUTER MINING TOOTH

ROR

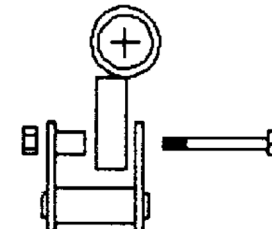
LIR



LEFT INNER MINING TOOTH

LIR

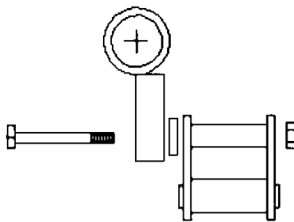
RIR



RIGHT INNER MINING TOOTH

RIR

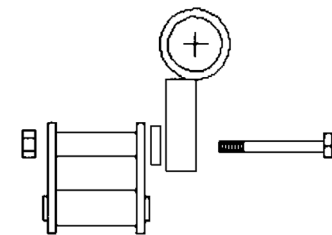
L6R
L7R
L8R



LEFT OUTER MINING TOOTH (6", 7" OR 8")

L6R

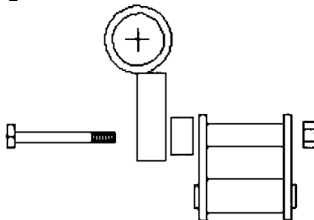
R6R
R7R
R8R



RIGHT OUTER MINING TOOTH (6", 7" OR 8")

R6R

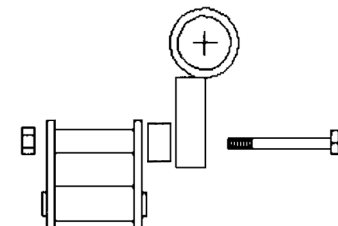
L8R



LEFT OUTER MINING TOOTH (8" 3.03 PITCH CHAIN)

L8R

R8R

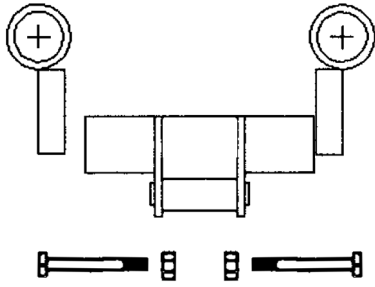


RIGHT OUTER MINING TOOTH (8" 3.03 PITCH CHAIN)

R8R

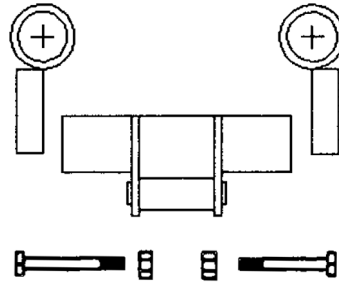
ROCK AND FROST MINING TEETH

**L8RR
L10RR
L12RR
L14RR
L16RR**



LEFT AND RIGHT OUTER MINING TEETH
(8", 10", 12", 14" OR 16")

RL8RR

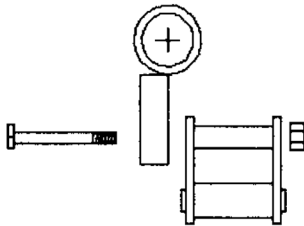


REVERSED LEFT AND RIGHT OUTER MINING TEETH

L8RR

RL8RR

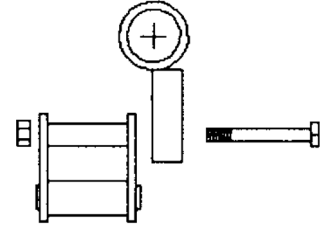
RLOR



REVERSED LEFT OUTER MINING TOOTH

RLOR

RROR



REVERSED RIGHT OUTER MINING TOOTH

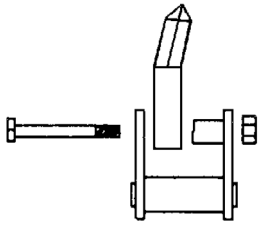
RROR

3

3

SHARK BIT TEETH

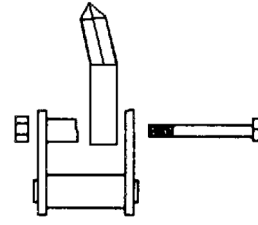
LCS



LEFT CENTER SHARK TOOTH

LCS

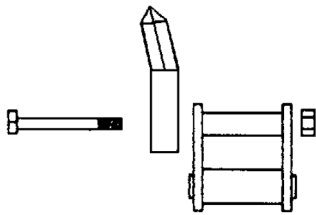
RCS



RIGHT CENTER SHARK TOOTH

RCS

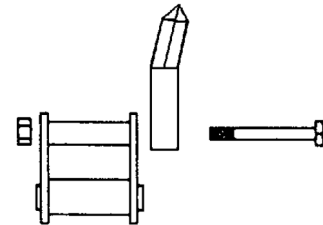
LOS



LEFT OUTER SHARK TOOTH

LOS

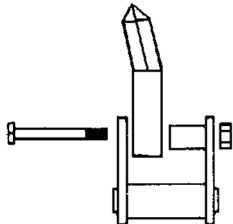
ROS



RIGHT OUTER SHARK TOOTH

ROS

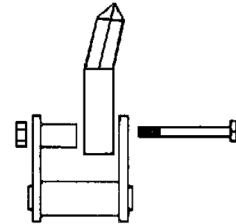
LIS



LEFT INNER SHARK TOOTH

LIS

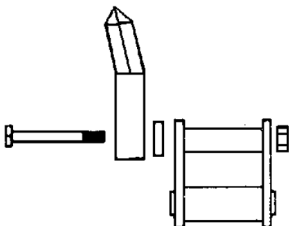
RIS



RIGHT INNER SHARK TOOTH

RIS

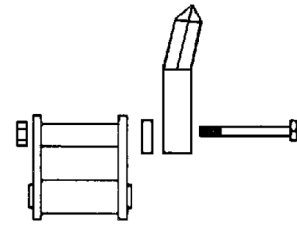
L6S



LEFT OUTER SHARK TOOTH (6")

L6S

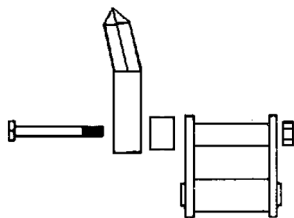
R6S



RIGHT OUTER SHARK TOOTH (6")

R6S

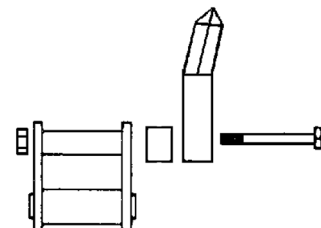
L8S



LEFT OUTER SHARK TOOTH (8" 3.03 PITCH CHAIN)

L8S

R8S

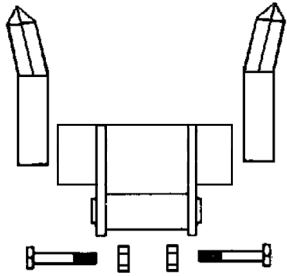


RIGHT OUTER SHARK TOOTH (8" 3.03 PITCH CHAIN)

R8S

SHARK BIT TEETH

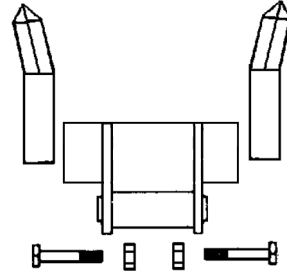
L8SR



LEFT AND RIGHT OUTER SHARK TEETH (8")

L8SR

L10SR



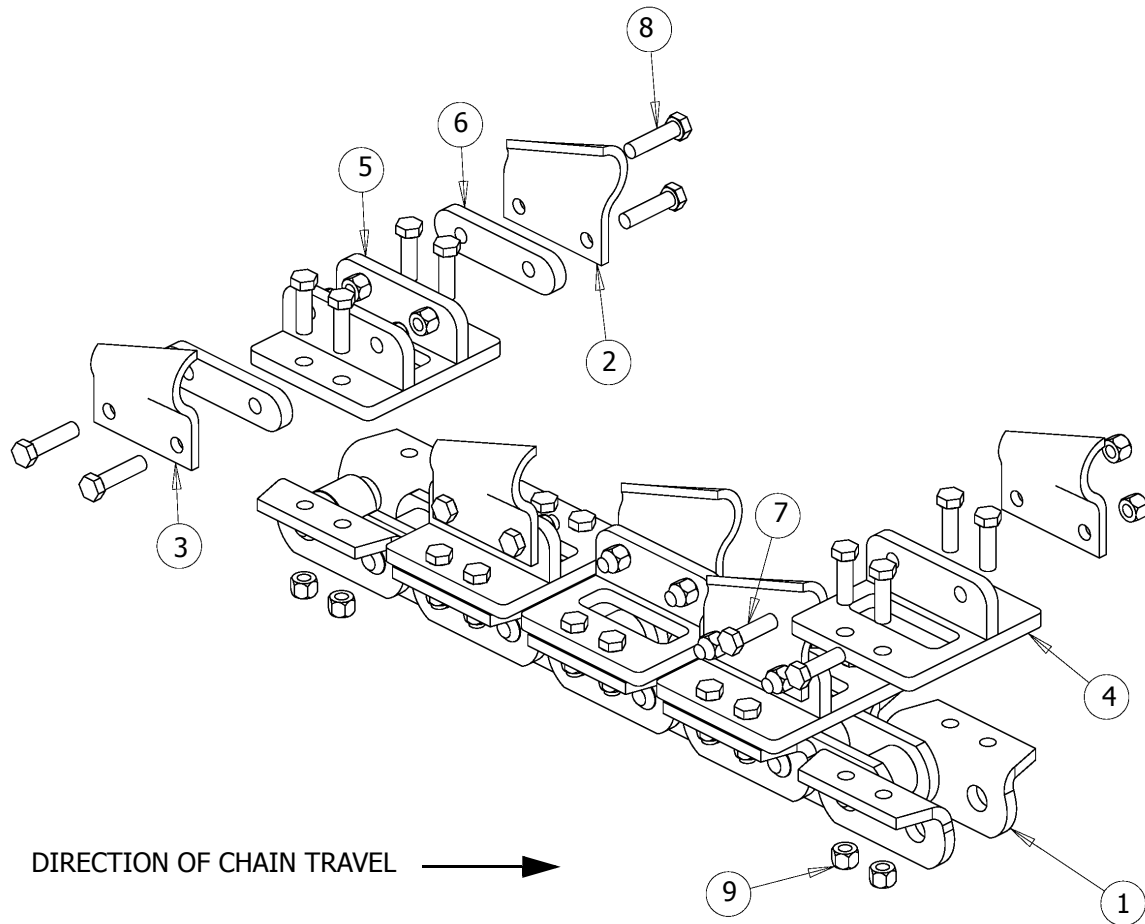
LEFT AND RIGHT OUTER SHARK TEETH (10")

L10SR

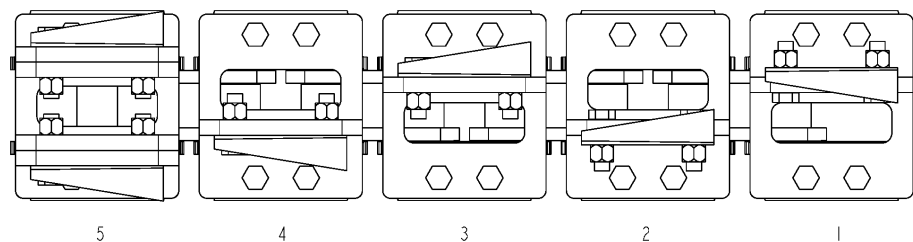
3

AU4512CT10xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40	43	46	53
				QTY	QTY	QTY	QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10TR	2	24	26	27	32
CC450R	Right Hand Cup Cutter	LCT, ROT, L10TR	3	24	25	28	31
AU103675	Cutter Bar Base	LCT, RCT, LOT, ROT	4	32	35	37	43
AU103676	Cutter Bar Base 10"	L10TR	5	8	8	9	10
AU103712	Spacer	L10TR	6	16	16	18	20
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	7	224	242	258	298
426-1248	Capscrew, 3/4" x3"	All Cup Cutter Tooth Holes	8	32	32	36	40
231-41412	Locknut, 3/4"	All Holes	9	256	274	294	338



