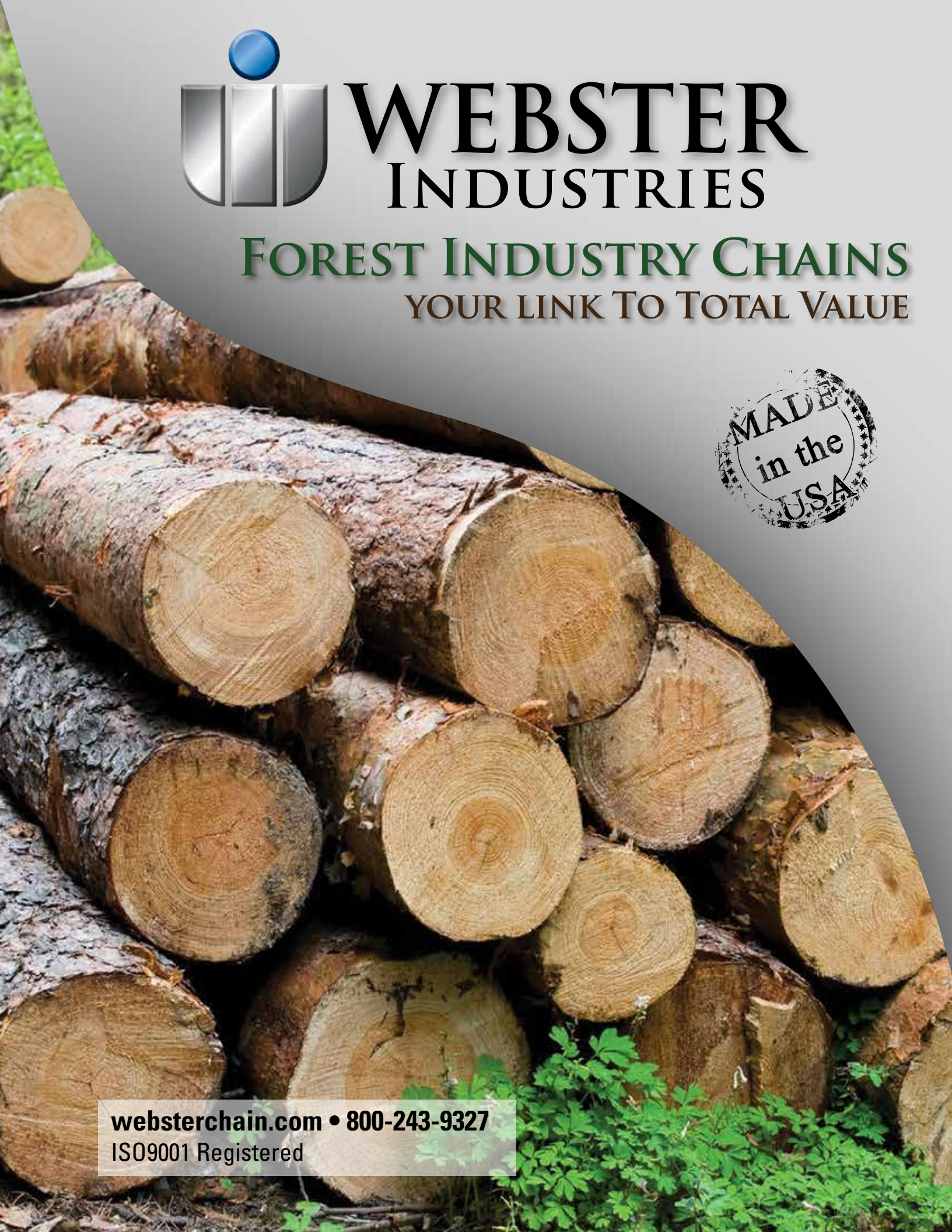
WEBSTER
INDUSTRIES
FOREST INDUSTRY CHAINS
YOUR LINK TO TOTAL VALUE
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ISO9001 Registered

HISTORY

For over 100 years, Webster Industries, Inc., has provided conveying solutions to a diverse range of markets with our extensive variety of products and industry expertise. Towner K. Webster founded Webster in 1876 in Chicago, Illinois, with his "Common Sense" elevator bucket. In 1907, Webster relocated to Tiffin, Ohio, where our corporate headquarters is located today. Throughout the past century, Webster has evolved from producing elevator buckets to being the world's leading manufacturer of engineered class chains, commercial castings and vibrating conveyors. Webster's reputation for high-quality products is rooted in a tradition of manufacturing excellence that is based on American materials, American labor and American pride.

LOCATIONS

Our Tiffin headquarters has more than 330,000 square feet of manufacturing space, including a malleable iron foundry, punch press operations, heat-treat facility, machine shop, fabrication department, chain assembly area, an in-plant laboratory and testing facilities. Our two warehousing and assembly locations, located in Meridian, Mississippi, and Portland, Oregon, allow for quick access to over $7 million of inventory, and our three manufacturing facilities stock over 250,000 feet of chain to quickly meet our customers' needs.

VERTICAL INTEGRATION

While many companies are relying increasingly on outsourcing for production needs, Webster Industries has invested in building, maintaining and growing a vertically integrated manufacturing system. With full services under one roof at our Tiffin, Ohio, headquarters, Webster offers superior product design, consistent product quality, and the best delivery time in the industry.

FOUNDRY

PUNCHING & STAMPING

MACHINING

HEAT TREAT

CHAIN ASSEMBLY

METAL FABRICATION

American Materials, Labor and Pride.

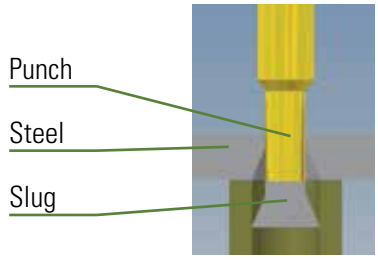
BURNISHED PITCH HOLE ADVANTAGE

Webster Industries utilizes a variety of manufacturing processes to ensure the highest quality solution is delivered to our customers. Burnishing and perfect hole sizing, used in manufacturing the pitch holes of our chains, are two of those processes.

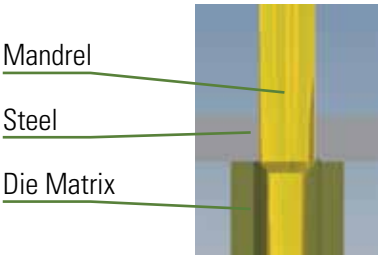
Burnishing is a unique cold-forming process where a graduated mandrel (punch) is used to punch the sidebar pitch holes. First, the punch pierces the sidebar material, producing a heavy tapered slug. The punch rubs the metal surface of the pitch hole with sufficient force to cause plastic flowing of the metal. This rubbing or smearing (burnishing) action of the metal fills the break-out or tapered portion of the hole that was produced during the initial piercing operation.

Webster's burnished holes achieve 85-90% bearing surface. Compared to single-punched holes, burnished holes allow at least 5x more surface against which the pin can rest, resulting in minimized material deformation of the hole under heavy loads.

(Fig. 1)

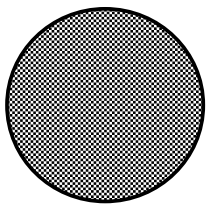


(Fig. 2)



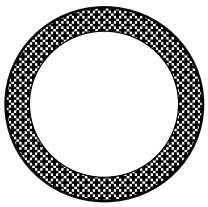
WEBSTER'S INDUCTION HARDENING PROCESS

Induction hardening is a non-contact heating process that utilizes the principle of electromagnetic induction to produce heat inside the surface layer of a workpiece. By placing a conductive material (pin) into a strong alternating magnetic field (coil), electrical current can be made to flow in the material, creating heat. The current generated flows predominantly in the surface layer of the part; the depth of the hardened layer is determined by the frequency of the alternating field, the surface density and permeability of the material, the heat time, and the pin diameter or material thickness. Then, by immersing the part in water, oil, or polymer-based quench, the surface layer is altered to form a martensitic structure which is harder than the base metal. The core of the material remains the same, and its original properties are unaffected by the induction hardening process. All Webster chains designated "WHX" are supplied with IH pins.



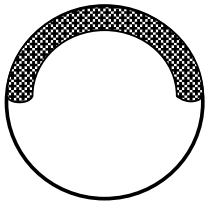
WEBSTER THRU-HARDENED PINS

Webster's pins are made of Duralloy©, thru-hardened to 35/40 Rc where the diameter is less than ¾".



CIRCUMFERENTIAL INDUCTION HARDENING

The load-bearing surface of the thru-hardened pin is induction hardened to 55/60 Rc to the appropriate depth (typically 10% of the body diameter and 360° around the body of the pin). The induction hardened areas extend into the press fit areas of the pin to maintain the integrity of the pin and guard against failure due to pin shear. This also puts the IH stop and start areas under compression, which eliminates potential cracking.



WEBSTER COMPETITORS SELECTIVE INDUCTION HARDENING

Typically, other companies harden only the area that will experience wear. The pin must be oriented properly during assembly to receive the benefit of the induction-hardened surface, and the stop and start area of this induction-hardened zone can promote cracking, ultimately leading to chain failure.

Welded Steel Mill Chains

Welded steel mill chains are designed for rugged, abrasive and demanding environments. The design allows for operating conditions that are less than desirable. Their rugged welded construction permits high speeds, minimal lubrication and easy modification for application specific attachments.

MATERIAL

Sidebars and barrels are medium carbon steel. Pins are medium carbon alloy steel and are thru hardened for maximum chain life. Pins can be induction hardened for even more wear resistance. The WH chains also have thru hardened sidebars and barrels for greater strength and wear resistance. All parts can be furnished with additional heat treatment on request or as the operating environment requires.

ASSEMBLY

Welded steel mill chains are riveted construction with cottered connecting pins. Cottered construction is available on request.

INTERCHANGEABILITY

Welded steel mill chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

Welded steel mill chains are used in wood yards, paper mills, OSB plants, grain systems and ethanol processing. They provide long life with very low maintenance.

