

WEBSTER

Master Catalog

WEBSTER QUALITY STATEMENT

"Webster Industries, Inc. will provide superior value to its customers through quality products, continuous improvement, competitive pricing and customer service."

Webster
American Materials, American Labor and American Pride

This catalog covers many of the standard sizes and styles of products we manufacture. Webster's in-house engineering and manufacturing personnel understand high volume production and custom designed chains giving our customers high quality, competitively priced chains specifically suited to each application. For additional support in selecting, identifying or sizing a chain, vibrating conveyor or commercial casting contact our customer service department. It is our goal to earn your business now and in the future. We strive to make your experience one that you will remember as simply the best.

Webster's ISO 9001:2000 Quality Management System registration insures product quality and continuous improvement.

HISTORY

Since 1876 Webster Industries, Inc. has provided conveying solutions to a broad range of markets with a wide variety of products and expertise. Towner K. Webster founded Webster with his "Common Sense" elevator bucket in Chicago, Illinois. In 1907 Webster relocated to Tiffin, Ohio where our corporate headquarters reside today. Over the past century Webster 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 comes from the same principles it was founded on – American materials, American labor and American pride.



LOCATIONS

Our Tiffin headquarters has over 300,000 square feet of manufacturing space and includes a malleable iron foundry, punch press operations, heat treat facility, machine shop, sheet metal fabrication department, chain assembly area, in-plant laboratory and testing facilities. Our two warehousing and assembly locations located in Meridian, Mississippi and Tualatin, Oregon allow for quick distribution throughout North America. Our three manufacturing facilities stock over 250,000 feet of chain to serve our customer requirements.