11




AU4512CT10xx

10" CHAIN PATTERNS

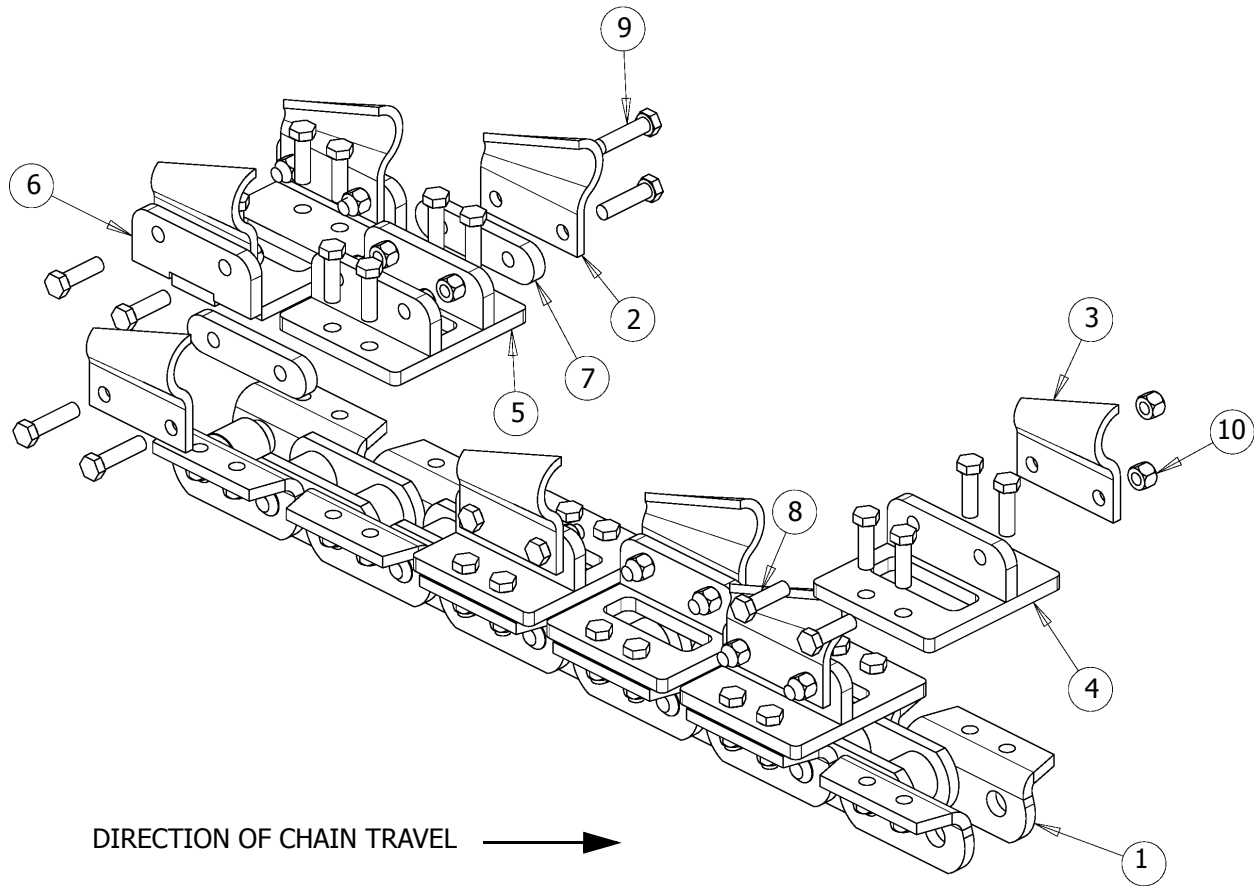
AU4512CT1040	AU4512CT1043	AU4512CT1046	AU4512CT1053	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	LCT	1
RCT	RCT	RCT	RCT	2
LOT	LOT	LOT	LOT	3
ROT	ROT	ROT	ROT	4
L10RT	L10RT	L10RT	L10RT	5
LCT	LCT	LCT	LCT	6
RCT	RCT	RCT	RCT	7
LOT	LOT	LOT	LOT	8
ROT	ROT	ROT	ROT	9
L10RT	L10RT	L10RT	L10RT	10
LCT	LCT	LCT	LCT	11
RCT	RCT	RCT	RCT	12
LOT	LOT	LOT	LOT	13
ROT	ROT	ROT	ROT	14
L10RT	L10RT	L10RT	L10RT	15
LCT	LCT	LCT	LCT	16
RCT	RCT	RCT	RCT	17
LOT	LOT	LOT	LOT	18
ROT	ROT	ROT	ROT	19
L10RT	L10RT	L10RT	L10RT	20
LCT	LCT	LCT	LCT	21
RCT	RCT	RCT	RCT	22
LOT	LOT	LOT	LOT	23
ROT	ROT	ROT	ROT	24
L10RT	L10RT	L10RT	L10RT	25
LCT	LCT	LCT	LCT	26
RCT	RCT	RCT	RCT	27
LOT	LOT	LOT	LOT	28
ROT	ROT	ROT	ROT	29
L10RT	L10RT	L10RT	L10RT	30
LCT	LCT	LCT	LCT	31
RCT	RCT	RCT	RCT	32
LOT	LOT	LOT	LOT	33
ROT	ROT	ROT	ROT	34
L10RT	L10RT	L10RT	L10RT	35
LCT	LCT	LCT	LCT	36
RCT	RCT	RCT	RCT	37
LOT	LOT	LOT	LOT	38
ROT	ROT	ROT	ROT	39
L10RT	L10RT	L10RT	L10RT	40
LCT	LCT	LCT	LCT	41
RCT	RCT	RCT	RCT	42
LOT	LOT	LOT	LOT	43
ROT	ROT	ROT	ROT	44
L10RT	L10RT	L10RT	L10RT	45
LCT	LCT	LCT	LCT	46
RCT	RCT	RCT	RCT	47
LOT	LOT	LOT	LOT	48
ROT	ROT	ROT	ROT	49
L10RT	L10RT	L10RT	L10RT	50
LCT	LCT	LCT	LCT	51
RCT	RCT	RCT	RCT	52
LOT	LOT	LOT	LOT	53

DIRECTION OF CHAIN TRAVEL

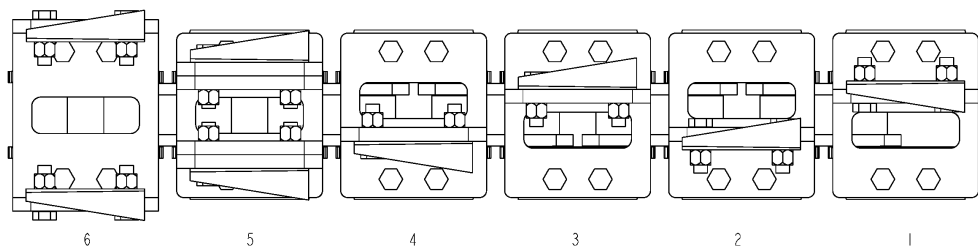


AU4512CT12xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40	43	46	53
			QTY	QTY	QTY	QTY	
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10TR, L12TR	2	26	28	30	35
CC450R	Right Hand Cup Cutter	LCT, ROT, L10TR, L12TR	3	26	29	30	35
AU103675	Cutter Bar Base	LCT, RCT, LOT, ROT	4	28	29	32	36
AU103676	Cutter Bar Base 10"	L10TR	5	6	7	7	9
AU103677	Cutter Bar Base 12"	L12TR	6	6	7	7	8
AU103712	Spacer	L10TR	7	12	14	14	18
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	8	240	258	276	316
426-1248	Capscrew, 3/4" x3"	All Cup Cutter Tooth Holes	9	24	28	28	36
231-41412	Locknut, 3/4"	All Holes	10	264	286	304	352



11




AU4512CT12xx

12" CHAIN PATTERNS

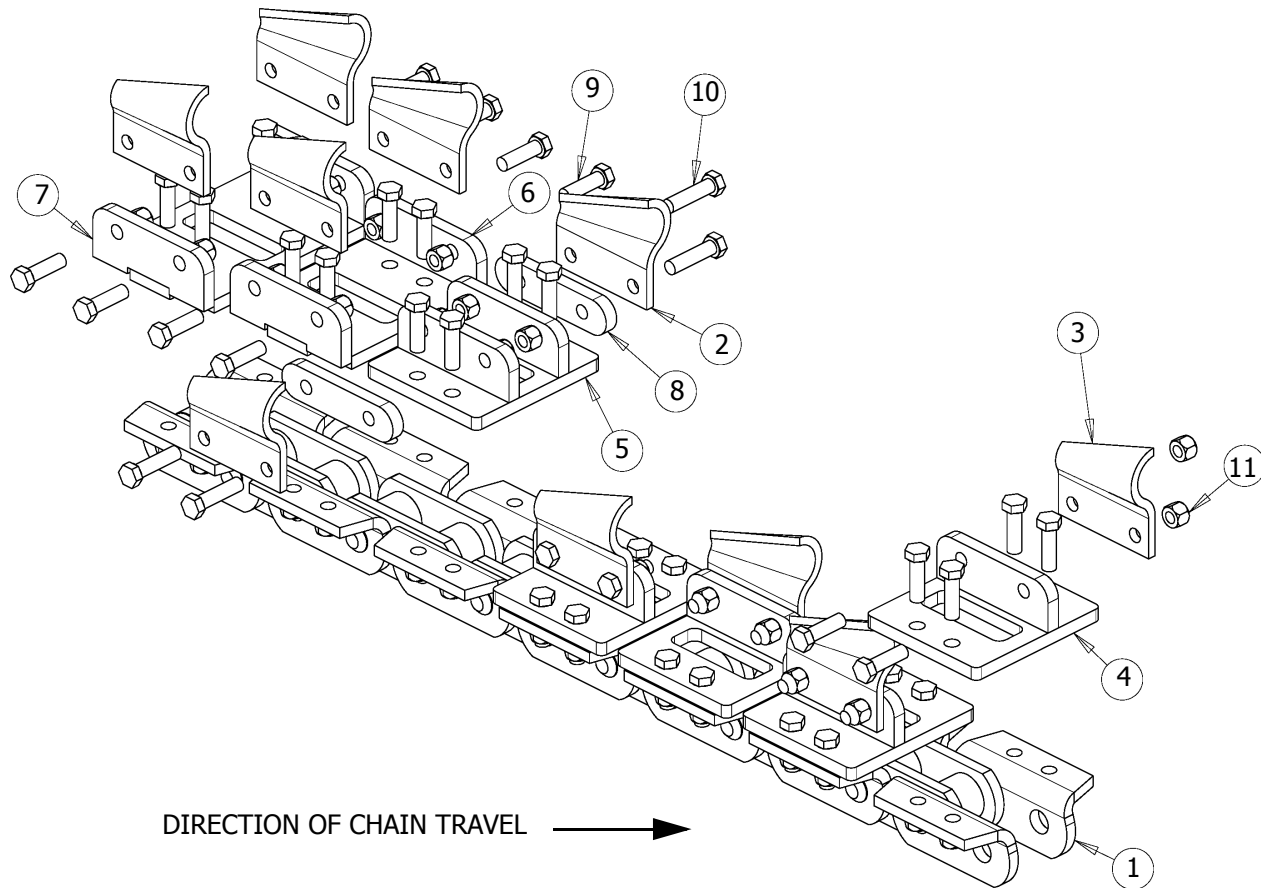
AU4512CT1240	AU4512CT1243	AU4512CT1246	AU4512CT1253	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	LCT	1
RCT	RCT	RCT	RCT	2
LOT	LOT	LOT	LOT	3
ROT	ROT	ROT	ROT	4
L10RT	L10RT	L10RT	L10RT	5
L12RT	L12RT	L12RT	L12RT	6
LCT	LCT	LCT	LCT	7
RCT	RCT	RCT	RCT	8
LOT	LOT	LOT	LOT	9
ROT	ROT	ROT	ROT	10
L10RT	L10RT	L10RT	L10RT	11
L12RT	L12RT	L12RT	L12RT	12
LCT	LCT	LCT	LCT	13
RCT	RCT	RCT	RCT	14
LOT	LOT	LOT	LOT	15
ROT	ROT	ROT	ROT	16
L10RT	L10RT	L10RT	L10RT	17
L12RT	L12RT	L12RT	L12RT	18
LCT	LCT	LCT	LCT	19
RCT	RCT	RCT	RCT	20
LOT	LOT	LOT	LOT	21
ROT	ROT	ROT	ROT	22
L10RT	L10RT	L10RT	L10RT	23
L12RT	L12RT	L12RT	L12RT	24
LCT	LCT	LCT	LCT	25
RCT	RCT	RCT	RCT	26
LOT	LOT	LOT	LOT	27
ROT	ROT	ROT	ROT	28
L10RT	L10RT	L10RT	L10RT	29
L12RT	L12RT	L12RT	L12RT	30
LCT	LCT	LCT	LCT	31
RCT	RCT	RCT	RCT	32
LOT	LOT	LOT	LOT	33
ROT	ROT	ROT	ROT	34
L10RT	L10RT	L10RT	L10RT	35
L12RT	L12RT	L12RT	L12RT	36
LCT	LCT	LCT	LCT	37
RCT	RCT	RCT	RCT	38
LOT	LOT	LOT	LOT	39
ROT	ROT	ROT	ROT	40
L10RT	L10RT	L10RT	L10RT	41
L12RT	L12RT	L12RT	L12RT	42
LCT	LCT	LCT	LCT	43
RCT	RCT	RCT	RCT	44
LOT	LOT	LOT	LOT	45
ROT	ROT	ROT	ROT	46
L10RT	L10RT	L10RT	L10RT	47
L12RT	L12RT	L12RT	L12RT	48
LCT	LCT	LCT	LCT	49
RCT	RCT	RCT	RCT	50
LOT	LOT	LOT	LOT	51
ROT	ROT	ROT	ROT	52
L10RT	L10RT	L10RT	L10RT	53

DIRECTION OF CHAIN TRAVEL

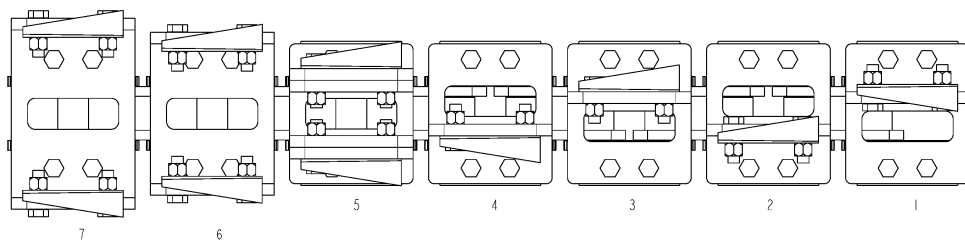


AU4512CT14xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40	43	46	53
				QTY	QTY	QTY	QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10TR, L12TR, L14TR	2	28	30	32	37
CC450R	Right Hand Cup Cutter	LCT, ROT, L10TR, L12TR, L14TR	3	28	31	32	37
AU103675	Cutter Bar Base	LCT, RCT, LOT, ROT	4	24	25	28	32
AU103676	Cutter Bar Base 10"	L10TR	5	6	6	6	7
AU103677	Cutter Bar Base 12"	L12TR	6	5	6	6	7
AU103678	Cutter Bar Base 14"	L14TR	7	5	6	6	7
AU103712	Spacer	L10TR	8	12	12	12	14
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	9	248	270	288	332
426-1248	Capscrew, 3/4" x3"	All Cup Cutter Tooth Holes	10	24	24	24	28
231-41412	Locknut, 3/4"	All Holes	11	272	294	312	360