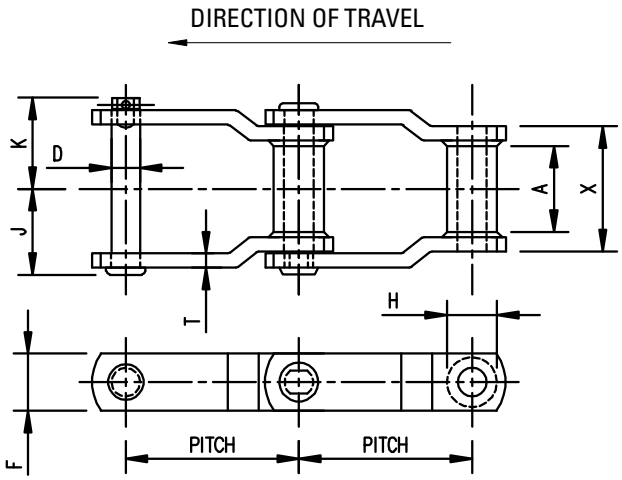
OPERATION

Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

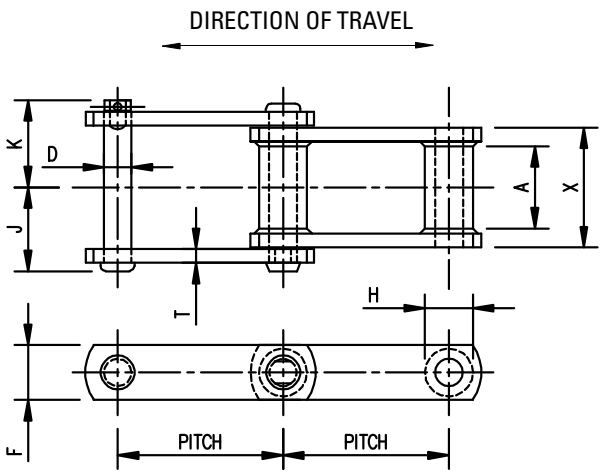
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs. ☆	General Dimensions		
							Length of Bearing	℄ To Cotter End	℄ To Head or Rivet End
							X	K	J
WR78	O	2.609	46	4.0	20,000	3,000	2	1 19/32	1 7/16
WH78	O	2.609	46	4.0	30,000	3,500	2	1 19/32	1 7/16
WHC78	S	2.609	46	4.0	30,000	3,500	2	1 19/32	1 7/16
WH78HD	O	2.636	46	6.5	42,700	3,940	2	1 23/32	1 19/32
WR78-4	O	4.000	30	4.0	25,900	3,000	2	1 19/32	1 7/16
WH78-4	O	4.000	30	4.0	36,000	3,500	2	1 19/32	1 7/16
WR82	O	3.075	39	4.8	25,000	3,800	2 1/4	1 23/32	1 19/32
WH82	O	3.075	39	4.8	36,000	4,400	2 1/4	1 23/32	1 19/32
WHC82	S	3.075	39	4.8	36,000	4,400	2 1/4	1 23/32	1 19/32
WH82HD	O	3.075	39	7.8	68,000	4,900	2 1/4	1 7/8	1 3/4
WH82XHD	O	3.075	39	9.2	62,000	5,900	2 1/4	2 1/32	1 25/32
WR124	O	4.000	30	8.3	47,000	6,200	2 3/4	2 9/32	2 1/32
WH124	O	4.000	30	8.3	69,000	7,200	2 3/4	2 9/32	2 1/32
WHX124	O	4.000	30	8.3	69,000	7,200	2 3/4	2 9/32	2 1/32
WHC124	S	4.000	30	8.3	69,000	7,200	2 3/4	2 9/32	2 1/32
WH124HDSPC	O	4.063	30	14.7	100,000	10,500	3	2 17/32	2 3/8
WH124XHD	O	4.063	30	17.4	129,000	11,375	3 1/4	2 13/16	2 5/8
WH144	O	4.000	30	10.5	69,000	9,600	2 3/4	2 9/32	2 3/32
WR111+	O	4.760	26	9.5	52,000	7,500	3 3/8	2 19/32	2 11/32
WH111+	O	4.760	26	9.5	77,000	8,850	3 3/8	2 19/32	2 11/32
WHC111+	S	4.760	26	9.5	77,000	8,850	3 3/8	2 19/32	2 11/32
WH111+HD	O	4.760	26	13.2	77,000	9,500	3 5/8	2 25/32	2 19/32

* Supplied in 10' strands but available up to 40' upon request at no additional cost.

☆ See page A-12 for Service Factor, Table 9, and page A-13 for Speed Factor, Tables 10 and 11 in Webster #400 Master Catalog.



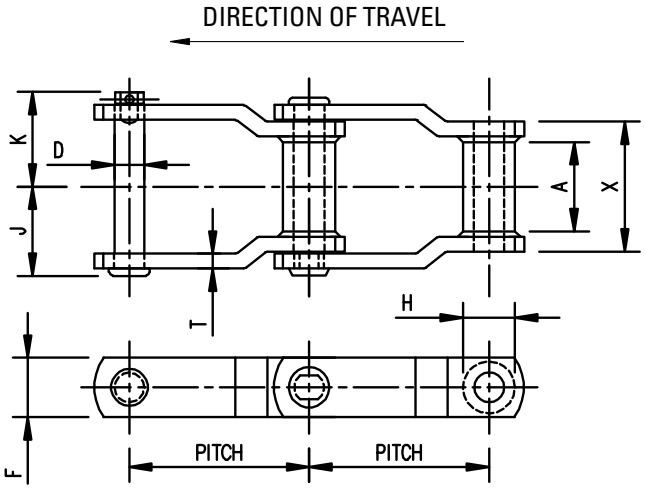
OFFSET STYLE



STRAIGHT STYLE

Abbreviations of Material and Treatment
M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
ALY.I.H. . . . . Alloy Steel, Induction Hardened

Chain No.	Pins		Sidebars			Barrels		Max. Spkt. Width	Common Attachment Numbers
	Dia. D	Material	Thk. T	Height F	Material	Outside Dia. H	Material	A	
WR78	½	ALY.H.T.	¼	1⅛	M.C.	⅞	M.C.	1⅛	A12, A22, F2, F4, G19, H1, H2, K1, K2, RF2, ROOFTOP, RR, SIDE LIFT CHAIR
WH78	½	ALY.H.T.	¼	1⅛	M.C.H.T.	⅞	M.C.H.T.	1⅛	
WHC78	½	ALY.H.T.	¼	1⅛	M.C.H.T.	⅞	M.C.H.T.	1⅛	
WH78HD	9/16	ALY.H.T.	⅜	1¼	M.C.H.T.	1	M.C.H.T.	⅞	K2
WR78-4	½	ALY.H.T.	¼	1¼	M.C.	⅞	M.C.	1⅛	
WH78-4	½	ALY.H.T.	¼	1¼	M.C.H.T.	⅞	M.C.H.T.	1⅛	
WR82	9/16	ALY.H.T.	¼	1¼	M.C.	1 1/16	M.C.	1¼	A22, A42, AD474, F4, H1, H2, K1, K2, RR, SIDE LIFT CHAIR
WH82	9/16	ALY.H.T.	¼	1¼	M.C.H.T.	1 1/16	M.C.H.T.	1¼	
WHC82	9/16	ALY.H.T.	¼	1¼	M.C.H.T.	1 1/16	M.C.H.T.	1¼	
WH82HD	5/8	ALY.H.T.	⅜	1½	M.C.H.T.	1 1/16	M.C.H.T.	1	K1, K2, SIDE LIFT CHAIR
WH82XHD	¾	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1	K2, SIDE LIFT CHAIR
WR124	¾	ALY.H.T.	⅜	1½	M.C.	1¼	M.C.	1½	A22OSB, A27, C CRADLE, F4, K1, K2, RF2, RR, S1, SIDE LIFT CHAIR
WH124	¾	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WHX124	¾	ALY.I.H.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WHC124	¾	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WH124HDSPC	1	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	1½	A22OSB, A & C CRADLE, K2, RF2, SIDE LIFT CHAIR
WH124XHD	1	ALY.H.T.	5/8	2	M.C.H.T.	1¾	M.C.H.T.	1½	A22OSB, C CRADLE, SIDE LIFT CHAIR
WH144	1	ALY.H.T.	⅜	1¾	M.C.H.T.	1⅝	M.C.H.T.	1½	A22OSB
WR111+	¾	ALY.H.T.	⅜	1¾	M.C.	1¼	M.C.	2	A & C CRADLE, K1, K2
WH111+	¾	ALY.H.T.	⅜	1¾	M.C.H.T.	1¼	M.C.H.T.	2	A & C CRADLE, K1, K2
WHC111+	¾	ALY.H.T.	⅜	1¾	M.C.H.T.	1¼	M.C.H.T.	2	
WH111+HD	¾	ALY.H.T.	½	2	M.C.H.T.	1 7/16	M.C.H.T.	2	



OFFSET STYLE

Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs. ☆	General Dimensions		
							Length of Bearing	℄ To Cotter End	℄ To Head or Rivet End
							X	K	J
WR110	O	6.000	20	7.2	47,000	6,750	3	2 11/32	2 5/32
WH110	O	6.000	20	7.2	69,000	7,875	3	2 11/32	2 5/32
WR106	O	6.000	20	7.0	47,000	6,200	2 3/4	2 9/32	2 1/32
WH106	O	6.000	20	7.0	69,000	7,200	2 3/4	2 9/32	2 1/32
WHX106	O	6.000	20	7.0	69,000	7,200	2 3/4	2 9/32	2 1/32
WHC106	S	6.000	20	7.0	69,000	7,200	2 3/4	2 9/32	2 1/32
WH106HD	O	6.000	20	9.0	92,500	7,875	3	2 1/2	2 5/16
WH106XHD	O	6.050	20	11.8	115,000	10,500	3	2 17/32	2 3/8
WH166	O	6.000	20	8.5	69,000	9,600	2 3/4	2 9/32	2 3/32
WR132	O	6.050	20	14.2	78,000	13,000	4 3/8	3 7/32	3 1/16
WH132	O	6.050	20	14.2	115,000	15,300	4 3/8	3 7/32	3 1/16
WHX132	O	6.050	20	14.2	115,000	15,300	4 3/8	3 7/32	3 1/16
WHC132	S	6.050	20	14.2	115,000	15,300	4 3/8	3 7/32	3 1/16
WH132HD	O	6.050	20	16.4	152,000	16,200	4 5/8	3 1/2	3 5/16
WH132XHD	O	6.050	20	18.6	182,000	17,000	4 7/8	3 3/4	3 1/2
WR150	O	6.050	20	16.8	78,000	13,000	4 3/8	3 7/32	3 1/16
WH150	O	6.050	20	16.8	116,000	15,300	4 3/8	3 7/32	3 1/16
WHX150	O	6.050	20	16.8	116,000	15,300	4 3/8	3 7/32	3 1/16
WH150HD	O	6.050	20	19.3	168,000	16,200	4 5/8	3 1/2	3 5/16
WH157	O	6.050	20	20.6	161,000	18,200	4 5/8	3 9/16	3 3/8
WHX157	O	6.050	20	20.6	161,000	18,200	4 5/8	3 9/16	3 3/8
WHC157	S	6.050	20	20.6	161,000	18,200	4 5/8	3 9/16	3 3/8
WHX157XHD	O	6.050	20	23.7	200,000	33,000	4 5/8	3 9/16	3 5/16
WHX155	O	6.050	20	19.0	145,000	17,750	4 1/2	3 1/2	3 3/8
WHX200	O	6.050	20	22.0	190,000	20,225	4 5/8	3 9/16	3 5/16
WHX159	O	6.125	20	26.5	230,000	20,250	4 5/8	3 9/16	3 5/16
WHX2012A	O	12.000	10	15.6	200,000	33,000	4 5/8	3 9/16	3 5/16
WHX3012	O	12.000	10	18.2	200,000	33,000	4 5/8	3 9/16	3 5/16

* Supplied in 10' strands but available up to 40' upon request at no additional cost.

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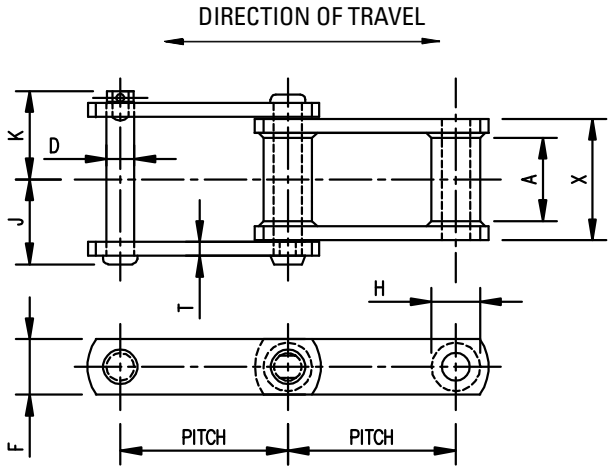

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ALY.H.T. . . . . Alloy Steel, Heat Treated
ALY.I.H. . . . . Alloy Steel, Induction Hardened