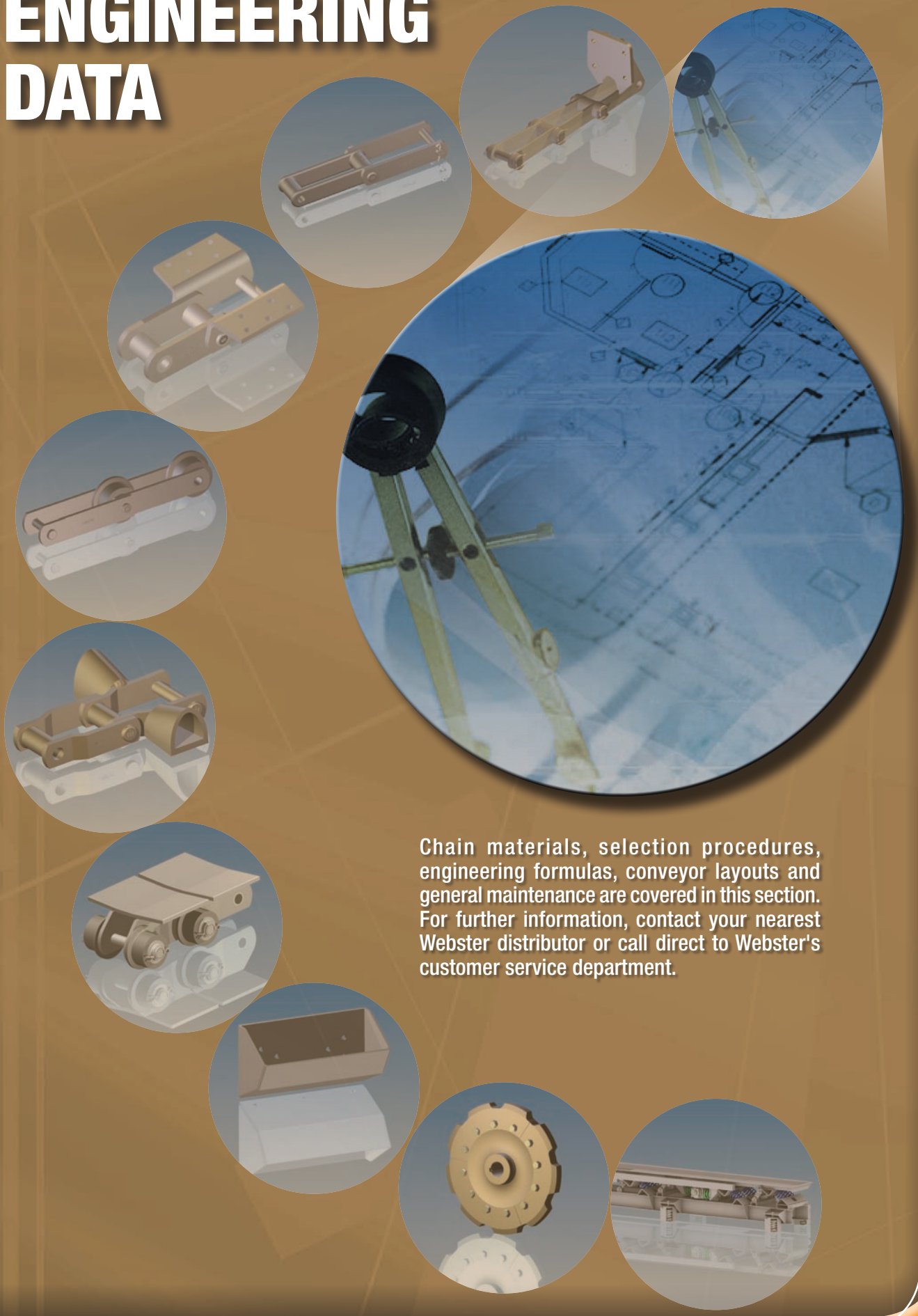
MARKETS

Webster serves a broad range of markets including asphalt, aggregate, ethanol, automotive, food, mining, forest products, steel processing, beef and pork processing, grain, foundry, citrus, sugar, cement, sewage treatment, recycling, demolition debris, construction equipment and numerous others.





ENGINEERING DATA



Chain materials, selection procedures, engineering formulas, conveyor layouts and general maintenance are covered in this section. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

Chain Materials

The information in the Engineering Data section of this catalog is provided as a service to assist the user in the application of Webster products. Webster Industries, Inc. accepts no liability for the use of this information and reserves the right to change or delete parts of this section at any time without notice.

MALLEABLE IRON

Malleable iron was one of the first materials used for cast chains and is still commonly used because of its strength, ductility and relatively low cost. As shown in the photomicrograph, top right, malleable iron is composed of a ferrite matrix (white areas) within which temper carbon nodules (black areas) are distributed. The grain boundaries are clearly visible. This combination produces a tough, ductile and machineable casting which can absorb shock and distortion without failure. Where increased strength and wear resistance is desired, Webster Duramal is recommended.

DURAMAL

Duramal is a heat treated copper bearing malleable iron developed by Webster to provide greater strength, higher hardness and greater wear resistance than that of standard malleable iron. Through special heat treatment of malleable iron, carbon is allowed to migrate from the temper carbon nodules and combine with the ferrite to form a stronger constituent known as martinsite. The photomicrograph, bottom right, shows the fine grain martinsitic matrix of Duramal. Duramal, as shown in the chain charts in Section B, is approximately 25% stronger than standard malleable iron.

Duramal can be used at temperatures up to 1,000° F at reduced working loads.

Duramal is copper bearing and well suited for sewage installations as it has higher strength and greater corrosion resistance.

File Hard Duramal is specially heat treated to secure a high surface hardness that provides excellent wearing qualities for abrasive conditions.