11




AU4512CT14xx

14" CHAIN PATTERNS

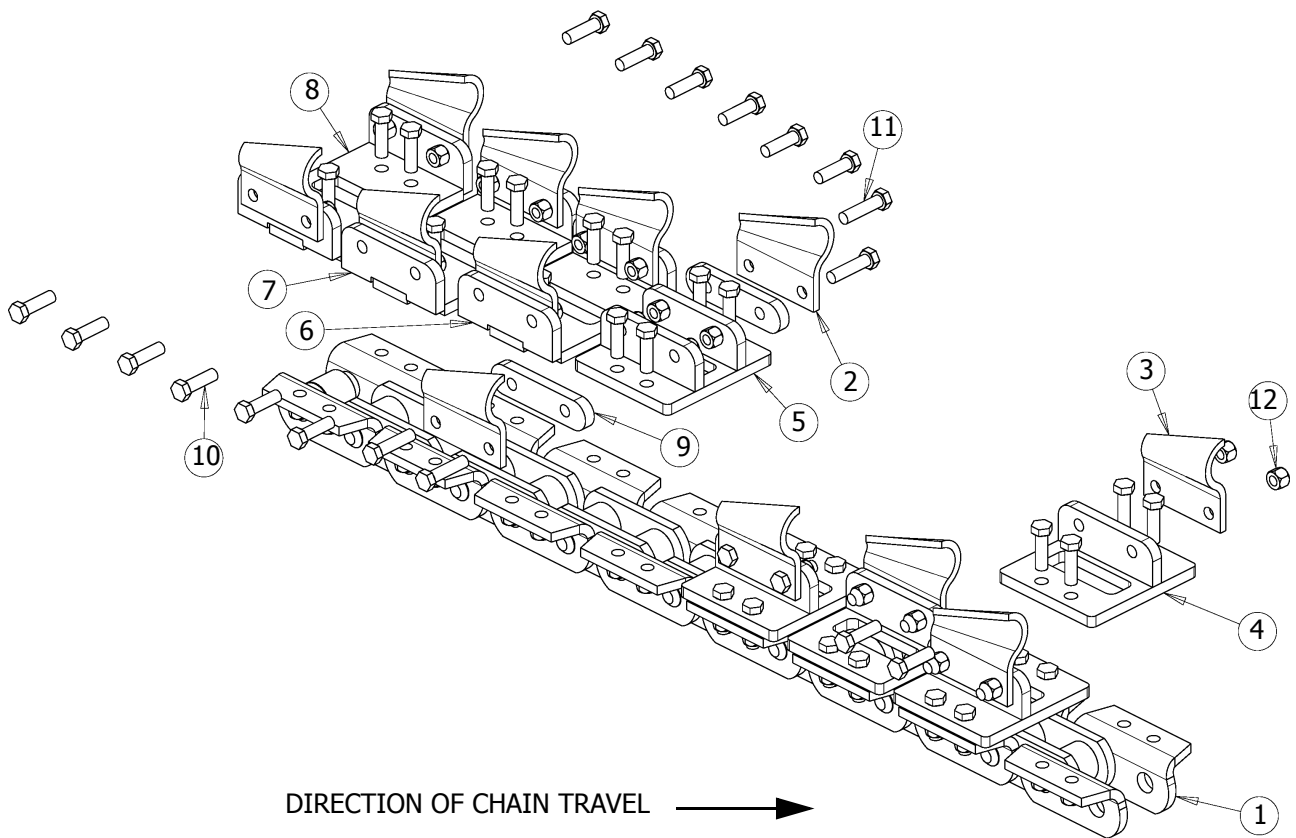
AU4512CT1440	AU4512CT1443	AU4512CT1446	AU4512CT1453	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	LCT	1
RCT	RCT	RCT	RCT	2
LOT	LOT	LOT	LOT	3
ROT	ROT	ROT	ROT	4
L10RT	L10RT	L10RT	L10RT	5
L12RT	L12RT	L12RT	L12RT	6
L14RT	L14RT	L14RT	L14RT	7
LCT	LCT	LCT	LCT	8
RCT	RCT	RCT	RCT	9
LOT	LOT	LOT	LOT	10
ROT	ROT	ROT	ROT	11
L10RT	L10RT	L10RT	L10RT	12
L12RT	L12RT	L12RT	L12RT	13
L14RT	L14RT	L14RT	L14RT	14
LCT	LCT	LCT	LCT	15
RCT	RCT	RCT	RCT	16
LOT	LOT	LOT	LOT	17
ROT	ROT	ROT	ROT	18
L10RT	L10RT	L10RT	L10RT	19
L12RT	L12RT	L12RT	L12RT	20
L14RT	L14RT	L14RT	L14RT	21
LCT	LCT	LCT	LCT	22
RCT	RCT	RCT	RCT	23
LOT	LOT	LOT	LOT	24
ROT	ROT	ROT	ROT	25
L10RT	L10RT	L10RT	L10RT	26
L12RT	L12RT	L12RT	L12RT	27
L14RT	L14RT	L14RT	L14RT	28
LCT	LCT	LCT	LCT	29
RCT	RCT	RCT	RCT	30
LOT	LOT	LOT	LOT	31
ROT	ROT	ROT	ROT	32
L10RT	L10RT	L10RT	L10RT	33
L12RT	L12RT	L12RT	L12RT	34
L14RT	L14RT	L14RT	L14RT	35
LCT	LCT	LCT	LCT	36
RCT	RCT	RCT	RCT	37
LOT	LOT	LOT	LOT	38
ROT	ROT	ROT	ROT	39
L10RT	L10RT	L10RT	L10RT	40
L12RT	L12RT	L12RT	L12RT	41
L14RT	L14RT	L14RT	L14RT	42
LCT	LCT	LCT	LCT	43
RCT	RCT	RCT	RCT	44
LOT	LOT	LOT	LOT	45
ROT	ROT	ROT	ROT	46
L10RT	L10RT	L10RT	L10RT	47
L12RT	L12RT	L12RT	L12RT	48
L14RT	L14RT	L14RT	L14RT	49
LCT	LCT	LCT	LCT	50
RCT	RCT	RCT	RCT	51
LOT	LOT	LOT	LOT	52
ROT	ROT	ROT	ROT	53

DIRECTION OF CHAIN TRAVEL

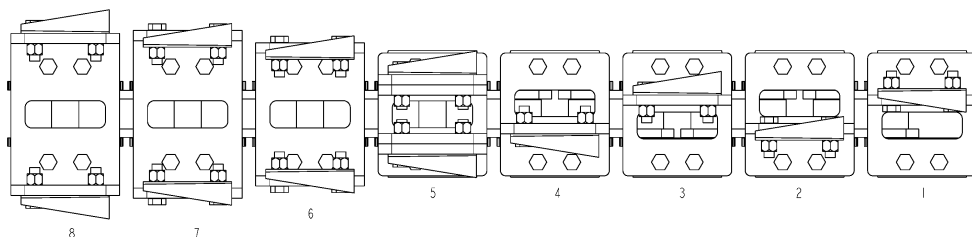


AU4512CT16xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10TR, L12TR, L14TR, L16TR	2	30	32	34	39
CC450R	Right Hand Cup Cutter	LCT, ROT, L10TR, L12TR, L14TR, L16TR	3	30	31	34	39
AU103675	Cutter Bar Base	LCT, RCT, LOT, ROT	4	20	23	24	28
AU103676	Cutter Bar Base 10"	L10TR	5	5	5	6	7
AU103677	Cutter Bar Base 12"	L12TR	6	5	5	6	6
AU103678	Cutter Bar Base 14"	L14TR	7	5	5	5	6
AU103679	Cutter Bar Base 16"	L16TR	8	5	5	5	6
AU103712	Spacer	L10TR	9	10	10	12	14
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	10	160	278	296	340
426-1248	Capscrew, 3/4" x3"	All Cup Cutter Tooth Holes	11	20	20	24	28
231-41412	Locknut, 3/4"	All Holes	12	280	298	320	368



11




AU4512CT16xx

16" CHAIN PATTERNS

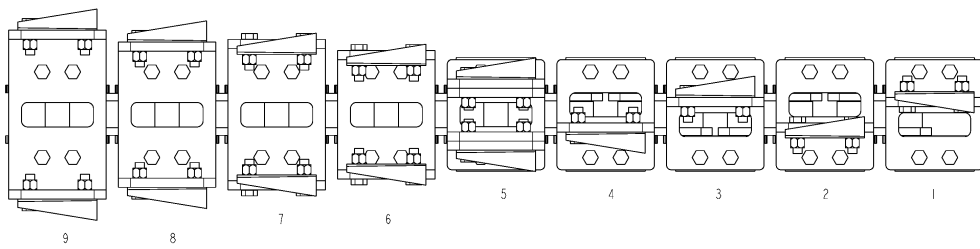
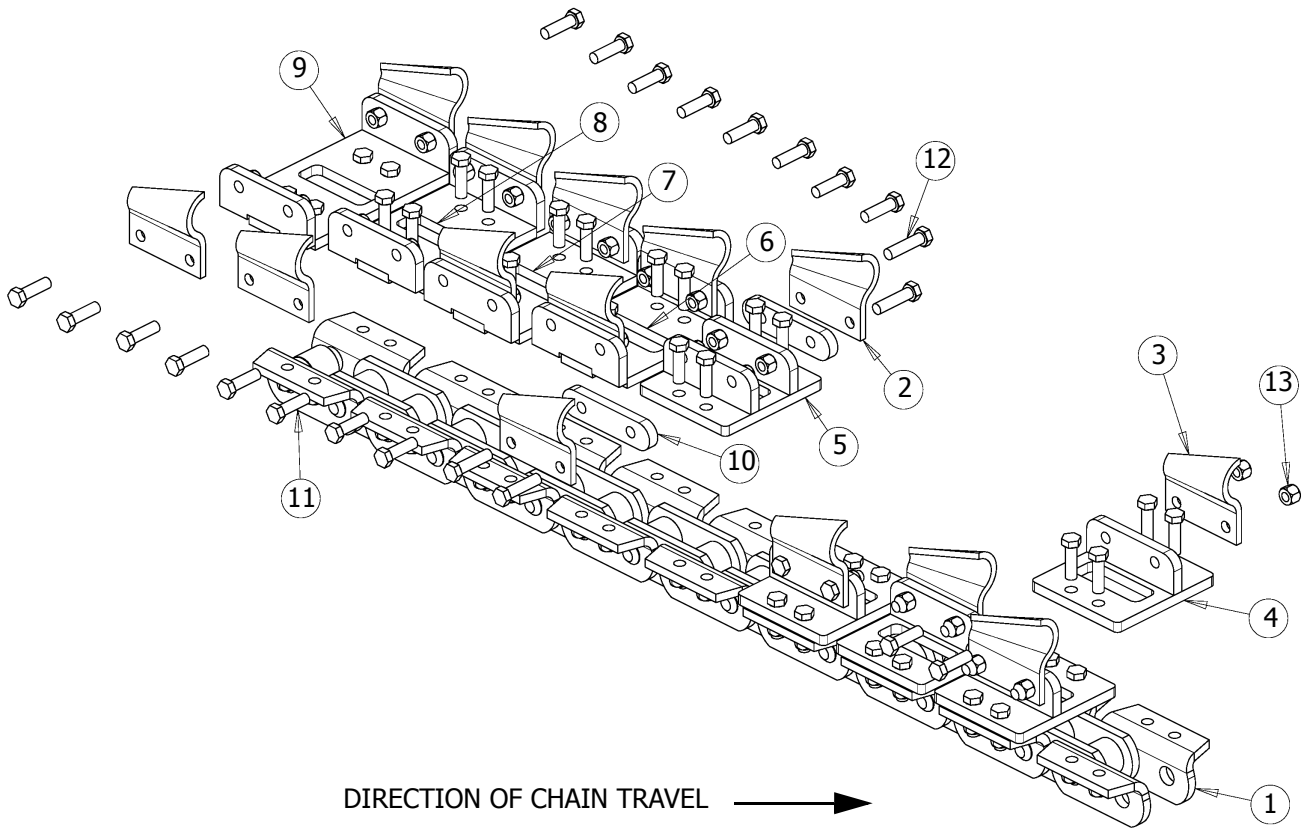
AU4512CT1640	AU4512CT1643	AU4512CT1646	AU4512CT1653	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	LCT	1
RCT	RCT	RCT	RCT	2
LOT	LOT	LOT	LOT	3
ROT	ROT	ROT	ROT	4
L10RT	L10RT	L10RT	L10RT	5
L12RT	L12RT	L12RT	L12RT	6
L14RT	L14RT	L14RT	L14RT	7
L16RT	L16RT	L16RT	L16RT	8
LCT	LCT	LCT	LCT	9
RCT	RCT	RCT	RCT	10
LOT	LOT	LOT	LOT	11
ROT	ROT	ROT	ROT	12
L10RT	L10RT	L10RT	L10RT	13
L12RT	L12RT	L12RT	L12RT	14
L14RT	L14RT	L14RT	L14RT	15
L16RT	L16RT	L16RT	L16RT	16
LCT	LCT	LCT	LCT	17
RCT	RCT	RCT	RCT	18
LOT	LOT	LOT	LOT	19
ROT	ROT	ROT	ROT	20
L10RT	L10RT	L10RT	L10RT	21
L12RT	L12RT	L12RT	L12RT	22
L14RT	L14RT	L14RT	L14RT	23
L16RT	L16RT	L16RT	L16RT	24
LCT	LCT	LCT	LCT	25
RCT	RCT	RCT	RCT	26
LOT	LOT	LOT	LOT	27
ROT	ROT	ROT	ROT	28
L10RT	L10RT	L10RT	L10RT	29
L12RT	L12RT	L12RT	L12RT	30
L14RT	L14RT	L14RT	L14RT	31
L16RT	L16RT	L16RT	L16RT	32
LCT	LCT	LCT	LCT	33
RCT	RCT	RCT	RCT	34
LOT	LOT	LOT	LOT	35
ROT	ROT	ROT	ROT	36
L10RT	L10RT	L10RT	L10RT	37
L12RT	L12RT	L12RT	L12RT	38
L14RT	L14RT	L14RT	L14RT	39
L16RT	L16RT	L16RT	L16RT	40
LCT	LCT	LCT	LCT	41
RCT	RCT	RCT	RCT	42
LOT	LOT	LOT	LOT	43
ROT	ROT	ROT	ROT	44
L10RT	L10RT	L10RT	L10RT	45
L12RT	L12RT	L12RT	L12RT	46
L14RT	L14RT	L14RT	L14RT	47
L16RT	L16RT	L16RT	L16RT	48
LCT	LCT	LCT	LCT	49
RCT	RCT	RCT	RCT	50
LOT	LOT	LOT	LOT	51
ROT	ROT	ROT	ROT	52
L10RT	L10RT	L10RT	L10RT	53