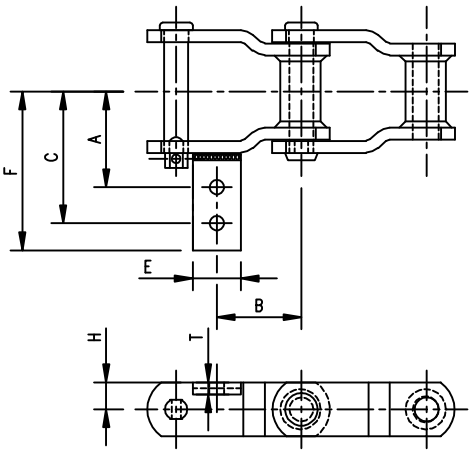
Chain No.	Pins		Sidebars			Barrels		Max. Spkt. Width	Common Attachment Numbers
	Dia. D	Material	Thk. T	Height F	Material	Outside Dia. H	Material	A	
WR110	¾	ALY.H.T.	⅜	1½	M.C.	1¼	M.C.	1¾	K2
WH110	¾	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1¾	K2
WR106	¾	ALY.H.T.	⅜	1½	M.C.	1¼	M.C.	1½	A22OSB, C CRADLE, K2
WH106	¾	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	A22OSB, C CRADLE, K2
WHX106	¾	ALY.I.H.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	A22OSB, C CRADLE, K2
WHC106	¾	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WH106HD	¾	ALY.H.T.	½	1½	M.C.H.T.	1¼	M.C.H.T.	1½	A22OSB
WH106XHD	1	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	1½	A22OSB, C CRADLE
WH166	1	ALY.H.T.	⅜	1¾	M.C.H.T.	1⅝	M.C.H.T.	1½	A22OSB
WR132	1	ALY.H.T.	½	2	M.C.	1¾	M.C.	2¾	A22, A22OSB, A42, A B & C CRADLE, K2, M1, PC47,PETER FLIGHTS, RF3, S1, SIDE LIFT CHAIR
WH132	1	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX132	1	ALY.I.H.	½	2	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHC132	1	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	2¾	
WH132HD	1	ALY.H.T.	⅝	2	M.C.H.T.	1¾	M.C.H.T.	2¾	A22OSB, A42, A & C CRADLE, K2, M1, PETER FLIGHTS, S1
WH132XHD	1	ALY.H.T.	¾	2	M.C.H.T.	1¾	M.C.H.T.	2¾	C CRADLE
WR150	1	ALY.H.T.	½	2½	M.C.	1¾	M.C.	2¾	C CRADLE, K2, M1, RF3, RF12, RF18, S1
WH150	1	ALY.H.T.	½	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX150	1	ALY.I.H.	½	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WH150HD	1	ALY.H.T.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	A CRADLE
WH157	1⅛	ALY.H.T.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	A42, A & C CRADLE, K2, M1, PETER FLIGHTS, RF12, RF18, S1
WHX157	1⅛	ALY.I.H.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHC157	1⅛	ALY.H.T.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX157XHD	1¼	ALY.I.H.	⅝	3	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX155	1⅛	ALY.I.H.	9/16	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	C CRADLE, M1
WHX200	1¼	ALY.I.H.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX159	1¼	ALY.I.H.	⅝	3	M.C.H.T.	2	M.C.H.T.	2¾	
WHX2012A	1¼	ALY.I.H.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX3012	1¼	ALY.I.H.	⅝	3	M.C.H.T.	1¾	M.C.H.T.	2¾	

Common Mill Chain Attachments

A12

Chain No.	A	B	C	E	F	H	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	2	1¾	2¾	1	3 5/16	9/16	¼	4.6	¼
WH78	2	1¾	2¾	1	3 5/16	9/16	¼	4.6	¼

Δ Weights of attachments coupled every pitch.



A12

A22

Chain No.	A	B	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	1⅞	1⅝	1	2½	⅜	4.6	⅜
WH78	1⅞	1⅝	1	2½	⅜	4.6	⅜
WR82	2⅛	1⅞	1¼	2 11/16	¼	5.2	⅜
WH82	2⅛	1⅞	1¼	2 11/16	¼	5.2	⅜
WR132	4	3¾	1½	4¾	½	15.0	½
WH132	4	3¾	1½	4¾	½	15.0	½
WHX132	4	3¾	1½	4¾	½	15.0	½

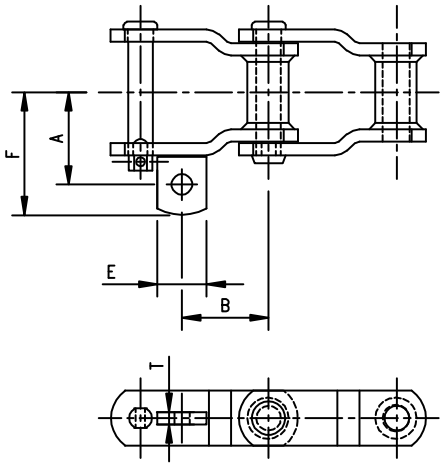
A27

WR124	3	2	1½	3¾	½	9.2	½
WH124	3	2	1½	3¾	½	9.2	½
WHX124	3	2	1½	3¾	½	9.2	½

A42

WR82	3⅝	1⅞	1½	3¼	½	6.2	⅝
WH82	3⅝	1⅞	1½	3¼	½	6.2	⅝
WR132	4½	3 1/32	2½	5¾	¾	16.8	⅞
WH132	4½	3 1/32	2½	5¾	¾	16.8	⅞
WHX132	4½	3 1/32	2½	5¾	¾	16.8	⅞
WH132HD	4⅝	3¾	2	5⅞	¾	18.7	¾
WH157	5¼	3	2¼	6⅜	¾	23.9	1
WHX157	5¼	3	2¼	6⅜	¾	23.9	1

Δ Weights of attachments coupled every pitch.

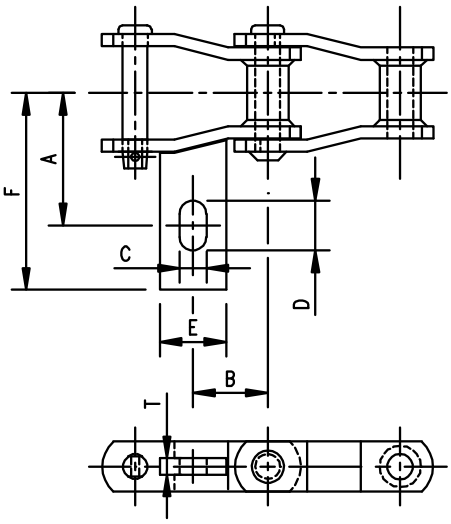


A22, A27 and A42

A220SB

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR124	4	2¼	13/16	1½	2	5 15/16	½	11.9	¾
WH124	4	2¼	13/16	1½	2	5 15/16	½	11.9	¾
WHX124	4	2¼	13/16	1½	2	5 15/16	½	11.9	¾
WH124HDSPC	4	2 1/32	13/16	1½	2½	5 15/16	½	18.8	¾
WH124XHD	4½	2 5/16	13/16	1½	2	6	⅝	21.5	¾
WR106	4	3½	13/16	1½	3	6	½	10.4	¾
WH106	4	3½	13/16	1½	3	6	½	10.4	¾
WHX106	4	3½	13/16	1½	3	6	½	10.4	¾
WH106HD	4	3	13/16	1½	3	5 15/16	⅝	12.0	¾
WH106XHD	4	3¼	13/16	1½	3	6	½	14.9	¾
WR132	4½	3 1/16	13/16	1½	2	6¼	½	16.3	¾
WH132	4½	3 1/16	13/16	1½	2	6¼	½	16.3	¾
WHX132	4½	3 1/16	13/16	1½	2	6¼	½	16.3	¾
WH132HD	5½	3 1/16	13/16	1½	2	6¾	1	19.2	¾
WH144	4	2	13/16	1½	2	5 15/16	½	13.8	¾
WH166	4	3½	13/16	1½	2½	6	½	11.3	¾

Δ Weights of attachments coupled every pitch.

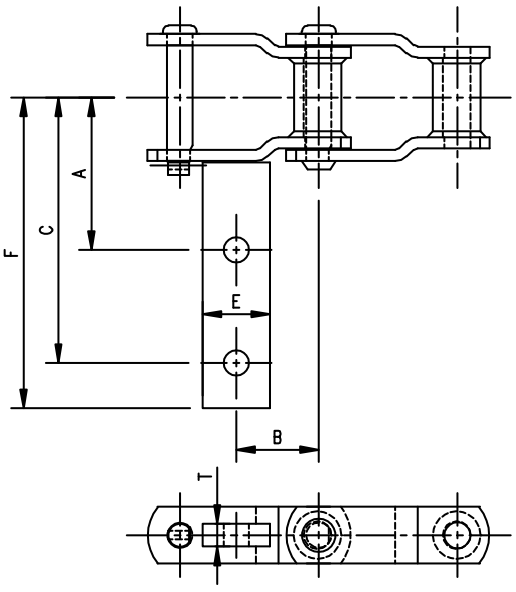


A220SB

AD474

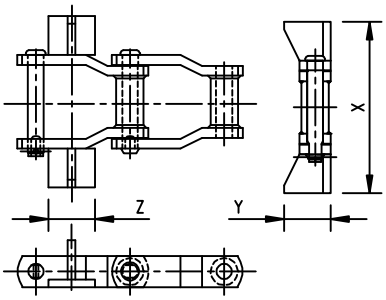
Chain No.	A	B	C	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR82	3⅜	1 13/16	5⅞	1½	6⅞	½	9.2	½
WH82	3⅜	1 13/16	5⅞	1½	6⅞	½	9.2	½

Δ Weights of attachments coupled every pitch.

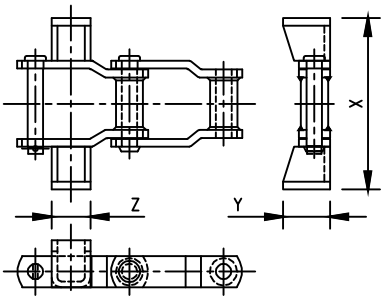


AD474

Common Mill Chain Attachments



STYLE A



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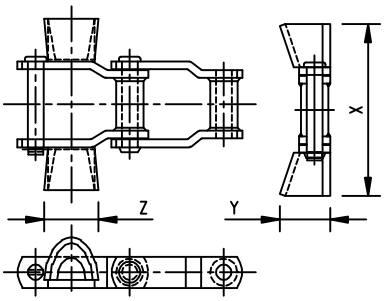
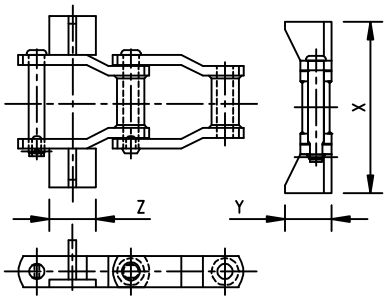


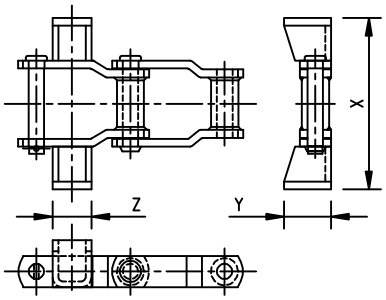
STYLE C

CRADLES

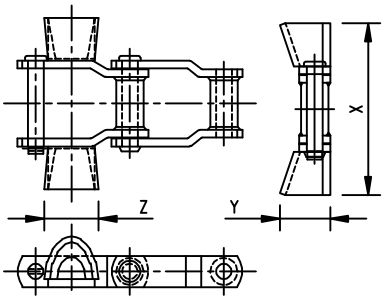
Chain No.	Style A Dimensions				Style B Dimensions				Style C Dimensions			
	X	Y	Z	Weight Per Pair-Lbs.	X	Y	Z	Weight Per Pair-Lbs.	X	Y	Z	Weight Per Pair-Lbs.
WR106	—	—	—	—	—	—	—	—	8	2½	3	4.0
WH106	—	—	—	—	—	—	—	—	8	2½	3	4.0
WHX106	—	—	—	—	—	—	—	—	8	2½	3	4.0
WR111+	—	—	—	—	—	—	—	—	8	2⅝	2½	4.0
WH111+	—	—	—	—	—	—	—	—	8	2⅝	2½	4.0
WR124	—	—	—	—	—	—	—	—	8	2½	2½	4.0
WH124	—	—	—	—	—	—	—	—	8	2½	2½	4.0
WHX124	—	—	—	—	—	—	—	—	8	2½	2½	4.0
WH124HDSPC	8	2⅞	2¼	2.5	—	—	—	—	8	3	2½	5.0
WR124	—	—	—	—	—	—	—	—	9	2½	2½	4.5
WH124	—	—	—	—	—	—	—	—	9	2½	2½	4.5
WHX124	—	—	—	—	—	—	—	—	9	2½	2½	4.5
WH124HDSPC	10	3	2	5.0	—	—	—	—	—	—	—	—
WR111+	10¼	3	1¾	6.0	—	—	—	—	—	—	—	—
WH111+	10¼	3	1¾	6.0	—	—	—	—	—	—	—	—
WR111+	—	—	—	—	—	—	—	—	11	2 13/16	2⅝	6.5
WH111+	—	—	—	—	—	—	—	—	11	2 13/16	2⅝	6.5
WR111+	11½	2½	2½	5.0	—	—	—	—	—	—	—	—
WH111+	11½	2½	2½	5.0	—	—	—	—	—	—	—	—
WR124	—	—	—	—	—	—	—	—	11	2½	2½	6.0
WH124	—	—	—	—	—	—	—	—	11	2½	2½	6.0
WHX124	—	—	—	—	—	—	—	—	11	2½	2½	6.0
WH124XHD	—	—	—	—	—	—	—	—	11	3¼	2½	7.0
WR132	11	3	3	6.0	11	3	2½	6.0	11	3¼	3½	6.0
WH132	11	3	3	6.0	11	3	2½	6.0	11	3¼	3½	6.0
WHX132	11	3	3	6.0	11	3	2½	6.0	11	3¼	3½	6.0
WH132HD	11	3	3	6.0	—	—	—	—	11	3¼	3½	8.0
WH132XHD	—	—	—	—	—	—	—	—	11	3¼	3½	8.0
WR150	—	—	—	—	—	—	—	—	11	3¼	3½	8.0
WH150	—	—	—	—	—	—	—	—	11	3¼	3½	8.0
WHX150	—	—	—	—	—	—	—	—	11	3¼	3½	8.0
WH150HD	11	3½	2½	6.0	—	—	—	—	—	—	—	—



