



# WEBSTER INDUSTRIES

## DAIRY INDUSTRY CHAINS

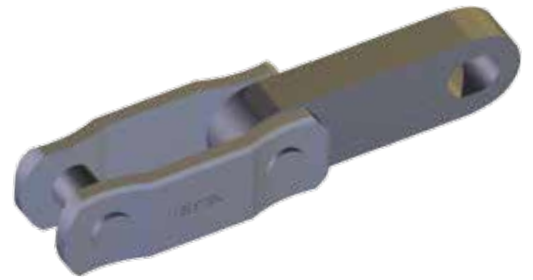
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# DOUBLE FLEX CHAINS

Double flex chains are made for a variety of conveying applications. They are widely used in the dairy and forest industries. They are designed to run in-floor in multidirectional applications and are induction hardened in all critical wear areas.



## MATERIAL

Pins and center links are made of heat treated alloy steel. Pins are induction hardened for increased wear resistance and longer life. Center links are also induction hardened on the edges for increased wear. Sidebars are made of medium carbon heat treated steel and the edges are induction hardened. DF3500 sidebars are also induction hardened on the sliding face to further increase life.

## ASSEMBLY

Double flex chains are riveted construction. Connecting pins are also riveted.

## INTERCHANGEABILITY

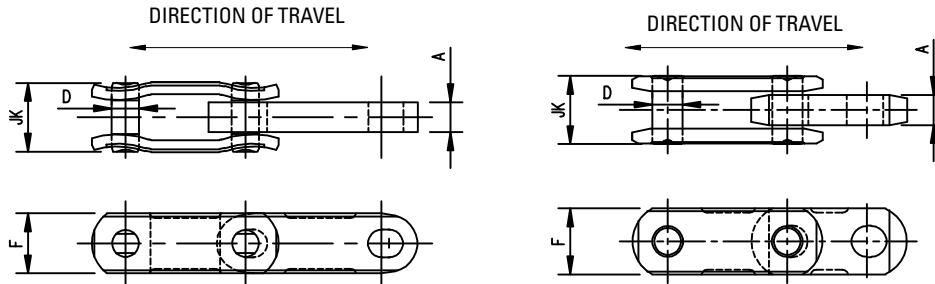
Double flex chains are interchangeable with other standard makes of corresponding sizes and numbers.

## APPLICATION

Double flex chains are primarily used in the dairy and forest product industries. The conveyors are usually multiple strands, moving boards and crates around corners.

## OPERATION

Double flex chains are best suited for slow or moderate speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see the Table below.



Chain No.	Average Pitch Inches	Average Weight Per Ft. Lbs.	Rated Working Load in Lbs.	General Dimensions				
				Overall Width	Max. Spkt. Width	Sidebar Height	Pin Dia.	Min. Flex Radius
				JK	A	F	D	
DF3498	1.750	4.5	See Table Below	1 <sup>7</sup> / <sub>16</sub>	5 <sup>8</sup> / <sub>16</sub>	3 <sup>8</sup> / <sub>16</sub>	3 <sup>8</sup> / <sub>16</sub>	16
	2.500							
DF3500	2.500	3.3	See Table Below	1 <sup>1</sup> / <sub>2</sub>	5 <sup>8</sup> / <sub>16</sub>	1 <sup>4</sup> / <sub>16</sub>	3 <sup>8</sup> / <sub>16</sub>	20
	3.000							

## CONVEYOR SERVICE

Ratio of Chain Speed (FPM) to Conveyor Length (Ft.)	Rated Working Load in Lbs.	
	DF3498	DF3500
0.1 to 0.6	5,000	4,000
0.7 to 1.0	4,250	3,400
1.1 to 1.5	3,650	2,900
1.6 to 2.0	3,250	2,600
2.1 to 2.5	2,850	2,300
2.6 to 15.0	2,600	2,100



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