DIRECTION OF CHAIN TRAVEL



AU4512CT18xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40	43	46	53
				QTY	QTY	QTY	QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10TR, L12TR, L14TR, L16TR, L18TR	2	30	33	35	41
CC450R	Right Hand Cup Cutter	LCT, ROT, L10TR, L12TR, L14TR, L16TR, L18TR	3	30	33	36	41
AU103675	Cutter Bar Base	LCT, RCT, LOT, ROT	4	20	20	21	24
AU103676	Cutter Bar Base 10"	L10TR	5	4	5	5	6
AU103677	Cutter Bar Base 12"	L12TR	6	4	5	5	6
AU103678	Cutter Bar Base 14"	L14TR	7	4	5	5	6
AU103679	Cutter Bar Base 16"	L16TR	8	4	4	5	6
AU103680	Cutter Bar Base 18"	L18TR	9	4	4	5	5
AU103712	Spacer	L10TR	10	8	10	10	12
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	11	264	284	306	352
426-1248	Capscrew, 3/4" x3"	All Cup Cutter Tooth Holes	12	16	20	20	24
231-41412	Locknut, 3/4"	All Holes	13	280	304	326	376




11

AU4512CT18xx

18" CHAIN PATTERNS

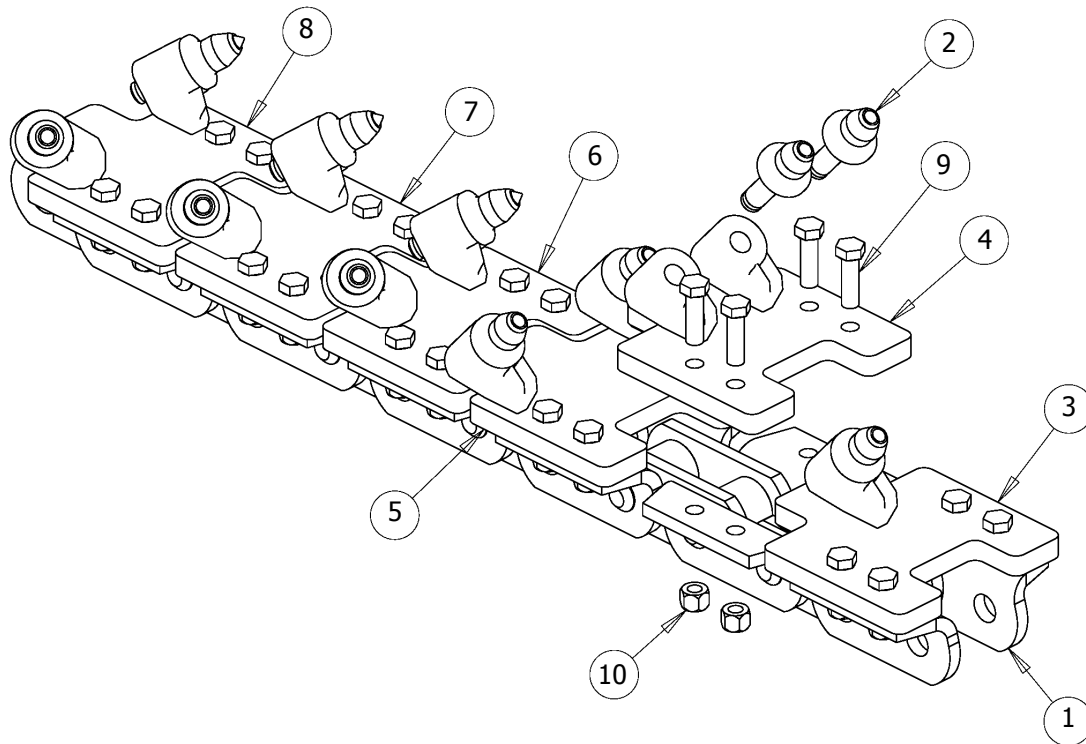
AU4512CT1840	AU4512CT1843	AU4512CT1846	AU4512CT1853	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	LCT	1
RCT	RCT	RCT	RCT	2
LOT	LOT	LOT	LOT	3
ROT	ROT	ROT	ROT	4
L10RT	L10RT	L10RT	L10RT	5
L12RT	L12RT	L12RT	L12RT	6
L14RT	L14RT	L14RT	L14RT	7
L16RT	L16RT	L16RT	L16RT	8
L18RT	L18RT	L18RT	L18RT	9
LCT	LCT	LCT	LCT	10
RCT	RCT	RCT	RCT	11
LOT	LOT	LOT	LOT	12
ROT	ROT	ROT	ROT	13
L10RT	L10RT	L10RT	L10RT	14
L12RT	L12RT	L12RT	L12RT	15
L14RT	L14RT	L14RT	L14RT	16
L16RT	L16RT	L16RT	L16RT	17
L18RT	L18RT	L18RT	L18RT	18
LCT	LCT	LCT	LCT	19
RCT	RCT	RCT	RCT	20
LOT	LOT	LOT	LOT	21
ROT	ROT	ROT	ROT	22
L10RT	L10RT	L10RT	L10RT	23
L12RT	L12RT	L12RT	L12RT	24
L14RT	L14RT	L14RT	L14RT	25
L16RT	L16RT	L16RT	L16RT	26
L18RT	L18RT	L18RT	L18RT	27
LCT	LCT	LCT	LCT	28
RCT	RCT	RCT	RCT	29
LOT	LOT	LOT	LOT	30
ROT	ROT	ROT	ROT	31
L10RT	L10RT	L10RT	L10RT	32
L12RT	L12RT	L12RT	L12RT	33
L14RT	L14RT	L14RT	L14RT	34
L16RT	L16RT	L16RT	L16RT	35
L18RT	L18RT	L18RT	L18RT	36
LCT	LCT	LCT	LCT	37
RCT	RCT	RCT	RCT	38
LOT	LOT	LOT	LOT	39
ROT	ROT	ROT	ROT	40
L10RT	L10RT	L10RT	L10RT	41
L12RT	L12RT	L12RT	L12RT	42
L14RT	L14RT	L14RT	L14RT	43
L16RT	L16RT	L16RT	L16RT	44
L18RT	L18RT	L18RT	L18RT	45
LCT	LCT	LCT	LCT	46
RCT	RCT	RCT	RCT	47
LOT	LOT	LOT	LOT	48
ROT	ROT	ROT	ROT	49
L10RT	L10RT	L10RT	L10RT	50
L12RT	L12RT	L12RT	L12RT	51
L14RT	L14RT	L14RT	L14RT	52
L16RT	L16RT	L16RT	L16RT	53

DIRECTION OF CHAIN TRAVEL

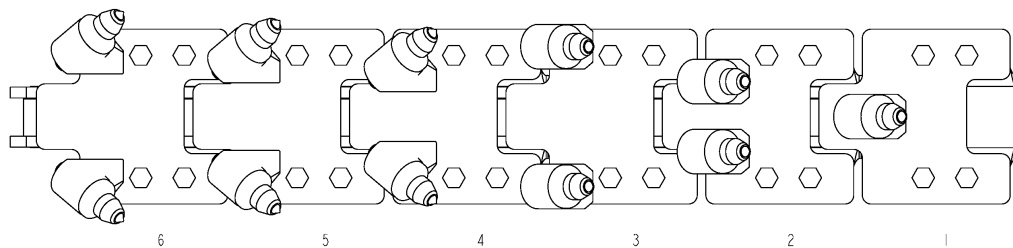


AU4512RB12xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
21000129	Tooth	All Stations	2	73	78	84	97
AU104468	Cutter Bar Center	CR	3	7	8	8	9
AU104469	Cutter Bar 4"	L4RR	4	7	7	8	9
AU104470	Cutter Bar 8"	L8RR	5	7	7	8	9
AU104471	Cutter Bar 10"	L10RR	6	7	7	8	9
AU104472	Cutter Bar 11"	L11RR	7	6	7	7	9
AU104473	Cutter Bar 12"	L12RR	8	6	7	7	8
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	9	160	172	184	212
231-41412	Locknut, 3/4"	All Cutter Bar Holes	10	160	172	184	212



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DIRECTION OF CHAIN TRAVEL →

AU4512RB12xx

12" CHAIN PATTERNS

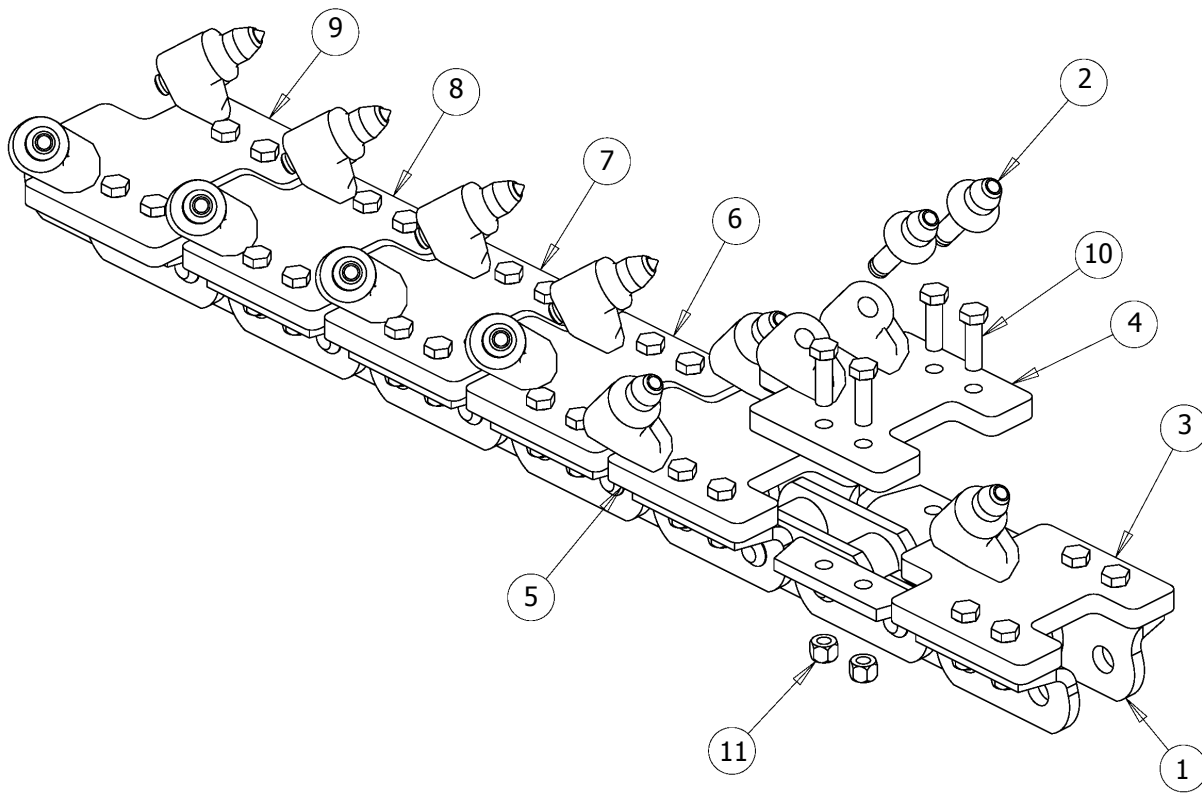
AU4512RB1240	AU4512RB1243	AU4512RB1246	AU4512RB1253	STATION
CT	CT	CT	CT	1
L4RR	L4RR	L4RR	L4RR	2
L8RR	L8RR	L8RR	L8RR	3
L10RR	L10RR	L10RR	L10RR	4
L11RR	L11RR	L11RR	L11RR	5
L12RR	L12RR	L12RR	L12RR	6
CT	CT	CT	CT	7
L4RR	L4RR	L4RR	L4RR	8
L8RR	L8RR	L8RR	L8RR	9
L10RR	L10RR	L10RR	L10RR	10
L11RR	L11RR	L11RR	L11RR	11
L12RR	L12RR	L12RR	L12RR	12
CT	CT	CT	CT	13
L4RR	L4RR	L4RR	L4RR	14
L8RR	L8RR	L8RR	L8RR	15
L10RR	L10RR	L10RR	L10RR	16
L11RR	L11RR	L11RR	L11RR	17
L12RR	L12RR	L12RR	L12RR	18
CT	CT	CT	CT	19
L4RR	L4RR	L4RR	L4RR	20
L8RR	L8RR	L8RR	L8RR	21
L10RR	L10RR	L10RR	L10RR	22
L11RR	L11RR	L11RR	L11RR	23
L12RR	L12RR	L12RR	L12RR	24
CT	CT	CT	CT	25
L4RR	L4RR	L4RR	L4RR	26
L8RR	L8RR	L8RR	L8RR	27
L10RR	L10RR	L10RR	L10RR	28
L11RR	L11RR	L11RR	L11RR	29
L12RR	L12RR	L12RR	L12RR	30
CT	CT	CT	CT	31
L4RR	L4RR	L4RR	L4RR	32
L8RR	L8RR	L8RR	L8RR	33
L10RR	L10RR	L10RR	L10RR	34
L11RR	L11RR	L11RR	L11RR	35
L12RR	L12RR	L12RR	L12RR	36
CT	CT	CT	CT	37
L4RR	L4RR	L4RR	L4RR	38
L8RR	L8RR	L8RR	L8RR	39
L10RR	L10RR	L10RR	L10RR	40
	L11RR	L11RR	L11RR	41
	L12RR	L12RR	L12RR	42
	CT	CT	CT	43
		L4RR	L4RR	44
		L8RR	L8RR	45
		L10RR	L10RR	46
			L11RR	47
			L12RR	48
			CT	49
			L4RR	50
			L8RR	51
			L10RR	52
			L11RR	53