STYLE A



STYLE B



STYLE C

CRADLES

Chain No.	Style A Dimensions				Style B Dimensions				Style C Dimensions			
	X	Y	Z	Weight Per Pair-Lbs.	X	Y	Z	Weight Per Pair-Lbs.	X	Y	Z	Weight Per Pair-Lbs.
WHX155	—	—	—	—	—	—	—	—	11	3½	3½	8.0
WH157	11	3½	2½	10.0	—	—	—	—	11	3½	3½	8.0
WHX157	11	3½	2½	10.0	—	—	—	—	11	3½	3½	8.0
WH106XHD	—	—	—	—	—	—	—	—	12	3½	3½	12.0
WH157	—	—	—	—	—	—	—	—	12	3½	3½	9.0
WHX157	—	—	—	—	—	—	—	—	12	3½	3½	9.0
WR111+	—	—	—	—	—	—	—	—	13	3	2¾	10.0
WH111+	—	—	—	—	—	—	—	—	13	3	2¾	10.0
WR132	—	—	—	—	13	3	2½	7.5	13	3½	3¾	9.0
WH132	—	—	—	—	13	3	2½	7.5	13	3½	3¾	9.0
WHX132	—	—	—	—	13	3	2½	7.5	13	3½	3¾	9.0
WH132HD	—	—	—	—	—	—	—	—	13	3½	3½	9.0
WH132XHD	—	—	—	—	—	—	—	—	13	3½	3½	11.0
WR150	—	—	—	—	—	—	—	—	13	3½	3¾	9.0
WH150	—	—	—	—	—	—	—	—	13	3½	3¾	9.0
WHX150	—	—	—	—	—	—	—	—	13	3½	3¾	9.0
WH157	—	—	—	—	—	—	—	—	13	4	3½	12.0
WHX157	—	—	—	—	—	—	—	—	13	4	3½	12.0
WR111+	—	—	—	—	—	—	—	—	14	3⅛	2⅞	11.0
WH111+	—	—	—	—	—	—	—	—	14	3⅛	2⅞	11.0
WH124HDSPC	15⅛	3½	2	14.5	—	—	—	—	—	—	—	—
WR132	—	—	—	—	—	—	—	—	15	3¾	3⅝	10.0
WH132	—	—	—	—	—	—	—	—	15	3¾	3⅝	10.0
WHX132	—	—	—	—	—	—	—	—	15	3¾	3⅝	10.0
WH132HD	—	—	—	—	—	—	—	—	15	3¾	3½	10.0
WHX155	—	—	—	—	—	—	—	—	16	4	4	10.0
WHX155	—	—	—	—	—	—	—	—	17	4	4	22.0
WH157	—	—	—	—	—	—	—	—	17	4¼	4	20.0
WHX157	—	—	—	—	—	—	—	—	17	4¼	4	20.0
WR132	—	—	—	—	—	—	—	—	18	3½	3¾	15.0
WH132	—	—	—	—	—	—	—	—	18	3½	3¾	15.0
WHX132	—	—	—	—	—	—	—	—	18	3½	3¾	15.0
WHX155	—	—	—	—	—	—	—	—	19	4½	4	21.0

Common Mill Chain Attachments

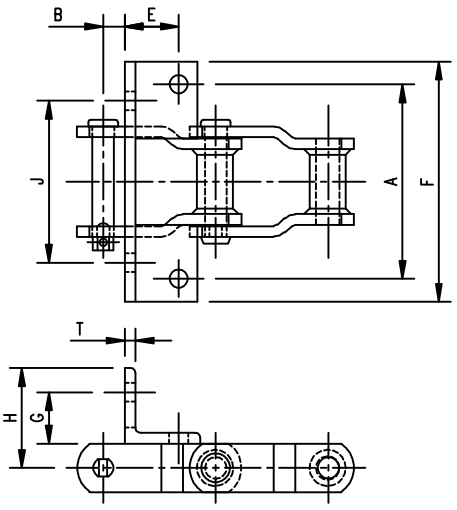
F2

Chain No.	A	B	E	F	G	H	J	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	—	½	—	4 11/16	⅞	2 5/16	3¾	¼	7.6	⅜
WH78	—	½	—	4 11/16	⅞	2 5/16	3¾	¼	7.6	⅜

F4

WR78	4½	½	1¼	5 9/16	1 3/16	2 5/16	3¾	¼	8.6	⅜
WH78	4½	½	1¼	5 9/16	1 3/16	2 5/16	3¾	¼	8.6	⅜
WR82	5	13/16	1⅛	5 15/16	1 3/16	2⅜	4⅛	¼	8.9	⅜
WH82	5	13/16	1⅛	5 15/16	1 3/16	2⅜	4⅛	¼	8.9	⅜
WR124	5¼	⅞	1 7/16	6 3/16	1 5/16	2¾	4⅜	⅜	14.0	⅜
WH124	5¼	⅞	1 7/16	6 3/16	1 5/16	2¾	4⅜	⅜	14.0	⅜
WHX124	5¼	⅞	1 7/16	6 3/16	1 5/16	2¾	4⅜	⅜	14.0	⅜

Δ Weights of attachments coupled every pitch.

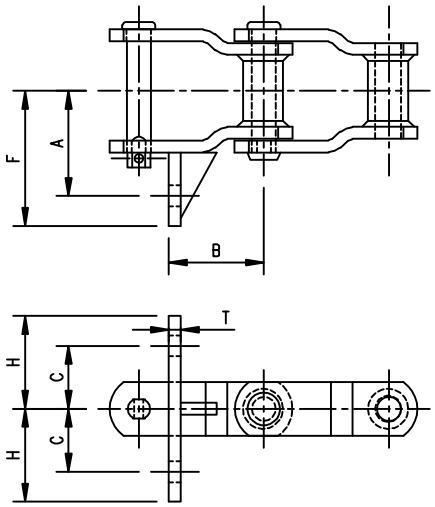


F2 and F4

G19

Chain No.	A	B	C	F	H	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	2 3/16	2	1 5/16	2 13/16	1 15/16	¼	6.3	⅜
WH78	2 3/16	2	1 5/16	2 13/16	1 15/16	¼	6.3	⅜

Δ Weights of attachments coupled every pitch.

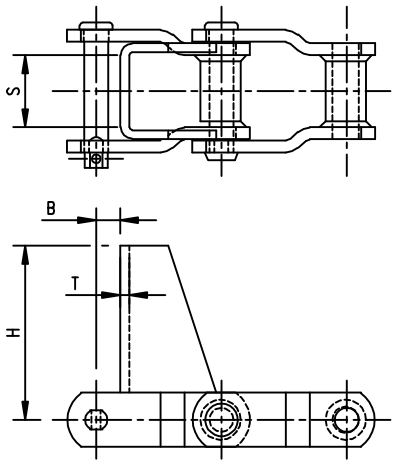


G19

H1

Chain No.	B	H	S	T	Weight Per Foot-Lbs. Δ
WR78	½	3⅝	1½	3/16	7.2
WH78	½	3⅝	1½	3/16	7.2
WR82	⅝	3⅝	1¾	3/16	7.9
WH82	⅝	3⅝	1¾	3/16	7.9

Δ Weights of attachments coupled every pitch.

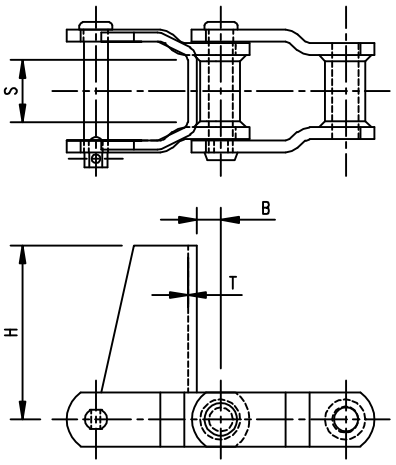


H1

H2

Chain No.	B	H	S	T	Weight Per Foot-Lbs. Δ
WR78	½	3⅝	1½	3/16	7.4
WH78	½	3⅝	1½	3/16	7.4
WR82	⅝	3⅝	1¾	3/16	7.5
WH82	⅝	3⅝	1¾	3/16	7.5

Δ Weights of attachments coupled every pitch.

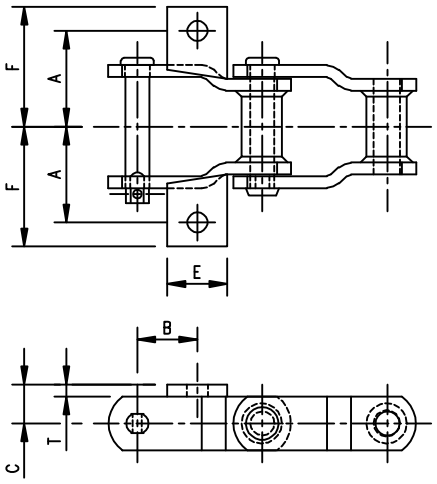


H2

K1

Chain No.	A	B	C	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	2	1¼	13/16	1¼	2½	¼	5.1	⅜
WH78	2	1¼	13/16	1¼	2½	¼	5.1	⅜
WR82	2⅛	1½	⅞	1¾	2¾	¼	6.3	⅜
WH82	2⅛	1½	⅞	1¾	2¾	¼	6.3	⅜
WH82HD	2⅛	1½	1⅛	1¾	2¾	⅜	9.9	⅜
WR124	2⅝	1 13/16	1⅛	2	3¼	⅜	10.6	⅝
WH124	2⅝	1 13/16	1⅛	2	3¼	⅜	10.6	⅝
WHX124	2⅝	1 13/16	1⅛	2	3¼	⅜	10.6	⅝
WR111+	3⅛	2⅜	1¼	2	3⅞	⅜	11.8	½
WH111+	3⅛	2⅜	1¼	2	3⅞	⅜	11.8	½

Δ Weights of attachments coupled every pitch.