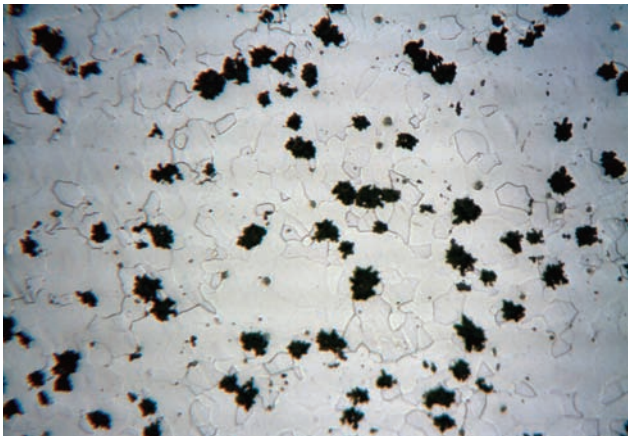
WEBLOY

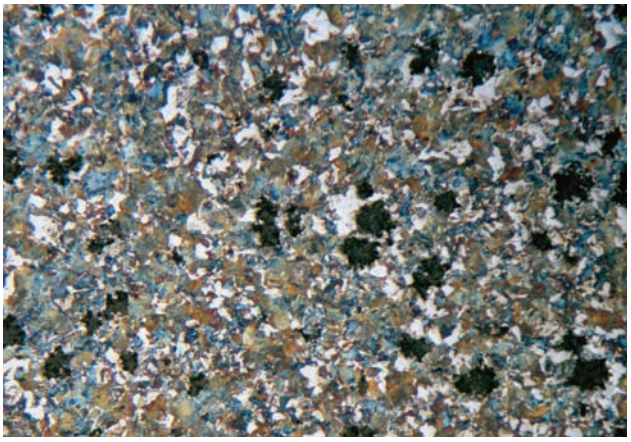
WEBLOY is a white iron alloy containing carbon, silicon, manganese, sulphur and phosphorus. The material content percentages are carefully controlled to produce a material that is extremely hard and long wearing. Chief uses are in applicatons where great resistance to wear and abrasion are required.

STEELS

A variety of steels are used in the manufacture of chain components. The selection depends upon strength and application requirements.

Chain pins are made from medium carbon Duralloy, medium carbon Super Duralloy or medium carbon alloy steels. Pins may be thru hardened or both thru and induction hardened to meet the necessary wear and strength requirements.





Bushings are usually made from low carbon or low carbon alloy steels and are carburized for wear resistance.

Steel rollers are made from either low carbon or low carbon alloy steels, medium carbon or medium carbon alloy steels. Low carbon and low carbon alloy rollers are carburized, while medium carbon and medium carbon alloy rollers are thru hardened and/or induction hardened.

Sidebars are made from medium carbon or medium carbon alloy steels. Sidebars of medium carbon steels may be used in the as-rolled condition or may be thru hardened for additional strength. Sidebars of medium carbon alloy steels are normally thru hardened.

STAINLESS STEELS

Chain components may be fabricated of one of several grades of stainless steel where additional corrosion or heat resistance is required.

Chain Selection Procedure

1. CONVEYOR PARAMETERS Determine all applicable conveyor parameters and operating conditions listed below. In order to follow the selection procedure outlined below, the following preliminary information and estimates must be made:

- **TYPE OF CONVEYOR** The type of conveyor is dependent upon the method of movement of the chain, the conveyed material and the direction (horizontal, inclined or vertical); refer to Table 1, page A-10, for the various conveyor possibilities.
- **NUMBER OF CHAIN STRANDS** Single strand, double strand, etc.
- **OPERATING CONDITION** The environment and use of the conveyor should be determined. Factors to consider are: corrosiveness, abrasiveness, elevated temperature operation, hours per day of operation, reversing application, etc.
- **CONVEYOR CENTER DISTANCE, VERTICAL RISE, HORIZONTAL RUN**
- **TYPE AND DENSITY OF MATERIAL TO BE CONVEYED** Table 4, page A-11, lists the densities of various materials in pounds per cubic foot.
- **CAPACITY** The required conveyor capacity in tons per hour or cubic feet per minute.
- **SIZE, SPACING AND WEIGHT OF CARRIERS AND ATTACHMENTS** Buckets, slats, aprons, etc.

2. CONVEYED MATERIAL WEIGHT Determine the weight of conveyed material per foot of conveyor and conveyor speed. Formulas A-1 and A-2, page A-5, can be used in determining these factors. A trade-off is necessary here. As the conveyor speed increases, the load per foot decreases and vice versa for a constant capacity. Higher chain speeds cause more rapid chain wear. Higher chain loading requires greater chain capacity. Refer to Table 1, page A-10, for typical conveyor speeds.