DIRECTION OF CHAIN TRAVEL

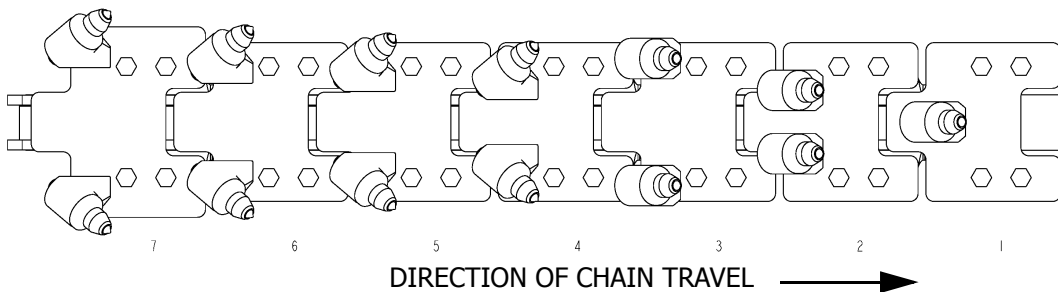


AU4512RB14xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
21000129	Tooth	All Stations	2	74	79	85	98
AU104468	Cutter Bar Center	CR	3	6	7	7	8
AU104469	Cutter Bar 4"	L4RR	4	6	6	7	8
AU104470	Cutter Bar 8"	L8RR	5	6	6	7	8
AU104471	Cutter Bar 10"	L10RR	6	6	6	7	8
AU104472	Cutter Bar 11"	L11RR	7	6	6	6	7
AU104473	Cutter Bar 12"	L12RR	8	5	6	6	7
AU104474	Cutter Bar 14"	L14RR	9	5	6	6	7
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	10	160	172	184	212
231-41412	Locknut, 3/4"	All Cutter Bar Holes	11	160	172	184	212



11




AU4512RB14xx

14" CHAIN PATTERNS

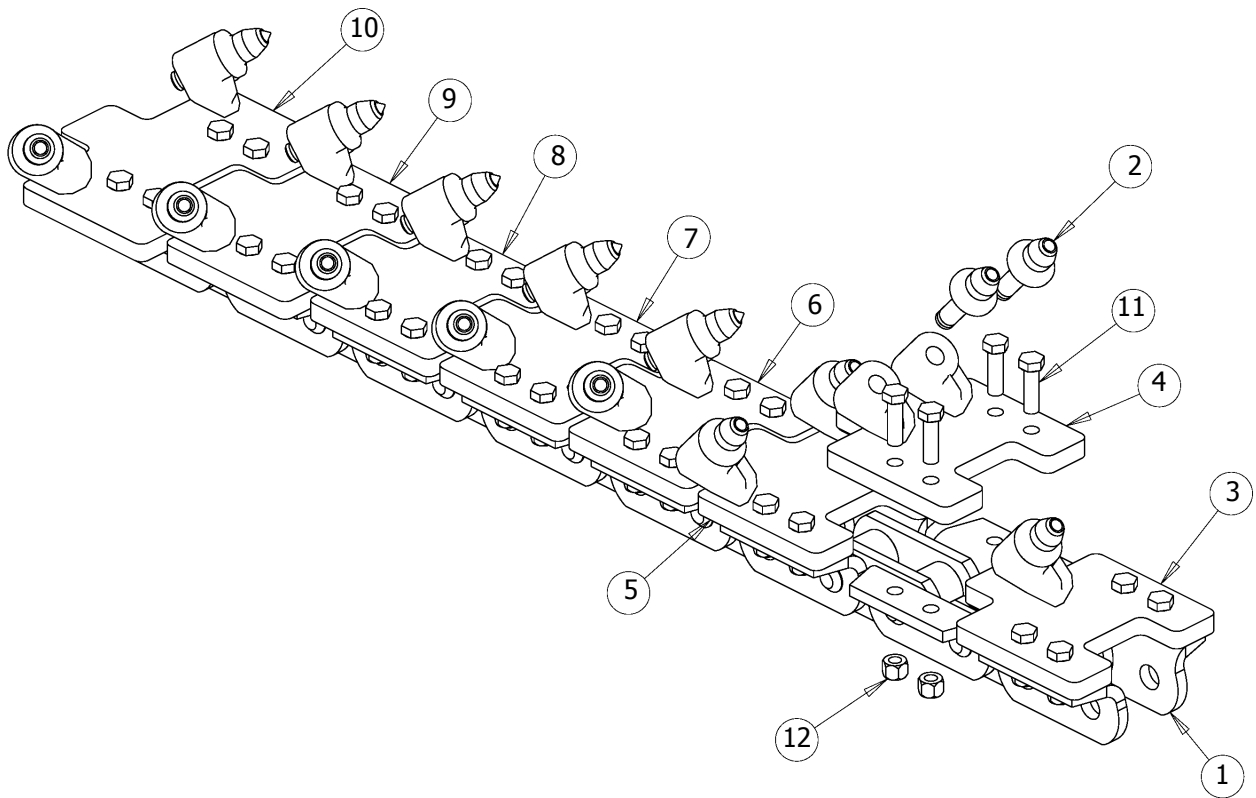
AU4512RB1440	AU4512RB1443	AU4512RB1446	AU4512RB1453	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
CT	CT	CT	CT	1
L4RR	L4RR	L4RR	L4RR	2
L8RR	L8RR	L8RR	L8RR	3
L10RR	L10RR	L10RR	L10RR	4
L11RR	L11RR	L11RR	L11RR	5
L12RR	L12RR	L12RR	L12RR	6
L14RR	L14RR	L14RR	L14RR	7
CT	CT	CT	CT	8
L4RR	L4RR	L4RR	L4RR	9
L8RR	L8RR	L8RR	L8RR	10
L10RR	L10RR	L10RR	L10RR	11
L11RR	L11RR	L11RR	L11RR	12
L12RR	L12RR	L12RR	L12RR	13
L14RR	L14RR	L14RR	L14RR	14
CT	CT	CT	CT	15
L4RR	L4RR	L4RR	L4RR	16
L8RR	L8RR	L8RR	L8RR	17
L10RR	L10RR	L10RR	L10RR	18
L11RR	L11RR	L11RR	L11RR	19
L12RR	L12RR	L12RR	L12RR	20
L14RR	L14RR	L14RR	L14RR	21
CT	CT	CT	CT	22
L4RR	L4RR	L4RR	L4RR	23
L8RR	L8RR	L8RR	L8RR	24
L10RR	L10RR	L10RR	L10RR	25
L11RR	L11RR	L11RR	L11RR	26
L12RR	L12RR	L12RR	L12RR	27
L14RR	L14RR	L14RR	L14RR	28
CT	CT	CT	CT	29
L4RR	L4RR	L4RR	L4RR	30
L8RR	L8RR	L8RR	L8RR	31
L10RR	L10RR	L10RR	L10RR	32
L11RR	L11RR	L11RR	L11RR	33
L12RR	L12RR	L12RR	L12RR	34
L14RR	L14RR	L14RR	L14RR	35
CT	CT	CT	CT	36
L4RR	L4RR	L4RR	L4RR	37
L8RR	L8RR	L8RR	L8RR	38
L10RR	L10RR	L10RR	L10RR	39
L11RR	L11RR	L11RR	L11RR	40
	L12RR	L12RR	L12RR	41
	L14RR	L14RR	L14RR	42
	CT	CT	CT	43
		L4RR	L4RR	44
		L8RR	L8RR	45
		L10RR	L10RR	46
			L11RR	47
			L12RR	48
			L14RR	49
			CT	50
			L4RR	51
			L8RR	52
			L10RR	53

DIRECTION OF CHAIN TRAVEL

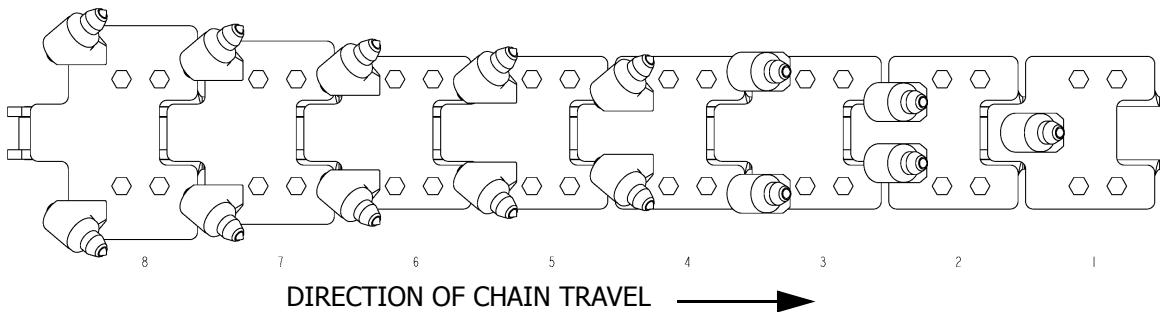


AU4512RB16xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
21000129	Tooth	All Stations	2	75	80	86	99
AU104468	Cutter Bar Center	CR	3	5	6	6	7
AU104469	Cutter Bar 4"	L4RR	4	5	6	6	7
AU104470	Cutter Bar 8"	L8RR	5	5	6	6	7
AU104471	Cutter Bar 10"	L10RR	6	5	5	6	7
AU104472	Cutter Bar 11"	L11RR	7	5	5	6	7
AU104473	Cutter Bar 12"	L12RR	8	5	5	6	6
AU104474	Cutter Bar 14"	L14RR	9	5	5	5	6
AU104475	Cutter Bar 16"	L16RR	10	5	5	5	6
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	11	160	172	184	212
231-41412	Locknut, 3/4"	All Cutter Bar Holes	12	160	172	184	212



11



AU4512RB16xx

16" CHAIN PATTERNS

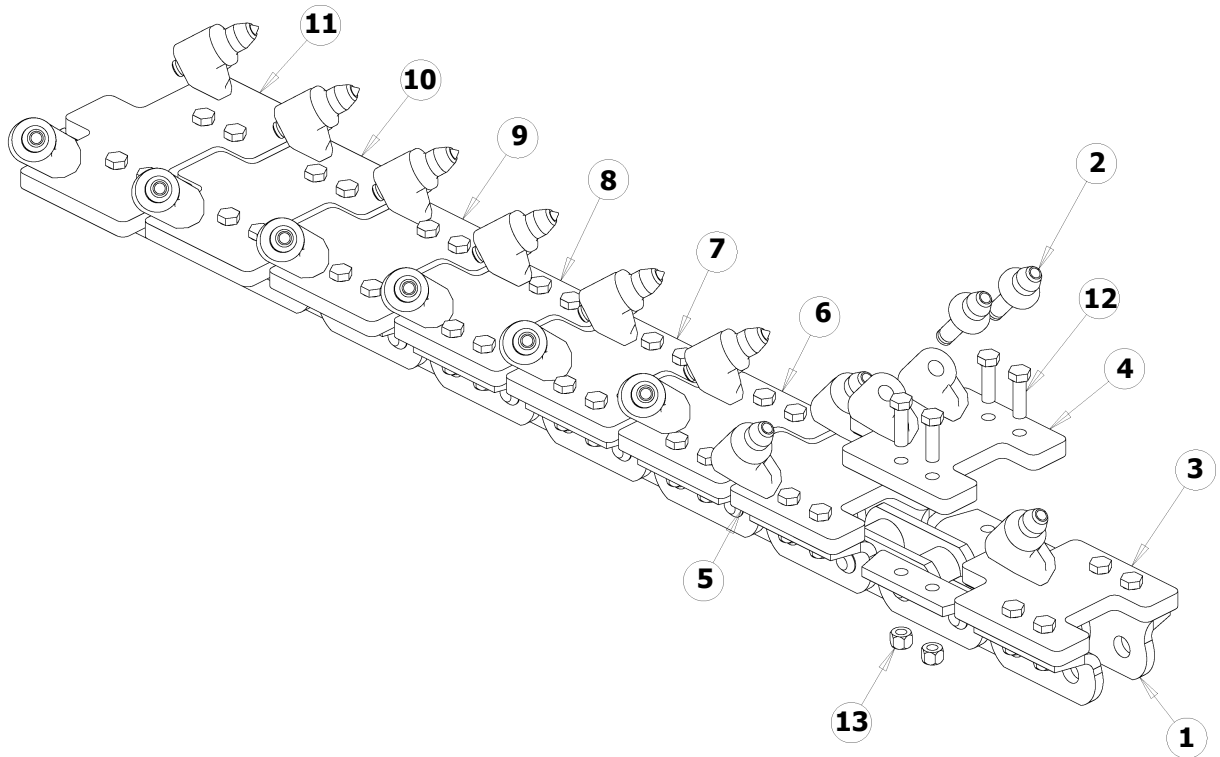
AU4512RB1640	AU4512RB1643	AU4512RB1646	AU4512RB1653	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
CT	CT	CT	CT	1
L4RR	L4RR	L4RR	L4RR	2
L8RR	L8RR	L8RR	L8RR	3
L10RR	L10RR	L10RR	L10RR	4
L11RR	L11RR	L11RR	L11RR	5
L12RR	L12RR	L12RR	L12RR	6
L14RR	L14RR	L14RR	L14RR	7
L16RR	L16RR	L16RR	L16RR	8
CT	CT	CT	CT	9
L4RR	L4RR	L4RR	L4RR	10
L8RR	L8RR	L8RR	L8RR	11
L10RR	L10RR	L10RR	L10RR	12
L11RR	L11RR	L11RR	L11RR	13
L12RR	L12RR	L12RR	L12RR	14
L14RR	L14RR	L14RR	L14RR	15
L16RR	L16RR	L16RR	L16RR	16
CT	CT	CT	CT	17
L4RR	L4RR	L4RR	L4RR	18
L8RR	L8RR	L8RR	L8RR	19
L10RR	L10RR	L10RR	L10RR	20
L11RR	L11RR	L11RR	L11RR	21
L12RR	L12RR	L12RR	L12RR	22
L14RR	L14RR	L14RR	L14RR	23
L16RR	L16RR	L16RR	L16RR	24
CT	CT	CT	CT	25
L4RR	L4RR	L4RR	L4RR	26
L8RR	L8RR	L8RR	L8RR	27
L10RR	L10RR	L10RR	L10RR	28
L11RR	L11RR	L11RR	L11RR	29
L12RR	L12RR	L12RR	L12RR	30
L14RR	L14RR	L14RR	L14RR	31
L16RR	L16RR	L16RR	L16RR	32
CT	CT	CT	CT	33
L4RR	L4RR	L4RR	L4RR	34
L8RR	L8RR	L8RR	L8RR	35
L10RR	L10RR	L10RR	L10RR	36
L11RR	L11RR	L11RR	L11RR	37
L12RR	L12RR	L12RR	L12RR	38
L14RR	L14RR	L14RR	L14RR	39
L16RR	L16RR	L16RR	L16RR	40
	CT	CT	CT	41
	L4RR	L4RR	L4RR	42
	L8RR	L8RR	L8RR	43
		L10RR	L10RR	44
		L11RR	L11RR	45
		L12RR	L12RR	46
			L14RR	47
			L16RR	48
			CT	49
			L4RR	50
			L8RR	51
			L10RR	52
			L11RR	53