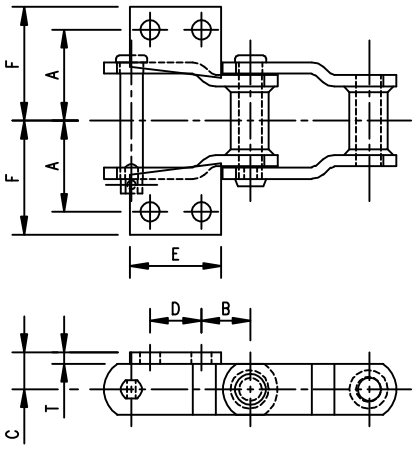


K1

K2

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	2	15/64	13/16	1 1/8	2	2 1/2	1/4	5.8	3/8
WH78	2	15/64	13/16	1 1/8	2	2 1/2	1/4	5.8	3/8
WH78HD	2	13/32	7/8	1 1/8	2	2 1/2	1/4	8.3	3/8
WR82	2 1/8	15/16	15/16	1 1/4	2 1/4	2 3/4	5/16	7.1	3/8
WH82	2 1/8	15/16	15/16	1 1/4	2 1/4	2 3/4	5/16	7.1	3/8
WH82HD	2 1/8	1	1	1 5/16	2 1/4	2 3/4	1/4	10.5	3/8
WH82XHD	2 3/8	1 1/16	1 1/8	1 1/4	2 1/4	2 15/16	3/8	12.4	3/8
WR124	2 5/8	1 3/16	1 1/8	1 15/16	3	3 1/2	3/8	12.1	3/8
WH124	2 5/8	1 3/16	1 1/8	1 15/16	3	3 1/2	3/8	12.1	3/8
WHX124	2 5/8	1 3/16	1 1/8	1 15/16	3	3 1/2	3/8	12.1	3/8
WH124HDSPC	2 5/8	1 13/16	1 1/2	1 15/16	4	3 3/8	1/2	20.7	1/2
WR111+	3 1/8	1 13/32	1 1/4	2 5/16	3 1/2	3 7/8	3/8	13.2	1/2
WH111+	3 1/8	1 13/32	1 1/4	2 5/16	3 1/2	3 7/8	3/8	13.2	1/2
WR110	2 21/32	2 1/8	1 1/8	1 3/4	3	3 5/16	3/8	9.2	3/8
WH110	2 21/32	2 1/8	1 1/8	1 3/4	3	3 5/16	3/8	9.2	3/8
WR106	2 5/8	2 1/8	1 1/8	1 3/4	3	3 7/16	3/8	9.3	3/8
WH106	2 5/8	2 1/8	1 1/8	1 3/4	3	3 7/16	3/8	9.3	3/8
WHX106	2 5/8	2 1/8	1 1/8	1 3/4	3	3 7/16	3/8	9.3	3/8
WR132	3 3/4	1 21/32	1 1/2	2 3/4	4	4 9/16	1/2	19.0	1/2
WH132	3 3/4	1 21/32	1 1/2	2 3/4	4	4 9/16	1/2	19.0	1/2
WHX132	3 3/4	1 21/32	1 1/2	2 3/4	4	4 9/16	1/2	19.0	1/2
WH132HD	3 3/4	1 21/32	1 1/2	2 3/4	4	4 9/16	1/2	21.2	1/2
WR150	3 3/4	1 21/32	1 3/4	2 3/4	4	4 9/16	1/2	21.6	1/2
WH150	3 3/4	1 21/32	1 3/4	2 3/4	4	4 9/16	1/2	21.6	1/2
WHX150	3 3/4	1 21/32	1 3/4	2 3/4	4	4 9/16	1/2	21.6	1/2
WH157	4	1 21/32	1 3/4	2 3/4	4	4 13/16	1/2	26.0	1/2
WHX157	4	1 21/32	1 3/4	2 3/4	4	4 13/16	1/2	26.0	1/2

Δ Weights of attachments coupled every pitch.

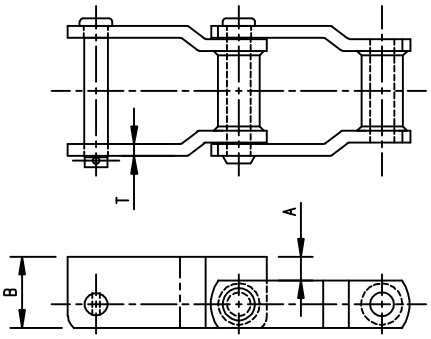


K2

M1

Chain No.	A	B	T	Weight Per Foot-Lbs. Δ
WR132	1	3	1/2	16.6
WH132	1	3	1/2	16.6
WHX132	1	3	1/2	16.6
WH132HD	1	3	5/8	19.4
WR150	1	3 1/2	1/2	19.2
WH150	1	3 1/2	1/2	19.2
WHX150	1	3 1/2	1/2	19.2
WHX155	1	3 1/2	9/16	21.7
WH157	1	3 1/2	5/8	23.6
WHX157	1	3 1/2	5/8	23.6

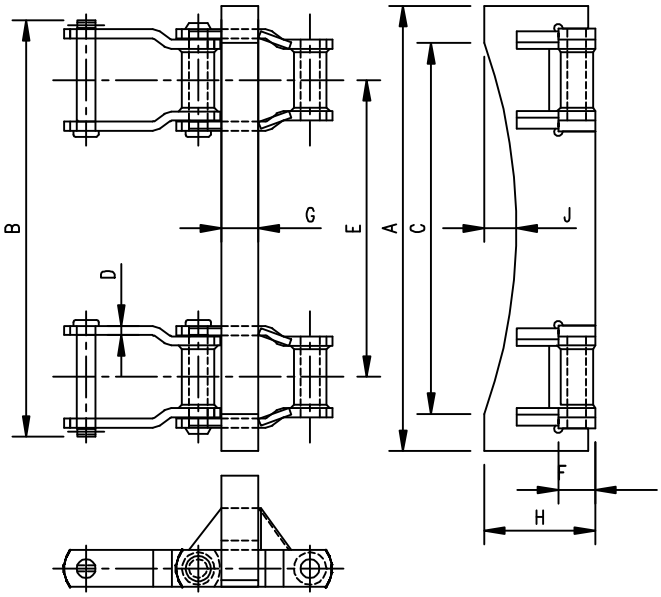
Δ Weights of attachments coupled every pitch.



M1

PC47

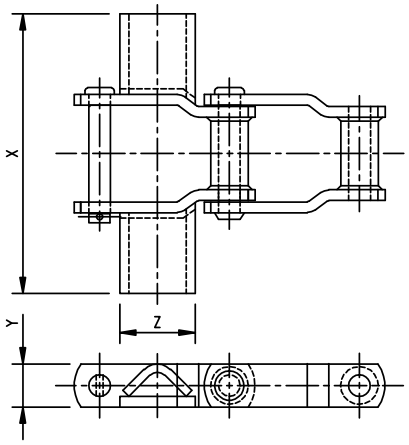
Chain No.	Assembly No.	Min. Spkt. Size	A	B	C	D	E	F	G	H	J	Weight Per Attach.-Lbs.
WH132	PC47-16	9T	18½	16⅜	16	½	10	2	2	6	1¾	50
WHX132	PC47-16	9T	18½	16⅜	16	½	10	2	2	6	1¾	50
WH132	PC47-20	9T	24	22⁷⁄₁₆	20	½	16	2	2	6	1¾	60
WHX132	PC47-20	9T	24	22⁷⁄₁₆	20	½	16	2	2	6	1¾	60



PC47

PETER FLIGHTS

Chain No.	X	Y	Z	Weight Per Pair-Lbs.
WR132	13	2	3½	8.0
WH132	13	2	3½	8.0
WHX132	13	2	3½	8.0
WH132HD	13	2	3½	8.0
WH157	13	2½	3½	9.0
WHX157	13	2½	3½	9.0



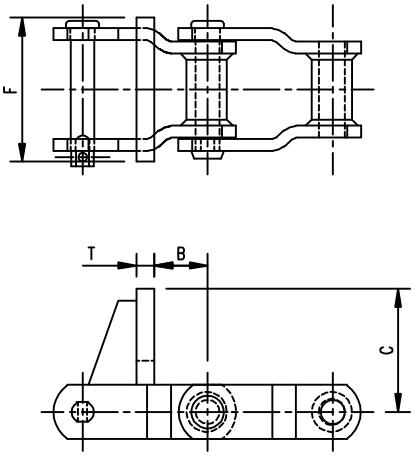
PETER FLIGHTS

Common Mill Chain Attachments

RF2

Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR78	1 3/32	2 9/16	3	3/8	7.8
WH78	1 3/32	2 9/16	3	3/8	7.8
WR124	2	3 1/4	4 1/4	3/8	12.8
WH124	2	3 1/4	4 1/4	3/8	12.8
WHX124	2	3 1/4	4 1/4	3/8	12.8
WH124HDSPC	1 9/16	3 1/2	4 3/4	1	25.7

Δ Weights of attachments coupled every pitch.

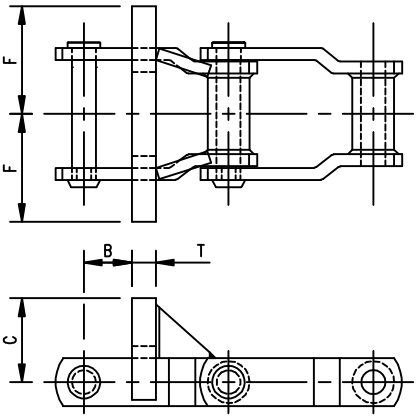


RF2

RF3

Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR132	2	3 1/2	4 1/2	1	31.1
WH132	2	3 1/2	4 1/2	1	31.1
WHX132	2	3 1/2	4 1/2	1	31.1
WR150	2	3 3/4	4 1/2	1	33.7
WH150	2	3 3/4	4 1/2	1	33.7
WHX150	2	3 3/4	4 1/2	1	33.7

Δ Weights of attachments coupled every pitch.

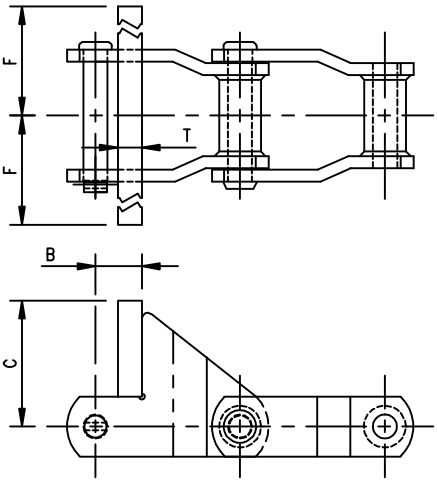


RF3

RF12

Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR150	1 15/16	5 1/4	6	1	48.9
WH150	1 15/16	5 1/4	6	1	48.9
WHX150	1 15/16	5 1/4	6	1	48.9
WH157	1 1/2	5 1/4	6	1 1/2	66.2
WHX157	1 1/2	5 1/4	6	1 1/2	66.2

Δ Weights of attachments coupled every pitch.

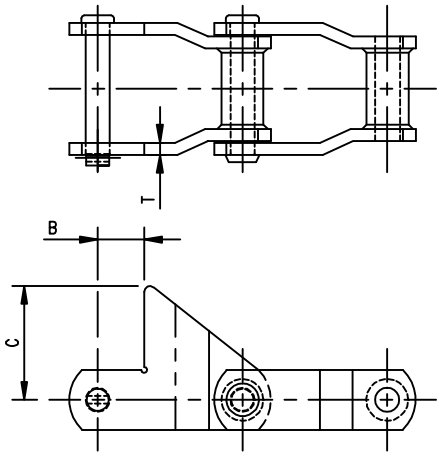


RF12

RF18

Chain No.	B	C	T	Weight Per Foot-Lbs. Δ
WR150	1 15/16	4 3/4	1/2	22.0
WH150	1 15/16	4 3/4	1/2	22.0
WHX150	1 15/16	4 3/4	1/2	22.0
WH157	1 1/2	4 3/4	5/8	27.9
WHX157	1 1/2	4 3/4	5/8	27.9

Δ Weights of attachments coupled every pitch.

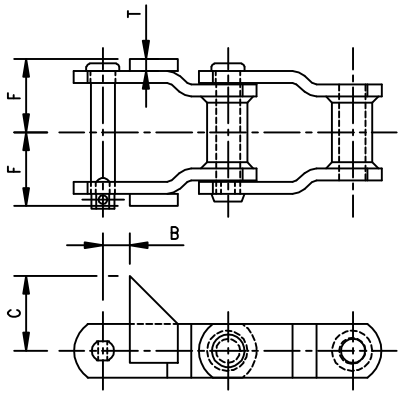


RF18

RR

Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR78	5/8	1 9/16	1	1/4	4.9
WH78	5/8	1 9/16	1	1/4	4.9
WR82	13/16	1 3/4	1 1/8	1/4	5.8
WH82	13/16	1 3/4	1 1/8	1/4	5.8
WR124	1 1/2	1 7/8	1 3/8	3/8	9.5
WH124	1 1/2	1 7/8	1 3/8	3/8	9.5
WHX124	1 1/2	1 7/8	1 3/8	3/8	9.5

Δ Weights of attachments coupled every pitch.

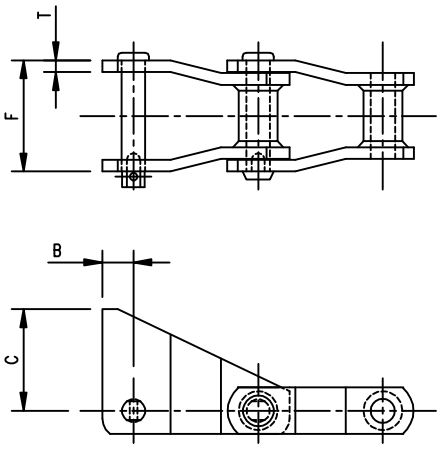


RR

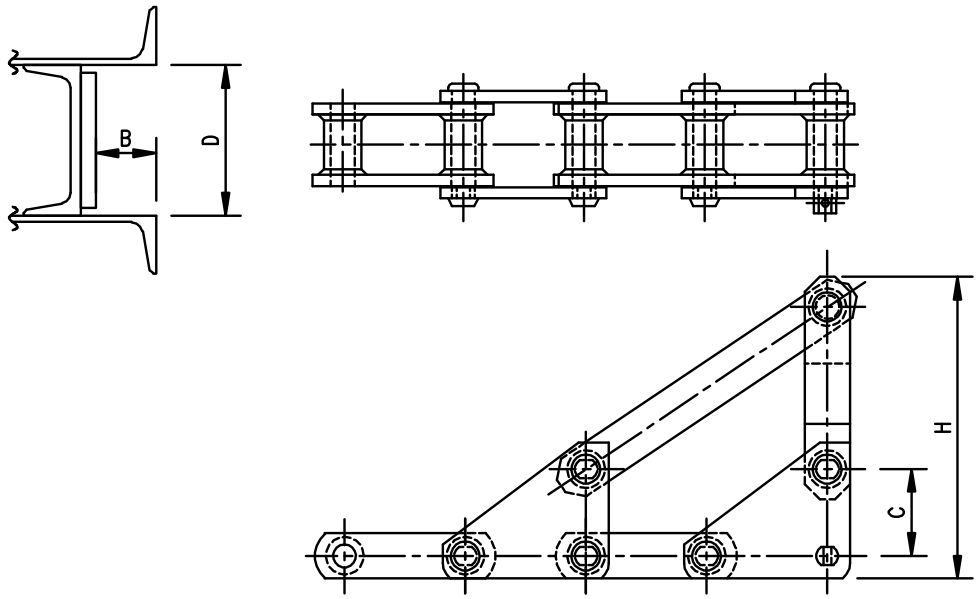
S1

Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR124	1	3 1/4	3 9/16	3/8	21.8
WH124	1	3 1/4	3 9/16	3/8	21.8
WHX124	1	3 1/4	3 9/16	3/8	21.8
WR132	1 3/16	5	5 1/2	1/2	28.5
WH132	1 3/16	5	5 1/2	1/2	28.5
WHX132	1 3/16	5	5 1/2	1/2	28.5
WH132HD	1 3/16	5	6	5/8	34.3
WR150	1 3/16	5 1/4	5 1/2	1/2	34.3
WH150	1 3/16	5 1/4	5 1/2	1/2	34.3
WHX150	1 3/16	5 1/4	5 1/2	1/2	34.3
WH157	1 11/32	3 3/4	6	5/8	36.2
WHX157	1 11/32	3 3/4	6	5/8	36.2

Specify one-piece or welded construction.
Δ Weights of attachments coupled every pitch.



S1



SIDE LIFT CHAIR - HINGED

SIDE LIFT CHAIR - HINGED

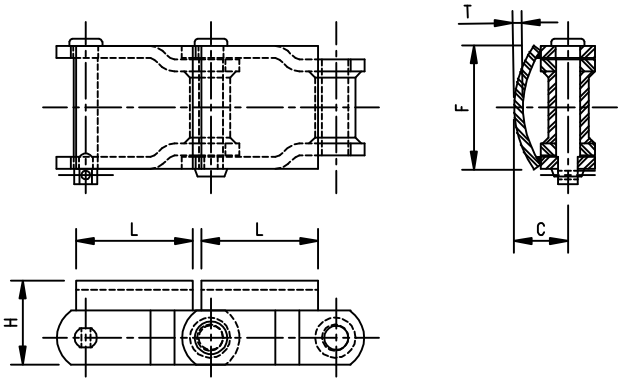
Chain No.	B	C	D	H	Pitches Per Assembly	Min. No. of Spkt. Teeth	Weight Per Chair-Lbs.
WR78	2	1¾	3½	14	7	9	12.0
WH78	2	1¾	3½	14	7	9	12.0
WR82	2	1¾	4	10	5	7	10.0
WH82	2	1¾	4	10	5	7	10.0
WR82	2	1¾	4	12	5	9	11.0
WH82	2	1¾	4	12	5	9	11.0
WH82HD	2	1¾	4½	12	5	9	12.0
WH82HD	2	1¾	4½	14	7	9	14.0
WH82XHD	2	1¾	4½	10	5	7	11.0
WR124	2	2⅛	5	10	4	7	11.0
WH124	2	2⅛	5	10	4	7	11.0
WHX124	2	2⅛	5	10	4	7	11.0
WR124	2	2⅛	5	12	4	7	13.0
WH124	2	2⅛	5	12	4	7	13.0
WHX124	2	2⅛	5	12	4	7	13.0
WH124HDSPC	2	2½	5½	10	4	7	20.0
WH124XHD	2	3	6¼	10	4	7	26.0
WR132	2½	3¾	6	12	4	8	40.0
WH132	2½	3¾	6	12	4	8	40.0
WHX132	2½	3¾	6	12	4	8	40.0

B and D dimensions are recommended trough sizes.
The height of chair depends on angle of lift and maximum diameter of logs.

UNIVERSAL ROOFTOP TRANSFER CHAIN

Chain No.	C	F	H	L	T	Weight Per Foot-Lbs. Δ
WR78	1 3/16	2 9/16	1 3/4	2 7/16	3/16	5.7
WH78	1 3/16	2 9/16	1 3/4	2 7/16	3/16	5.7

Low tooth profile sprockets must be used with this chain.
Δ Weights of attachments coupled every pitch.

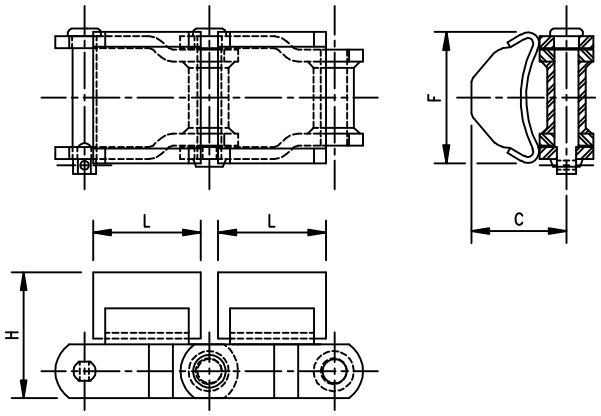


UNIVERSAL ROOFTOP TRANSFER CHAIN

RUBBER ROOFTOP TRANSFER CHAIN

Chain No.	C	F	H	L	Weight Per Foot-Lbs. Δ
WR78	2 1/16	2 3/4	2 5/8	2 7/16	7.0
WH78	2 1/16	2 3/4	2 5/8	2 7/16	7.0

Low tooth profile sprockets must be used with this chain.
Δ Weights of attachments coupled every pitch.

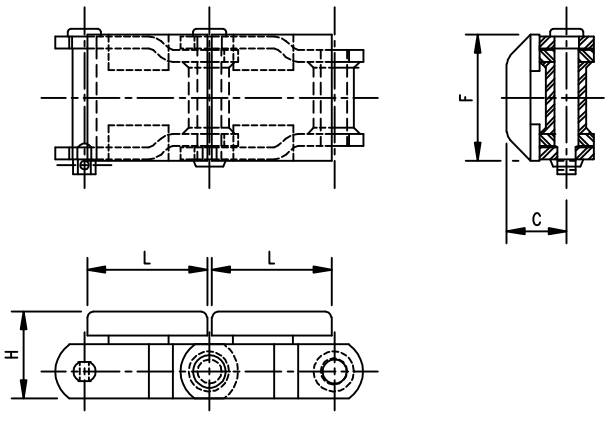


RUBBER ROOFTOP TRANSFER CHAIN

UHMW ROOFTOP TRANSFER CHAIN

Chain No.	C	F	H	L	Weight Per Foot-Lbs. Δ
WR78	1 1/4	2 5/8	1 13/16	2 1/2	4.8
WH78	1 1/4	2 5/8	1 13/16	2 1/2	4.8

Low tooth profile sprockets must be used with this chain.
Δ Weights of attachments coupled every pitch.



UHMW ROOFTOP TRANSFER CHAIN

Welded Steel Drag Chains

Welded steel drag chains are designed for drag conveyors where rugged and demanding environments exist. Webster's unique two-piece welded barrel offers better scraping action as well as double thickness at the wear points. The rugged welded construction permits high speeds, minimal lubrication and easy modification for application specific attachments. These chains are available in reverse barrel design.

MATERIAL

Sidebars are medium carbon steel. Barrels are low carbon steel. Pins are medium carbon steel and are thru hardened for maximum chain life. The WDH chains also have thru hardened sidebars for greater strength and wear resistance. All parts can be furnished with additional heat treatment on request or as the operating environment requires.

ASSEMBLY

Welded steel drag chains are riveted construction. Cottered connecting pins are available on request as well as complete cottered construction.

INTERCHANGEABILITY

Welded steel drag chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

Welded steel drag chains are used in wood yards, paper mills and OSB plants to convey sawdust, bark and other scraps. They are also used to convey ash or machine chips in powerhouses or machining operations. They provide long life with very low maintenance.

OPERATION

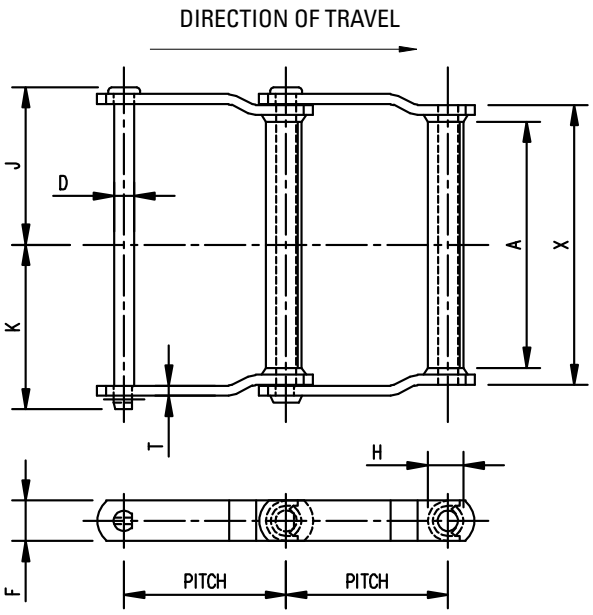
Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions		
						Length of Bearing	℄ To Cotter End	℄ To Head or Rivet End
						X	K	J
WD102	5.000	24	11.8	51,000	8,500	7¾	4 11/16	4 9/16
WDH102	5.000	24	11.8	60,000	10,000	7¾	4 11/16	4 9/16
WD104	6.000	20	8.7	51,000	8,500	5⅜	3 15/32	3 11/32
WDH104	6.000	20	8.7	60,000	10,000	5⅜	3 15/32	3 11/32
WD110	6.000	20	12.0	51,000	8,500	10⅜	6 5/32	5 27/32
WDH110	6.000	20	12.0	60,000	10,000	10⅜	6 5/32	5 27/32
WD113	6.000	20	15.0	55,000	9,200	10⅝	6 5/16	6⅛
WDH113	6.000	20	15.0	70,000	11,700	10⅝	6 5/16	6⅛
WD120	6.000	20	19.4	70,000	11,700	10⅛	6 1/16	5⅞
WDH120	6.000	20	19.4	90,000	15,000	10⅛	6 1/16	5⅞
WDH520	6.000	20	21.0	103,000	17,200	10⅛	6 1/16	5⅞
WD112	8.000	15	9.8	51,000	8,500	10⅜	5 31/32	5 27/32
WDH112	8.000	15	9.8	60,000	10,000	10⅜	5 31/32	5 27/32
WD116	8.000	15	14.5	55,000	9,200	14⅛	7 27/32	7 23/32
WDH116	8.000	15	14.5	69,000	11,500	14⅛	7 27/32	7 23/32
WD118	8.000	15	19.8	70,000	11,700	14⅞	8 7/16	8¼
WDH118	8.000	15	19.8	90,000	15,000	14⅞	8 7/16	8¼
WD122	8.000	15	16.0	70,000	11,700	10⅛	6 1/16	5⅞
WDH122	8.000	15	16.0	90,000	15,000	10⅛	6 1/16	5⅞
WDH522	8.000	15	17.5	103,000	17,200	10⅛	6 1/16	5⅞
WD480	8.000	15	18.1	70,000	11,700	12¾	7⅜	7 3/16
WDH480	8.000	15	18.1	90,000	15,000	12¾	7⅜	7 3/16
WDH580	8.000	15	19.4	123,000	20,500	12¾	7½	7 3/16
WDH680	8.000	15	21.4	134,000	22,300	13	7⅝	7 1/16

Recommended minimum drag chain sprocket diameter is three times the pitch.