DIRECTION OF CHAIN TRAVEL

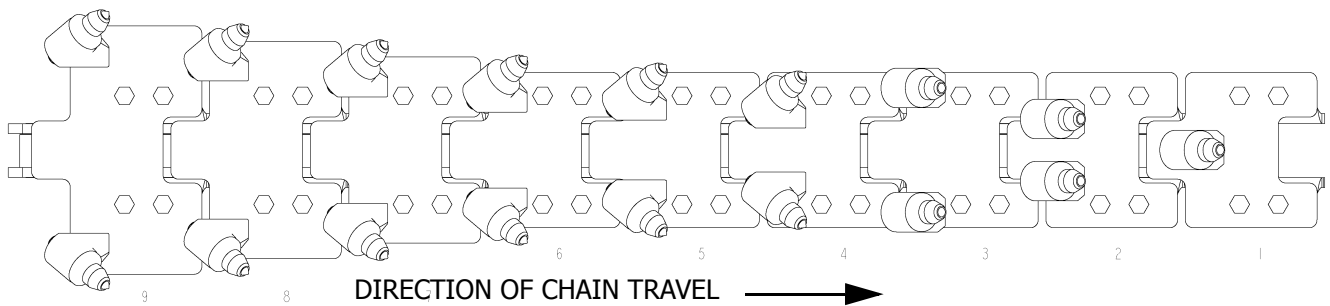


AU4512RB18xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
21000129	Tooth	All Stations	2	75	81	86	100
AU104468	Cutter Bar Center	CR	3	5	5	6	6
AU104469	Cutter Bar 4"	L4RR	4	5	5	5	6
AU104470	Cutter Bar 8"	L8RR	5	5	5	5	6
AU104471	Cutter Bar 10"	L10RR	6	5	5	5	6
AU104472	Cutter Bar 11"	L11RR	7	4	5	5	6
AU104473	Cutter Bar 12"	L12RR	8	4	5	5	6
AU104474	Cutter Bar 14"	L14RR	9	4	5	5	6
AU104475	Cutter Bar 16"	L16RR	10	4	4	5	6
AU104476	Cutter Bar 18"	L18RR	11	4	4	5	5
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	12	160	172	184	212
231-41412	Locknut, 3/4"	All Cutter Bar Holes	13	160	172	184	212



11




AU4512RB18xx

18" CHAIN PATTERNS

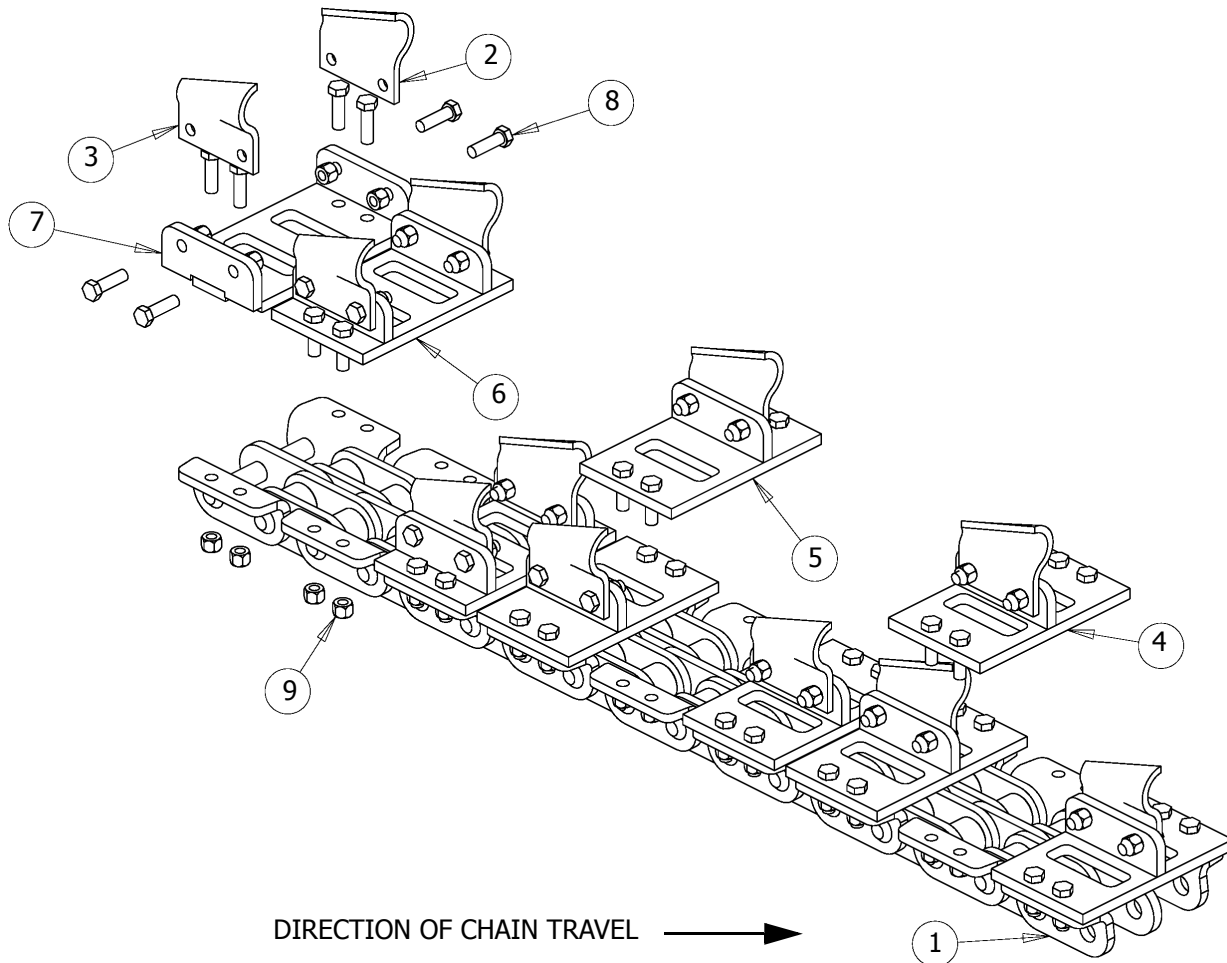
AU4512RB1840	AU4512RB1843	AU4512RB1846	AU4512RB1853	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
CT	CT	CT	CT	1
L4RR	L4RR	L4RR	L4RR	2
L8RR	L8RR	L8RR	L8RR	3
L10RR	L10RR	L10RR	L10RR	4
L11RR	L11RR	L11RR	L11RR	5
L12RR	L12RR	L12RR	L12RR	6
L14RR	L14RR	L14RR	L14RR	7
L16RR	L16RR	L16RR	L16RR	8
L18RR	L18RR	L18RR	L18RR	9
CT	CT	CT	CT	10
L4RR	L4RR	L4RR	L4RR	11
L8RR	L8RR	L8RR	L8RR	12
L10RR	L10RR	L10RR	L10RR	13
L11RR	L11RR	L11RR	L11RR	14
L12RR	L12RR	L12RR	L12RR	15
L14RR	L14RR	L14RR	L14RR	16
L16RR	L16RR	L16RR	L16RR	17
L18RR	L18RR	L18RR	L18RR	18
CT	CT	CT	CT	19
L4RR	L4RR	L4RR	L4RR	20
L8RR	L8RR	L8RR	L8RR	21
L10RR	L10RR	L10RR	L10RR	22
L11RR	L11RR	L11RR	L11RR	23
L12RR	L12RR	L12RR	L12RR	24
L14RR	L14RR	L14RR	L14RR	25
L16RR	L16RR	L16RR	L16RR	26
L18RR	L18RR	L18RR	L18RR	27
CT	CT	CT	CT	28
L4RR	L4RR	L4RR	L4RR	29
L8RR	L8RR	L8RR	L8RR	30
L10RR	L10RR	L10RR	L10RR	31
L11RR	L11RR	L11RR	L11RR	32
L12RR	L12RR	L12RR	L12RR	33
L14RR	L14RR	L14RR	L14RR	34
L16RR	L16RR	L16RR	L16RR	35
L18RR	L18RR	L18RR	L18RR	36
CT	CT	CT	CT	37
L4RR	L4RR	L4RR	L4RR	38
L8RR	L8RR	L8RR	L8RR	39
L10RR	L10RR	L10RR	L10RR	40
	L11RR	L11RR	L11RR	41
	L12RR	L12RR	L12RR	42
	L14RR	L14RR	L14RR	43
		L16RR	L16RR	44
		L18RR	L18RR	45
		CT	CT	46
			L4RR	47
			L8RR	48
			L10RR	49
			L11RR	50
			L12RR	51
			L14RR	52
			L16RR	53

DIRECTION OF CHAIN TRAVEL

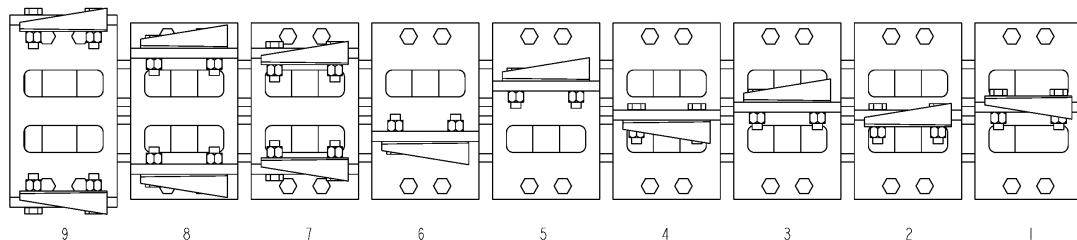


AU4522CT16xx

P/N	DESCRIPTION	USED WITH	ITEM	STATIONS	
				40	46
AU104738	Bare Chain, 40 Station		1	1	
30-960-1270	Bare Chain, 46 Station		1		1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10T, L12TR, L14TR, L16TR	2	26	30
CC450R	Right Hand Cup Cutter	LCT, ROT, R10T, L12TR, L14TR, L16TR	3	26	31
AU103696	Cutter Bar Base 1	LCT, RCT, LOT, ROT	4	20	21
AU103697	Cutter Bar Base 2	L10T, R10T	5	8	10
AU103698	Cutter Bar Base 3	L12TR, L14TR	6	8	10
AU104747	Cutter Bar Base 4	L16TR	7	4	5
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	8	264	306
231-41412	Locknut, 3/4"	All Holes	9	264	306



12



AU4522CT16xx

16" CHAIN PATTERNS

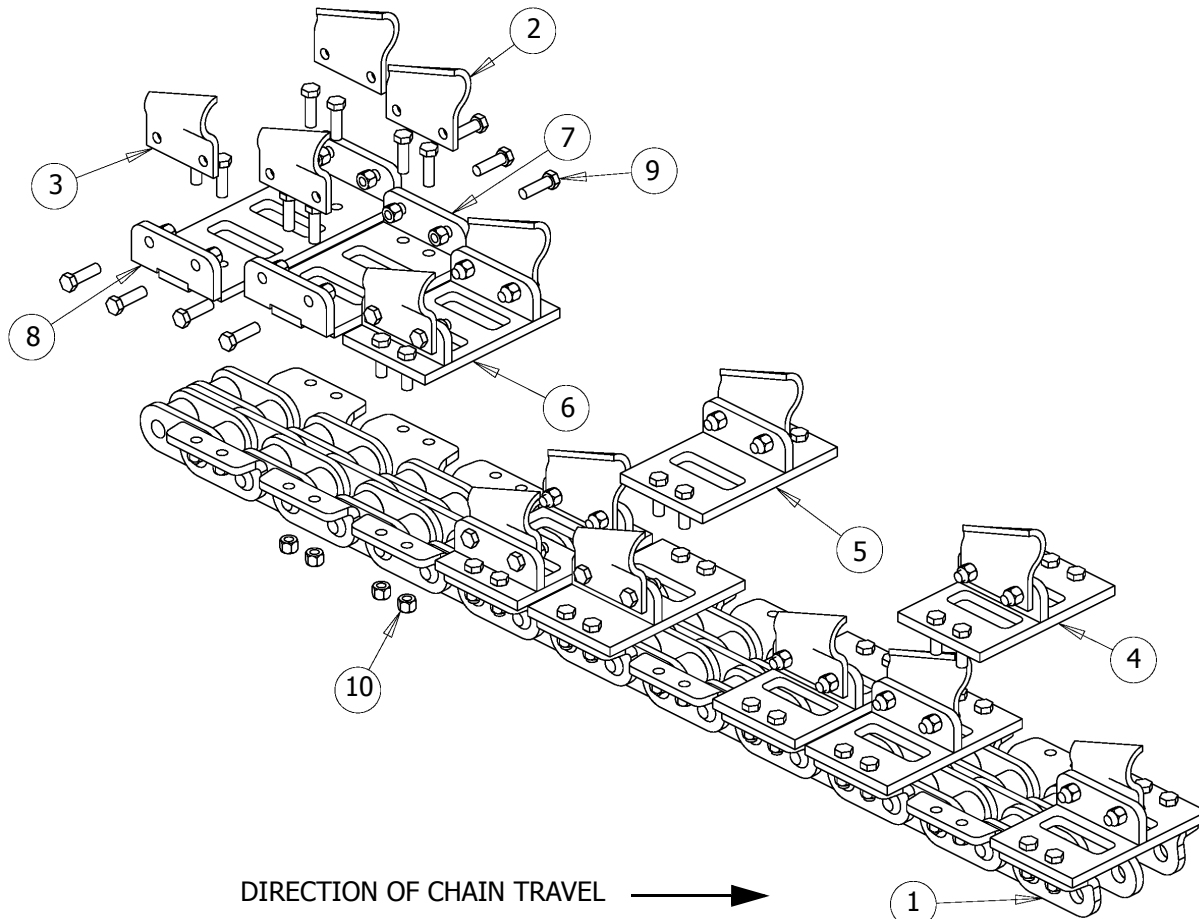
AU4522CT1640	AU4522CT1646	STATION
LCT	LCT	1
RCT	RCT	2
LOT	LOT	3
ROT	ROT	4
L10T	L10T	5
R10T	R10T	6
L12RT	L12RT	7
L14RT	L14RT	8
L16RT	L16RT	9
LCT	LCT	10
RCT	RCT	11
LOT	LOT	12
ROT	ROT	13
L10T	L10T	14
R10T	R10T	15
L12RT	L12RT	16
L14RT	L14RT	17
L16RT	L16RT	18
LCT	LCT	19
RCT	RCT	20
LOT	LOT	21
ROT	ROT	22
L10T	L10T	23
R10T	R10T	24
L12RT	L12RT	25
L14RT	L14RT	26
L16RT	L16RT	27
LCT	LCT	28
RCT	RCT	29
LOT	LOT	30
ROT	ROT	31
L10T	L10T	32
R10T	R10T	33
L12RT	L12RT	34
L14RT	L14RT	35
L16RT	L16RT	36
LCT	LCT	37
RCT	RCT	38
LOT	LOT	39
ROT	ROT	40
	L10T	41
	R10T	42
	L12RT	43
	L14RT	44
	L16RT	45
	LCT	46



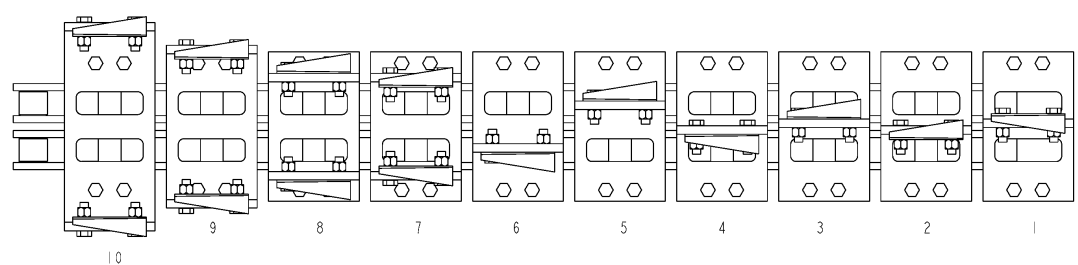
DIRECTION OF CHAIN TRAVEL

AU4522CT20xx

P/N	DESCRIPTION	USED WITH	ITEM	NO. OF STATIONS		
				40	43	46
				QTY	QTY	QTY
91000431	Bare Chain, 6 Station		1		1	
30-760-1077	Bare Chain, 37 Station		1		1	
AU104738	Bare Chain, 40 Station		1	1		
30-960-1270	Bare Chain, 46 Station		1			1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10T, L12TR, L14TR, L16TR, L20TR	2	28	30	31
CC450R	Right Hand Cup Cutter	LCT, ROT, R10T, L12TR, L14TR, L16TR, L20TR	3	28	29	31
AU103696	Cutter Bar Base 1	LCT, RCT, LOT, ROT, L10T, R10T	4	16	19	20
AU103697	Cutter Bar Base 2	L12TR	5	8	8	10
AU103698	Cutter Bar Base 3	L14TR	6	8	8	8
AU104747	Cutter Bar Base 4	L16TR	7	4	4	4
AU103681	Cutter Bar Base 20"	L20TR	8	4	4	4
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	9	272	290	308
231-41412	Locknut, 3/4"	All Holes	10	272	290	308



12



AU4522CT20xx

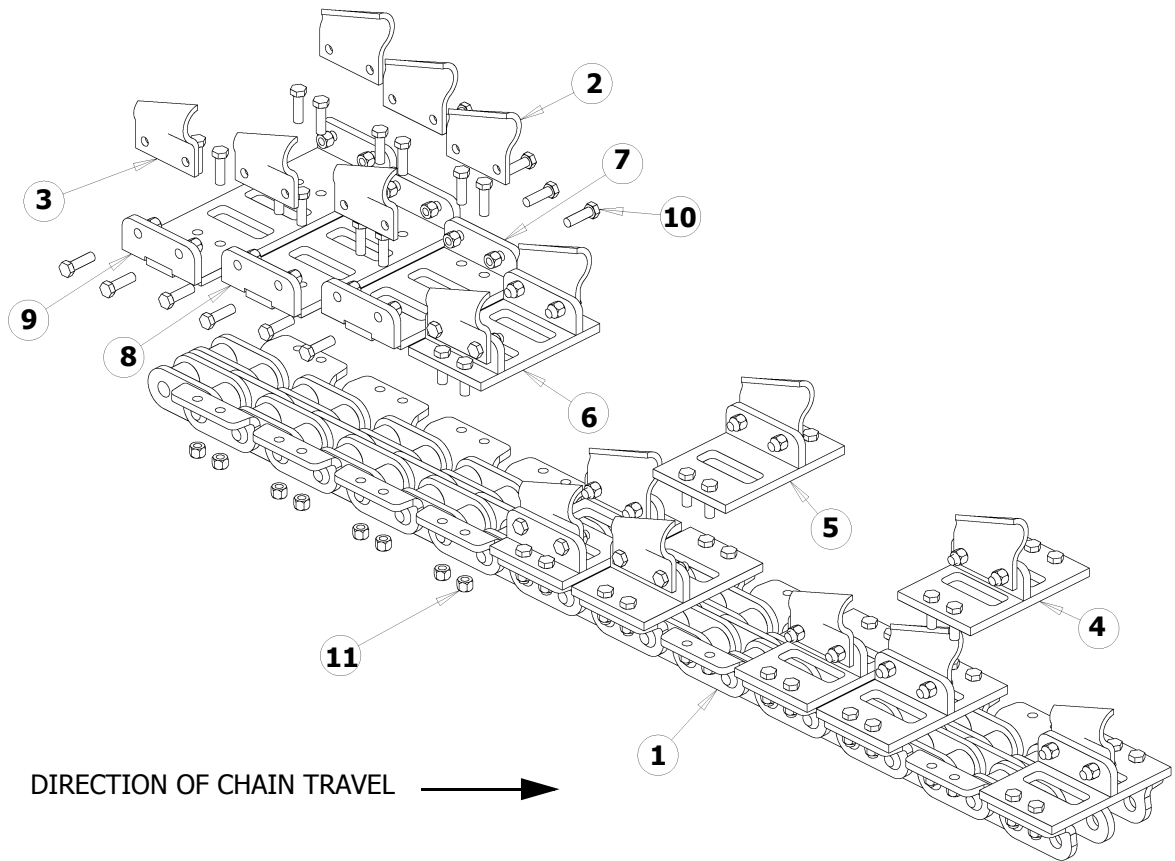
20" CHAIN PATTERNS

AU4522CT2040	AU4522CT2043	AU4522CT2046	STATION
TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	1
RCT	RCT	RCT	2
LOT	LOT	LOT	3
ROT	ROT	ROT	4
L10T	L10T	L10T	5
R10T	R10T	R10T	6
L12RT	L12RT	L12RT	7
L14RT	L14RT	L14RT	8
L16RT	L16RT	L16RT	9
L20RT	L20RT	L20RT	10
LCT	LCT	LCT	11
RCT	RCT	RCT	12
LOT	LOT	LOT	13
ROT	ROT	ROT	14
L10T	L10T	L10T	15
R10T	R10T	R10T	16
L12RT	L12RT	L12RT	17
L14RT	L14RT	L14RT	18
L16RT	L16RT	L16RT	19
L20RT	L20RT	L20RT	20
LCT	LCT	LCT	21
RCT	RCT	RCT	22
LOT	LOT	LOT	23
ROT	ROT	ROT	24
L10T	L10T	L10T	25
R10T	R10T	R10T	26
L12RT	L12RT	L12RT	27
L14RT	L14RT	L14RT	28
L16RT	L16RT	L16RT	29
L20RT	L20RT	L20RT	30
LCT	LCT	LCT	31
RCT	RCT	RCT	32
LOT	LOT	LOT	33
ROT	ROT	ROT	34
L10T	L10T	L10T	35
R10T	R10T	R10T	36
L12RT	L12RT	L12RT	37
L14RT	L14RT	L14RT	38
L16RT	L16RT	L16RT	39
L20RT	L20RT	L20RT	40
	LCT	LCT	41
	RCT	RCT	42
	LOT	LOT	43
	ROT	ROT	44
	L10T	L10T	45
	R10T	R10T	46

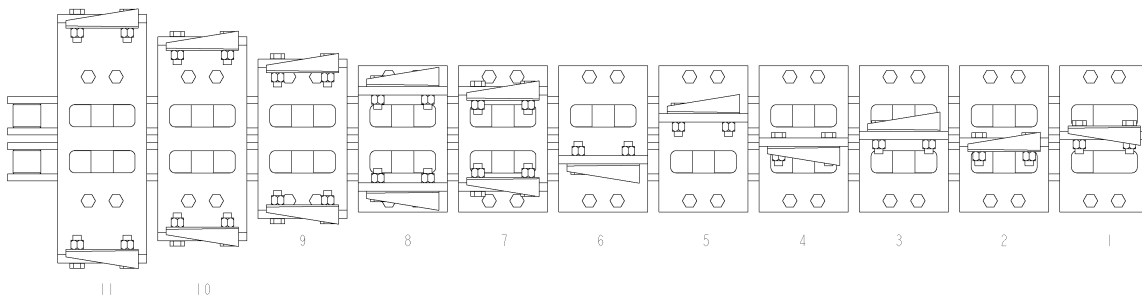
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DIRECTION OF CHAIN TRAVEL

AU4522CT24xx

P/N	DESCRIPTION	USED WITH	ITEM	NO. OF STATIONS		
				40	43	46
				QTY	QTY	QTY
91000431	Bare Chain, 6 Station		1		1	
30-760-1077	Bare Chain, 37 Station		1		1	
AU104738	Bare Chain, 40 Station		1	1		
30-960-1270	Bare Chain, 46 Station		1			1
CC450L	Left Hand Cup Cutter	RCT, LOT, L10T, L12TR, L14TR, L16TR, L20TR, L24TR	2	28	31	33
CC450R	Right Hand Cup Cutter	LCT, ROT, R10T, L12TR, L14TR, L16TR, L20TR, L24TR	3	28	31	33
AU103696	Cutter Bar Base 1	LCT, RCT, LOT, ROT, L10T, R10T	4	16	16	18
AU103697	Cutter Bar Base 2	L12TR	5	8	8	8
AU103698	Cutter Bar Base 3	L14TR	6	7	8	8
AU104747	Cutter Bar Base 4	L16TR	7	3	4	4
AU103681	Cutter Bar Base 20"	L20TR	8	3	4	4
AU103682	Cutter Bar Base 24"	L24TR	9	3	3	4
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	10	272	296	316
231-41412	Locknut, 3/4"	All Holes	11	272	296	316



12



AU4522CT24xx

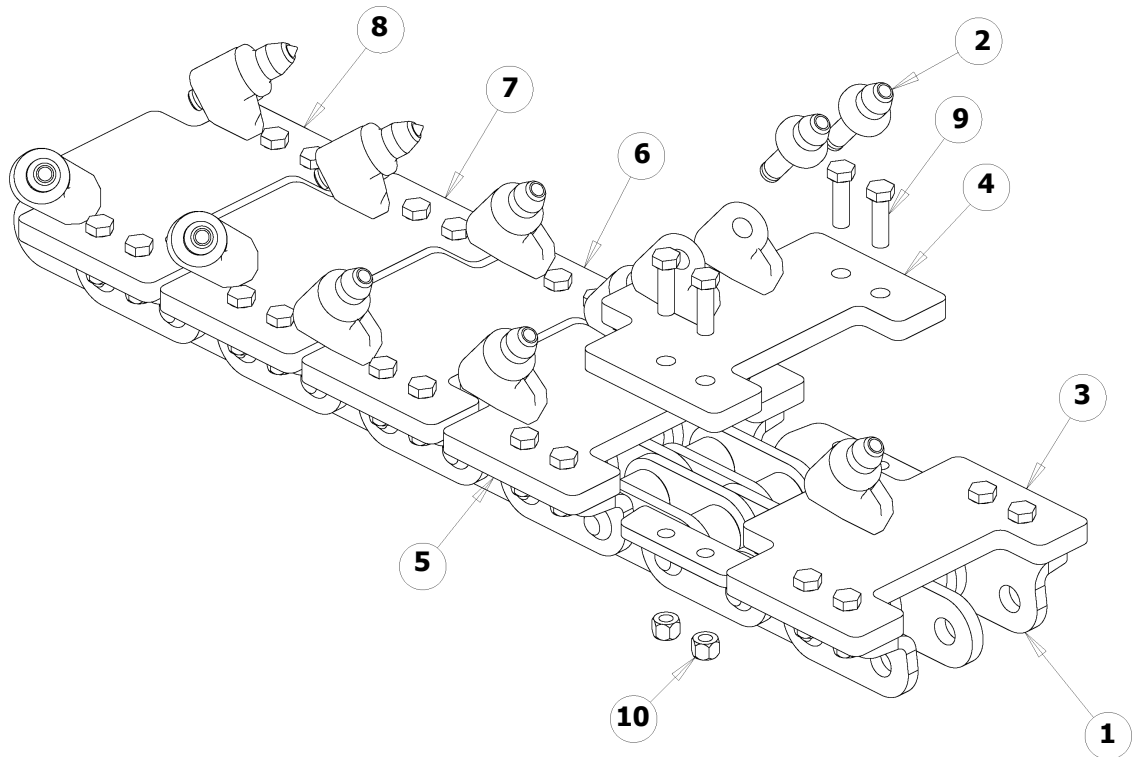
24" CHAIN PATTERNS

AU4522CT2440	AU4522CT2443	AU4522CT2446	STATION
TOOTH	TOOTH	TOOTH	
LCT	LCT	LCT	1
RCT	RCT	RCT	2
LOT	LOT	LOT	3
ROT	ROT	ROT	4
L10T	L10T	L10T	5
R10T	R10T	R10T	6
L12RT	L12RT	L12RT	7
L14RT	L14RT	L14RT	8
L16RT	L16RT	L16RT	9
L20RT	L20RT	L20RT	10
L24RT	L24RT	L24RT	11
LCT	LCT	LCT	12
RCT	RCT	RCT	13
LOT	LOT	LOT	14
ROT	ROT	ROT	15
L10T	L10T	L10T	16
R10T	R10T	R10T	17
L12RT	L12RT	L12RT	18
L14RT	L14RT	L14RT	19
L16RT	L16RT	L16RT	20
L20RT	L20RT	L20RT	21
L24RT	L24RT	L24RT	22
LCT	LCT	LCT	23
RCT	RCT	RCT	24
LOT	LOT	LOT	25
ROT	ROT	ROT	26
L10T	L10T	L10T	27
R10T	R10T	R10T	28
L12RT	L12RT	L12RT	29
L14RT	L14RT	L14RT	30
L16RT	L16RT	L16RT	31
L20RT	L20RT	L20RT	32
L24RT	L24RT	L24RT	33
LCT	LCT	LCT	34
RCT	RCT	RCT	35
LOT	LOT	LOT	36
ROT	ROT	ROT	37
L10T	L10T	L10T	38
R10T	R10T	R10T	39
L12RT	L12RT	L12RT	40
	L14RT	L14RT	41
	L16RT	L16RT	42
	L20RT	L20RT	43
		L24RT	44
		LCT	45
		RCT	46