* Supplied in 10' strands but available up to 40' upon request at no additional cost.

☆ See page A-12 for Service Factor, Table 9, and page A-13 for Speed Factor, Tables 10 and 11 in Webster #400 Master Catalog.



Abbreviations of Material and Treatment

L.C. . . . . Low Carbon
M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated

Chain No.	Pins		Sidebars			Barrels		Max. Spkt. Width	Common Attachment Numbers
	Dia. D	Material	Thk. T	Height F	Material	Outside Dia. H	Material	A	
WD102	¾	M.C.H.T.	⅜	1½	M.C.	1½	L.C.	6¼	C1, C4, RR, WING
WDH102	¾	M.C.H.T.	⅜	1½	M.C.H.T.	1½	L.C.	6¼	C1, C4, RR, WING
WD104	¾	M.C.H.T.	⅜	1½	M.C.	1½	L.C.	4	C1, C4, RR, WING
WDH104	¾	M.C.H.T.	⅜	1½	M.C.H.T.	1½	L.C.	4	C1, C4, RR, WING
WD110	¾	M.C.H.T.	⅜	1½	M.C.	1½	L.C.	9	C1, C3, C4, RR, WING
WDH110	¾	M.C.H.T.	⅜	1½	M.C.H.T.	1½	L.C.	9	C1, C3, C4, RR, WING
WD113	⅞	M.C.H.T.	½	1½	M.C.	1½	L.C.	9	C3, C4, RR, WING
WDH113	⅞	M.C.H.T.	½	1½	M.C.H.T.	1½	L.C.	9	C3, C4, RR, WING
WD120	⅞	M.C.H.T.	½	2	M.C.	2	L.C.	8½	C3, WING
WDH120	⅞	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	8½	C3, WING
WDH520	1	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	8½	
WD112	¾	M.C.H.T.	⅜	1½	M.C.	1½	L.C.	9	C1, C4, RR, WING
WDH112	¾	M.C.H.T.	⅜	1½	M.C.H.T.	1½	L.C.	9	C1, C4, RR, WING
WD116	¾	M.C.H.T.	⅜	1¾	M.C.	1¾	L.C.	12¾	C1, C3, C4, RR, WING
WDH116	¾	M.C.H.T.	⅜	1¾	M.C.H.T.	1¾	L.C.	12¾	C1, C3, C4, RR, WING
WD118	⅞	M.C.H.T.	½	2	M.C.	2	L.C.	13¼	C3, RR, WING
WDH118	⅞	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	13¼	C3, RR, WING
WD122	⅞	M.C.H.T.	½	2	M.C.	2	L.C.	8½	WING
WDH122	⅞	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	8½	WING
WDH522	1	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	8½	
WD480	⅞	M.C.H.T.	½	2	M.C.	2	L.C.	11	C1, C3, C4, RR, WING
WDH480	⅞	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	11	C1, C3, C4, RR, WING
WDH580	1	M.C.H.T.	½	2	M.C.H.T.	2	L.C.	11	C1, RR
WDH680	1	M.C.H.T.	⅝	2	M.C.H.T.	2	L.C.	11	RR, WING

Recommended minimum drag chain sprocket diameter is three times the pitch.

Welded Steel Heavy-Duty Drag Chains

Welded steel heavy-duty drag chains are manufactured with larger, heftier parts with extra surface area for longer service life. Their rugged welded construction permits higher speeds, minimal lubrication and easy modification for application specific attachments.

MATERIAL

Sidebars, barrels and pins are medium carbon steel which has been thru hardened for maximum chain life. All components can be furnished with additional heat treatment on request or as the operating environment requires.

ASSEMBLY

Welded steel heavy-duty drag chains are riveted construction. Cottered connecting pins are available on request as well as complete cottered construction.

INTERCHANGEABILITY

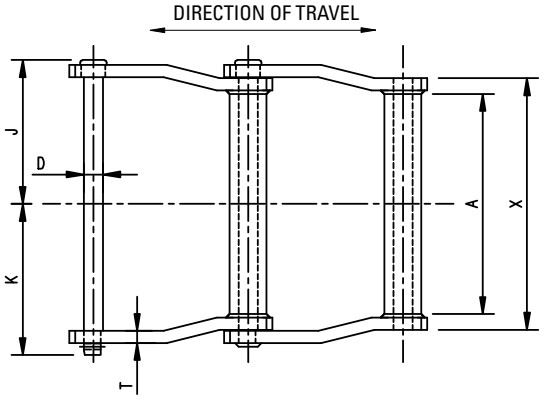
Welded steel heavy-duty drag chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

Welded steel heavy-duty drag chains can be used anywhere that our standard welded steel drag chains are used. This includes wood yards, paper mills, OSB plants and powerhouses. They provide longer life with very low maintenance.

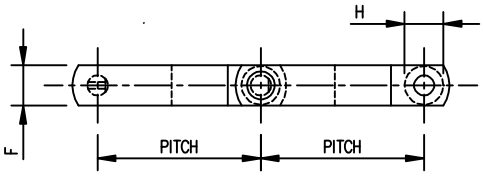
OPERATION

Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.



Abbreviations of Material and Treatment

M.C.H.T. . . . . Medium Carbon, Heat Treated



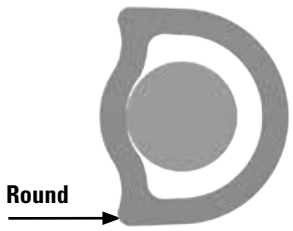
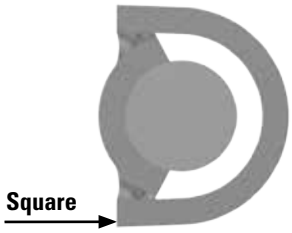
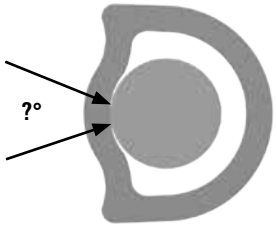
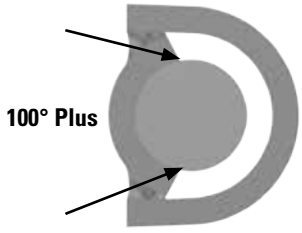
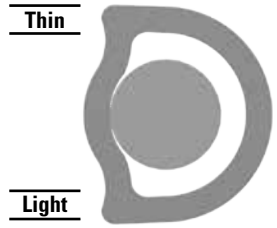
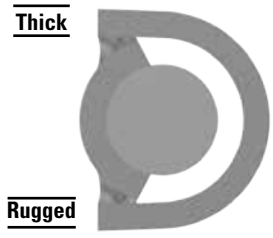
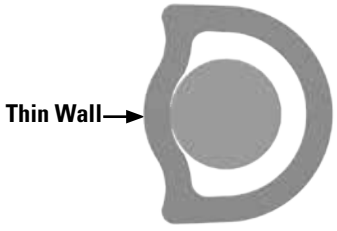
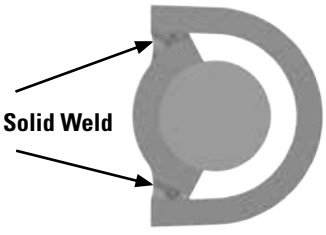
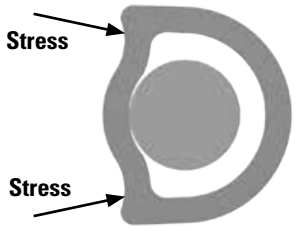
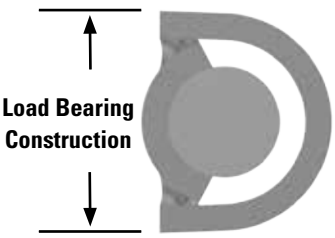
Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions		
						Length of Bearing	℄ To Cotter End	℄ To Head or Rivet End
						X	K	J
WDH118HD	8.00	15	24.5	134,000	22,300	15⅛	8 1⁄16	8½
WDH120HD	6.00	20	24.5	134,000	22,300	10⅜	6 5⁄16	6⅛
WDH122HD	8.00	15	20.5	134,000	22,300	10⅜	6 5⁄16	6⅛
WDH480HD	8.00	15	22.4	134,000	22,300	13	7⅝	7 1⁄16

☆ See page A-12 for Service Factor, Table 9, and page A-13 for Speed Factor, Tables 10 & 11 in Webster #400 Master Catalog.

Chain No.	Pins		Sidebars			Barrels		Max. Spkt. Width	Common Attachment Numbers
	Dia.		Thk.	Height		Outside Dia.			
	D	Material	T	F	Material	H	Material	A	
WDH118HD	1	M.C.H.T.	⅝	2	M.C.H.T.	2	M.C.H.T.	13¼	
WDH120HD	1	M.C.H.T.	⅝	2	M.C.H.T.	2	M.C.H.T.	8½	
WDH122HD	1	M.C.H.T.	⅝	2	M.C.H.T.	2	M.C.H.T.	8½	
WDH480HD	1	M.C.H.T.	⅝	2	M.C.H.T.	2	M.C.H.T.	11	

Barrel Comparison

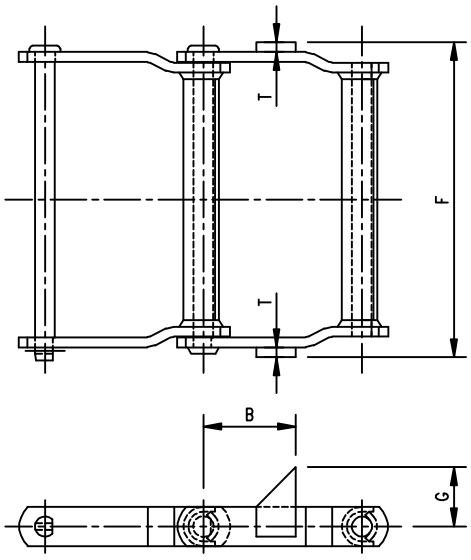
For longer life, look to Webster's two-piece welded barrel.

CROSS SECTION OF A DRAG CHAIN BARREL		Why the exclusive Webster heavy-duty, two-piece welded barrel is your best buy.
Competitor's Formed Tube Barrel	Webster's Two-Piece Welded Barrel	
		**SCRAPING ACTION** The square edge runs flat in the conveyor and will not ride up on the product. This ensures product conveyance despite moisture content.
		**FULL LOAD DISTRIBUTION ON PIN** The Webster two-piece welded barrel wraps around the pin insuring fixed, positive contact with the barrel. The wear is distributed over 100° or more of the pin diameter.
		**DOUBLE THICKNESS, TOP AND BOTTOM** This provides protection at the wear points for longer life even in the harshest loading applications.
		**RIGID TWO-PIECE WELDED CONSTRUCTION** The Webster barrel wraps around the pin, which reduces flexing. This minimizes fatigue failures and increases pin life.
		**IMPACT RESISTANCE** The structure of the Webster two-piece welded barrel can take more vertical load impact without weakening the barrel or causing barrel deformation, which in turn eliminates binding between the barrel and the pin.