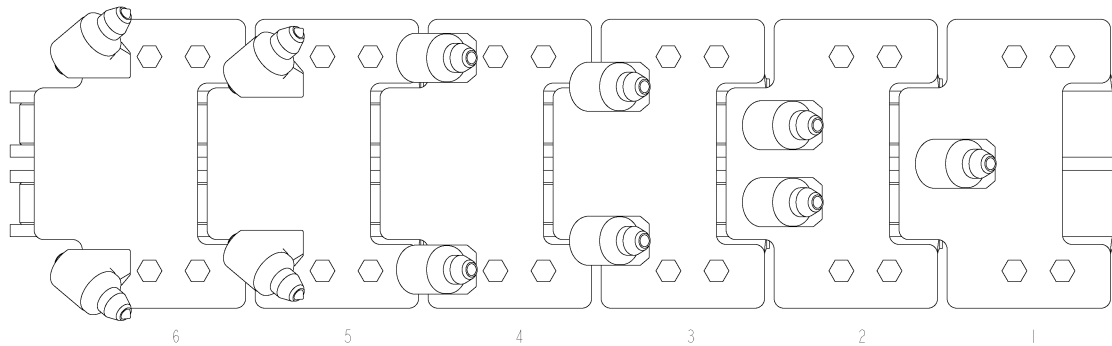
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DIRECTION OF CHAIN TRAVEL

AU4522RB16xx

P/N	DESCRIPTION	USED WITH	ITEM	STATIONS	
				40	46
				QTY	QTY
AU104738	Bare Chain, 40 Station		1	1	
30-960-1270	Bare Chain, 46 Station		1		1
21000129	Tooth	All Stations	2	73	84
AU104477	Cutter Bar Center	CR	3	7	8
AU104745	Cutter Bar 4"	L4RR	4	7	8
AU104744	Cutter Bar 8"	L8RR	5	7	8
AU104743	Cutter Bar 11"	L11RR	6	7	8
AU104742	Cutter Bar 14"	L14RR	7	6	7
AU104741	Cutter Bar 16"	L16RR	8	6	7
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	9	160	184
231-41412	Locknut, 3/4"	All Cutter Bar Holes	10	160	184



DIRECTION OF CHAIN TRAVEL →



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AU4522RB16xx

16" CHAIN PATTERNS

AU4522RB1640	AU4522RB1646	STATION
TOOTH	TOOTH	
CT	CT	1
L4RR	L4RR	2
L8RR	L8RR	3
L11RR	L11RR	4
L14RR	L14RR	5
L16RR	L16RR	6
CT	CT	7
L4RR	L4RR	8
L8RR	L8RR	9
L11RR	L11RR	10
L14RR	L14RR	11
L16RR	L16RR	12
CT	CT	13
L4RR	L4RR	14
L8RR	L8RR	15
L11RR	L11RR	16
L14RR	L14RR	17
L16RR	L16RR	18
CT	CT	19
L4RR	L4RR	20
L8RR	L8RR	21
L11RR	L11RR	22
L14RR	L14RR	23
L16RR	L16RR	24
CT	CT	25
L4RR	L4RR	26
L8RR	L8RR	27
L11RR	L11RR	28
L14RR	L14RR	29
L16RR	L16RR	30
CT	CT	31
L4RR	L4RR	32
L8RR	L8RR	33
L11RR	L11RR	34
L14RR	L14RR	35
L16RR	L16RR	36
CT	CT	37
L4RR	L4RR	38
L8RR	L8RR	39
L11RR	L11RR	40
	L14RR	41
	L16RR	42
	CT	43
	L4RR	44
	L8RR	45
	L11RR	46

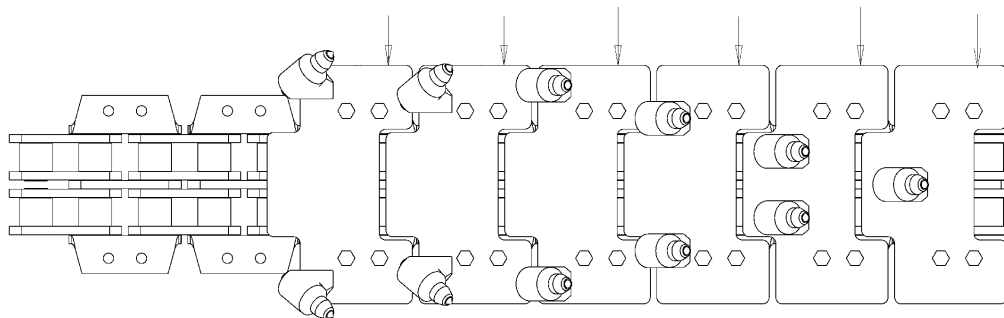
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DIRECTION OF CHAIN TRAVEL

SECTION 12 - AU4502 2-PITCH CHAIN CONFIGURATIONS - DIGGING CHAIN SELECTION GUIDE

AU4522RB20xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
21000129	Tooth	All Stations	2	73	78	84	97
AU104477	Cutter Bar Center	CR	3	7	8	8	9
AU104478	Cutter Bar 4"	L4RR	4	7	7	8	9
AU104479	Cutter Bar 10"	L10RR	5	7	7	8	9
AU104480	Cutter Bar 15"	L15RR	6	6	7	8	9
AU104481	Cutter Bar 18"	L18RR	7	6	7	7	9
AU104482	Cutter Bar 20"	L20RR	8	6	7	7	8
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	9	156	172	184	212
231-41412	Locknut, 3/4"	All Cutter Bar Holes	10	156	172	184	212

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DIRECTION OF CHAIN TRAVEL →

AU4522RB20xx

20" CHAIN PATTERNS

AU4522RB2040	AU4522RB2043	AU4522RB2046	AU4522RB2053	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
CT	CT	CT	CT	1
L4RR	L4RR	L4RR	L4RR	2
L10RR	L10RR	L10RR	L10RR	3
L15RR	L15RR	L15RR	L15RR	4
L18RR	L18RR	L18RR	L18RR	5
L20RR	L20RR	L20RR	L20RR	6
CT	CT	CT	CT	7
L4RR	L4RR	L4RR	L4RR	8
L10RR	L10RR	L10RR	L10RR	9
L15RR	L15RR	L15RR	L15RR	10
L18RR	L18RR	L18RR	L18RR	11
L20RR	L20RR	L20RR	L20RR	12
CT	CT	CT	CT	13
L4RR	L4RR	L4RR	L4RR	14
L10RR	L10RR	L10RR	L10RR	15
L15RR	L15RR	L15RR	L15RR	16
L18RR	L18RR	L18RR	L18RR	17
L20RR	L20RR	L20RR	L20RR	18
CT	CT	CT	CT	19
L4RR	L4RR	L4RR	L4RR	20
L10RR	L10RR	L10RR	L10RR	21
L15RR	L15RR	L15RR	L15RR	22
L18RR	L18RR	L18RR	L18RR	23
L20RR	L20RR	L20RR	L20RR	24
CT	CT	CT	CT	25
L4RR	L4RR	L4RR	L4RR	26
L10RR	L10RR	L10RR	L10RR	27
L15RR	L15RR	L15RR	L15RR	28
L18RR	L18RR	L18RR	L18RR	29
L20RR	L20RR	L20RR	L20RR	30
CT	CT	CT	CT	31
L4RR	L4RR	L4RR	L4RR	32
L10RR	L10RR	L10RR	L10RR	33
L15RR	L15RR	L15RR	L15RR	34
L18RR	L18RR	L18RR	L18RR	35
L20RR	L20RR	L20RR	L20RR	36
CT	CT	CT	CT	37
L4RR	L4RR	L4RR	L4RR	38
L10RR	L10RR	L10RR	L10RR	39
L15RR	L15RR	L15RR	L15RR	40
	L18RR	L18RR	L18RR	41
	L20RR	L20RR	L20RR	42
	CT	CT	CT	43
		L4RR	L4RR	44
		L10RR	L10RR	45
		L15RR	L15RR	46
			L18RR	47
			L20RR	48
			CT	49
			L4RR	50
			L10RR	51
			L15RR	52
			L18RR	53

DIRECTION OF CHAIN TRAVEL

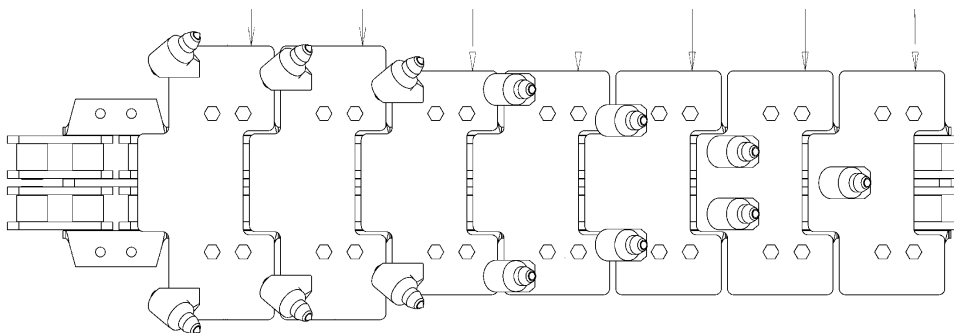


SECTION 12 - AU4502 2-PITCH CHAIN CONFIGURATIONS - DIGGING CHAIN SELECTION GUIDE

AU4522RB24xx

P/N	DESCRIPTION	USED WITH	ITEM	NUMBER OF STATIONS			
				40 QTY	43 QTY	46 QTY	53 QTY
91000323	Bare Chain, 40 Station		1	1			
91000325	Bare Chain, 43 Station		1		1		
91000328	Bare Chain, 46 Station		1			1	
91000334	Bare Chain, 53 Station		1				1
21000129	Tooth	All Stations	2	74	79	85	98
AU104477	Cutter Bar Center	CR	3	6	7	7	9
AU104478	Cutter Bar 5"	L5RR	4	6	6	7	9
AU104479	Cutter Bar 10"	L10RR	5	6	6	7	9
AU104480	Cutter Bar 15"	L15RR	6	6	6	7	9
AU104482	Cutter Bar 20"	L20RR	7	6	6	6	7
AU104483	Cutter Bar 22"	L22RR	8	5	6	6	7
AU104484	Cutter Bar 24"	L24RR	9	5	6	6	7
426-1240	Capscrew, 3/4" x2-1/2"	All Cutter Bar Holes	10	160	172	184	212
231-41412	Locknut, 3/4"	All Cutter Bar Holes	11	160	172	184	212

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DIRECTION OF CHAIN TRAVEL →

AU4522RB24xx

24" CHAIN PATTERNS

AU4522RB2440	AU4522RB2443	AU4522RB2446	AU4522RB2453	STATION
TOOTH	TOOTH	TOOTH	TOOTH	
CT	CT	CT	CT	1
L5RR	L5RR	L5RR	L5RR	2
L10RR	L10RR	L10RR	L10RR	3
L15RR	L15RR	L15RR	L15RR	4
L20RR	L20RR	L20RR	L20RR	5
L22RR	L22RR	L22RR	L22RR	6
L24RR	L24RR	L24RR	L24RR	7
CT	CT	CT	CT	8
L5RR	L5RR	L5RR	L5RR	9
L10RR	L10RR	L10RR	L10RR	10
L15RR	L15RR	L15RR	L15RR	11
L20RR	L20RR	L20RR	L20RR	12
L22RR	L22RR	L22RR	L22RR	13
L24RR	L24RR	L24RR	L24RR	14
CT	CT	CT	CT	15
L5RR	L5RR	L5RR	L5RR	16
L10RR	L10RR	L10RR	L10RR	17
L15RR	L15RR	L15RR	L15RR	18
L20RR	L20RR	L20RR	L20RR	19
L22RR	L22RR	L22RR	L22RR	20
L24RR	L24RR	L24RR	L24RR	21
CT	CT	CT	CT	22
L5RR	L5RR	L5RR	L5RR	23
L10RR	L10RR	L10RR	L10RR	24
L15RR	L15RR	L15RR	L15RR	25
L20RR	L20RR	L20RR	L20RR	26
L22RR	L22RR	L22RR	L22RR	27
L24RR	L24RR	L24RR	L24RR	28
CT	CT	CT	CT	29
L5RR	L5RR	L5RR	L5RR	30
L10RR	L10RR	L10RR	L10RR	31
L15RR	L15RR	L15RR	L15RR	32
L20RR	L20RR	L20RR	L20RR	33
L22RR	L22RR	L22RR	L22RR	34
L24RR	L24RR	L24RR	L24RR	35
CT	CT	CT	CT	36
L5RR	L5RR	L5RR	L5RR	37
L10RR	L10RR	L10RR	L10RR	38
L15RR	L15RR	L15RR	L15RR	39
L20RR	L20RR	L20RR	L20RR	40
	L22RR	L22RR	L22RR	41
	L24RR	L24RR	L24RR	42
	CT	CT	CT	43
		L5RR	L5RR	44
		L10RR	L10RR	45
		L15RR	L15RR	46
			L20RR	47
			L22RR	48
			L24RR	49
			CT	50
			L5RR	51
			L10RR	52
			L15RR	53

DIRECTION OF CHAIN TRAVEL