Common Drag Chain Attachments

RR

Chain No.	B	F	G	T	Weight Per Pair-Lbs.
WD102/WDH 102	3	9⅜	2¼	⅜	0.6
WD104/WDH 104	3½	7	2¼	⅜	0.6
WD110/WDH 110	3½	12	2¼	⅜	0.6
WD112/WDH 112	3½	12	2¼	⅜	0.6
WD113/WDH 113	3½	12⅝	2¼	⅜	0.6
WD116/WDH 116	4¾	15¾	2⅝	⅜	0.9
WD118/WDH 118	4¾	17	3	½	1.5
WD480/WDH 480	4¾	14⅞	3	½	1.5
WDH580	4¾	14⅞	3	½	1.5
WDH680	4¾	15⅜	3	½	1.5



RR

C1

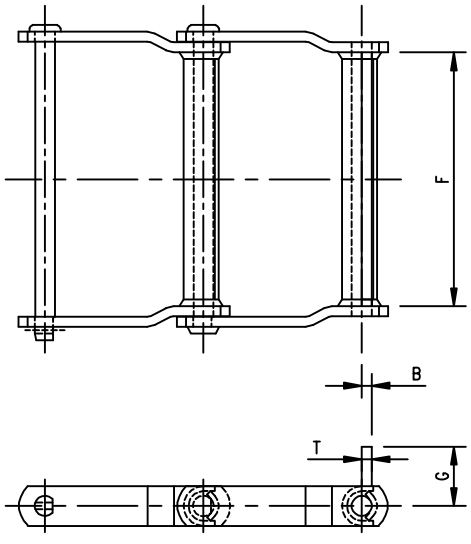
Chain No.	B	F	G	T	Weight Per Attach.-Lbs.
WD102/WDH 102	⅜	6½	2¼	⅜	1.2
WD104/WDH 104	⅜	4⅛	2¼	⅜	0.8
WD110/WDH 110	⅜	9⅛	2¼	⅜	1.6
WD112/WDH 112	⅜	9⅛	2¼	⅜	1.6
WD116/WDH 116	⅜	12⅞	2⅜	⅜	2.2
WD480/WDH 480	½	11¾	2¾	½	3.1
WDH580	½	11¾	2½	½	2.6

C3

WD110/WDH 110	⅜	9⅛	3	⅜	2.4
WD113/WDH 113	½	9⅛	3	½	3.1
WD116/WDH 116	⅜	12⅞	3	⅜	3.1
WD118/WDH 118	½	13¼	3	½	3.9
WD120/WDH 120	½	8⅝	3	½	2.6
WD480/WDH 480	½	11¾	3	½	3.5

C4

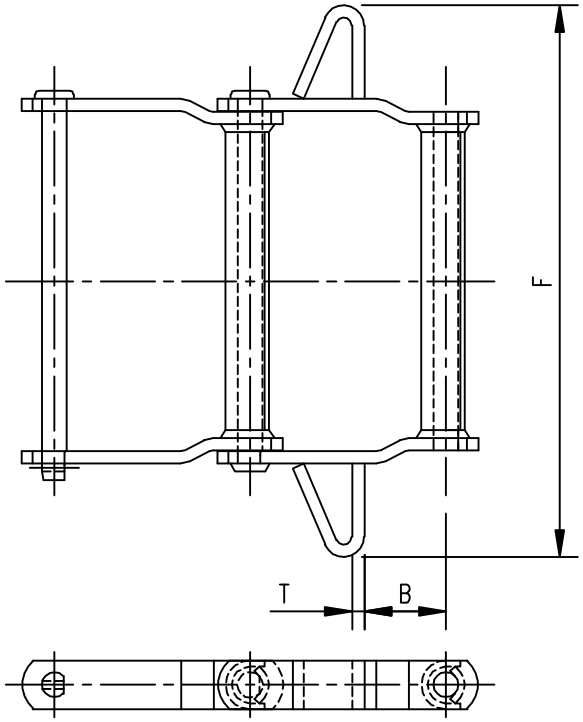
WD102/WDH 102	⅜	6½	3¾	⅜	2.2
WD104/WDH 104	⅜	4⅛	3¾	⅜	1.5
WD110/WDH 110	⅜	9⅛	3¾	⅜	3.1
WD112/WDH 112	⅜	9⅛	3¾	⅜	3.1
WD113/WDH 113	⅜	9⅛	4¾	½	5.4
WD116/WDH 116	⅜	12⅞	4⅞	⅜	5.6
WD480/WDH 480	½	11¾	5	½	7.0



C1, C3 and C4

WING

Chain No.	F	B	T	Weight Per Pair-Lbs.
WD104/WDH104	11	2½	⅜	1.8
WD104/WDH104	12	2½	⅜	2.1
WD102/WDH102	13¼	1¾	⅜	1.8
WD102/WDH102	14⅜	1¾	⅜	2.2
WD110/WDH110	15	2½	⅜	1.4
WD120/WDH120	15	2¾	½	2.4
WD110/WDH110	16	1⅞	⅜	1.8
WD110/WDH110	17	2½	⅜	2.0
WD112/WDH112	17	3¼	⅜	2.0
WD113/WDH113	17	2½	⅜	2.4
WD120/WDH120	17	2½	½	3.6
WD122/WDH122	17	3	½	3.6
WD480/WDH480	17	3	½	2.1
WD480/WDH480	18	3¼	½	2.6
WDH680/WDH680	18	2½	½	2.5
WD110/WDH110	19	2½	⅜	2.7
WD120/WDH120	19	2½	½	4.6
WD480/WDH480	19	3	½	3.2
WD110/WDH110	20	2½	⅜	3.0
WD480/WDH480	20	3	½	3.8
WD110/WDH110	21	2½	⅜	3.3
WD480/WDH480	21	3	½	4.4
WD110/WDH110	22	1⅞	⅜	3.7
WD116/WDH116	22	3	⅜	2.9
WD118/WDH118	22	3	½	3.7
WD120/WDH120	22	2⅛	½	6.2
WD122/WDH122	22	3	½	6.4
WD480/WDH480	22	3	½	5.0
WDH680	22	2½	½	4.9
WD110/WDH110	23	1⅞	⅜	4.0
WD110/WDH110	24	1⅞	⅜	4.3
WD112/WDH112	24	3	⅜	4.3
WD480/WDH480	24	3	½	6.0
WD118/WDH118	25	2¾	½	5.6
WD116/WDH116	28	3	⅜	5.1
WD480/WDH480	26	3	½	7.2
WD480/WDH480	28	2¾	½	8.4
WD116/WDH116	29	3	⅜	5.9
WD118/WDH118	30	2¾	½	8.2
WD480/WDH480	30	2⅝	½	9.5
WD480/WDH480	32	2¾	½	10.5



WING

WEBSTER CONVEYORS

Webster vibrating conveyors have been the leader in servicing sawmills and other forest product applications for over 40 years. Our conveyors are utilized extensively to effectively convey bark, chips, edgings, sawdust, slabs and trim blocks. Webster conveyors are designed to provide spill- and jam-free operation of the long and irregularly shaped sizes of waste common to the forest products industry. The smooth, continuous trough of our conveyors handles this waste with minimal operational maintenance, providing years of reliable service. In addition, Webster conveyors can be fitted with screens to remove small particles from the waste stream; fiberglass or stainless steel section to allow for metal detection or removal; oversize pans, which are designed to catch or turn materials effectively; and transition chutes and spouts to seamlessly feed waste into other conveyors, chippers or hogs. Webster's vibrating conveyors are available in two models, flat spring and coil spring, and both are effective solutions for the tough demands of the forest products industry.

FS SERIES VIBRATING CONVEYORS

FS series conveyors are a cost-effective solution to many conveying applications. FS series conveyors are available in three models, FSL, FSM, and FSH, and all designs incorporate standardized sectional construction. FS conveyors utilize a plastic composite flat spring, which acts both as the spring and a guide arm in the conveyor. These heavy duty flat springs are glass-filament reinforced, which allows for continuous, maintenance-free conveyor operation. In addition, Webster conveyors utilize a positive connected eccentric drive, making them simple, yet rugged, conveyors. Webster models FSL and FSM are designed for light- to medium-duty applications when lower-capacity, smaller-size material handling is required. Usual applications include sawdust, chips and trim blocks. The FSH model is a more robust design, and is capable of handling larger volumes and material sizes. FSH conveyors are often used in handling edgings and slabs, as well as collecting material from other conveyors. The FSH model is also used for screening and metal detection before material is fed into a chipper.

FS series conveyors are designed for simple, efficient field assembly. Each model is designed and manufactured in preassembled sections with jig fixtures. The pans come with bolt flanges between sections to allow for more efficient installation and replacement. The drive sections have been assembled with a timed and tested positive eccentric drive (P3000 FSL, P5000 FSM, and P8000N/P8000W FSH).

FS series conveyors feature fabricated steel pans (standard) and a natural frequency spring system tuned to the conveyor requirements. In addition, Webster can produce custom pan sizes, as needed, to suit any application.

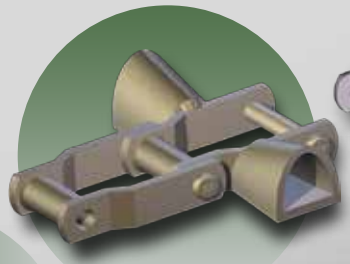
COILWEB® SERIES VIBRATING CONVEYORS

Webster CoilWeb® vibrating conveyors are heavy duty systems that are configured with a broad range of capabilities for the most demanding applications. The CoilWeb® and CoilWeb®-LS models are configured with coil reactor springs with rocker arms and a coil-spring drive, tested and tuned for the application. The CoilWeb® series utilizes the natural frequency principle to efficiently move waste material and minimize power requirements. CoilWeb® conveyors come configured as the standard unbalanced design, balanced, or a combination of balanced and isolated for vibration-sensitive locations.

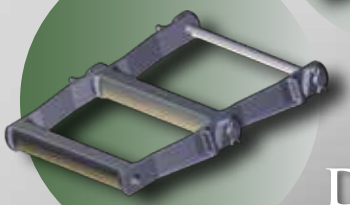
The CoilWeb® series features the use of a coil spring drive connected to the pan. The incorporation of the drive spring substantially lowers the starting and full-load torque requirements in the conveyor. This results in a dramatic horsepower reduction over a positive connected drive. In addition, the coil spring drive allows for much longer conveyor lengths on a single drive.

CoilWeb® conveyors are offered with standard pan sizes and capacities. However, Webster has the capability to build custom sizes to suit each application.

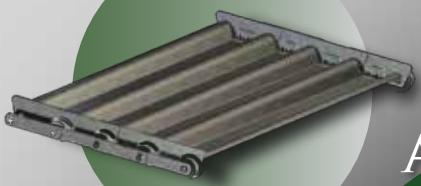
SBR Chain



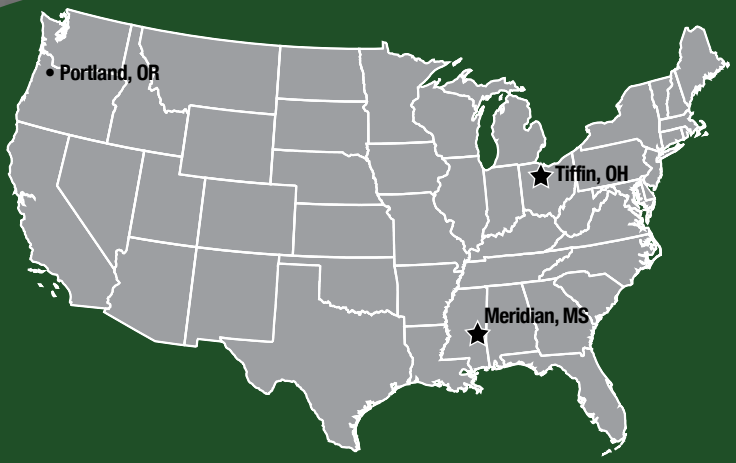
Mill



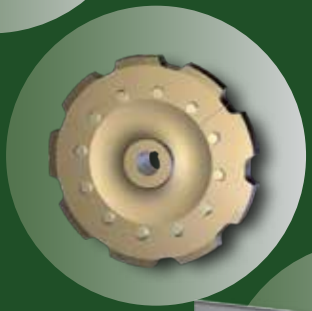
Drag



Apron

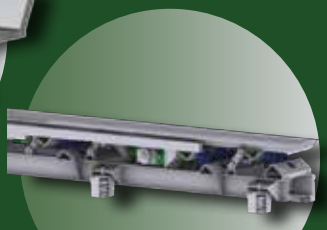


Buckets



Sprockets

FS Vibrating Conveyors



CoilWeb® Vibrating Conveyors

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