3. CHAIN TYPE Determine the probable chain type. Table 3, page A-10, is helpful in selecting the type of chain to be used based on the type and loading of the conveyor. Often several different types of chain can be used for a specific application. Factors influencing chain selection include: wear rate, relative price, load capacity and operating conditions. In general, steel chains have the greatest resistance to wear and abrasion and are usually selected for higher speed and highly abrasive applications. Steel chains have the greatest load capacity of the different types of chains, but are also the most expensive. Cast chains offer an economical selection for mildly abrasive and moderately corrosive environments. The combination chains offer a compromise between cast and steel chains. Typical chain weights are also shown in Table 3, page A-10.

4. CHAIN WEIGHT Determine the total weight of the chain and other conveying components, slats, pans, buckets, etc., per foot of conveyor, refer to formula I-1, page A-5.

5. TRIAL CHAIN PULL Calculate trial chain pull. Various conveyor layouts and chain pull formulas are outlined on pages A-6 through A-8. Locate the layout which is appropriate for your specific application to calculate chain pull. The symbols which are used in the formulas are listed and defined on page A-4.

6. CHAIN PITCH AND SPROCKETS Select the chain pitch and number of teeth on the sprocket. The chain pitch may be dictated by the required attachment spacing. The larger the pitch the more economical the chain, however, the pitch is limited by the chain speed and sprocket size as shown in Table 2, page A-10.

7. DESIGN CHAIN PULL Calculate the design chain pull. This procedure is outlined on page A-9.

8. CHAIN SELECTION Make the specific chain selection. Refer to the chain section of this catalog for the type of chain selected as the preliminary chain type. Locate the chain of the desired pitch which has a rated working load equal to or greater than the calculated design chain pull.

9. SPROCKET SELECTION Make the specific sprocket selection. Refer to the sprocket section of this catalog and follow the selection procedures outlined.

10. FINAL DESIGN CHAIN PULL Recalculate the design chain pull. Use the exact weight, number of teeth, conveyor speed, etc., for the specific chain, attachments and sprockets selected to recalculate the design chain pull to insure that it is less than the rated working load for the specific chain selected.

11. CHAIN LENGTH Calculate the required chain length. Refer to formula B-1, page A-5, to calculate the required chain length.

See chain selection example, pages A-14 and A-15.

Symbol Definitions

The following is a list of the symbols used in the formulas in this section. Each symbol is followed by its unit of measurement in parentheses. Following each symbol is its definition and a reference to the correct table or equation for determining its value. Care should be taken to insure that the values used in the formulas are expressed in the units shown in the following list.

(-)	Denotes dimensionless quality.
A (-)	Empirical factor used in calculating f_r, see Table 7, page A-11, for A factor values for various bearing surfaces.
a (ft)	Vertical rise or height of an inclined conveyor, use diagram on page A-7.
b (ft)	Horizontal length of an inclined conveyor, use diagram on page A-7.
C (ft)	Conveyor center distance.
CFM (ft^3/min)	Conveyor capacity or conveyed material flow rate, use formula A-2, page A-5.
D (in)	Chain roller outside diameter.
D_h (in)	Pitch diameter of head sprocket, use formula H-1, page A-5.
D_t (in)	Pitch diameter of tail or foot sprocket, use formula H-2, page A-5.
d (in)	Chain bushing outside diameter.
E (in)	Excess chain, the length of chain greater than U_c which results in forming catenary, use formula C-1, page A-5.
F_n (-)	Multiple strand factor, see design chain pull, page A-9.
F_p (-)	Composite service factor, see design chain pull, page A-9, and Table 9, page A-12.
F_s (-)	Speed factor, see design chain pull, page A-9, and Tables 10 and 11, page A-13.
f_d (-)	Digging factor, use formula E-1, page A-5.
f_h (-)	Material horizontal friction factor, see Table 4, page A-11, for values of f_h for various materials.
f_m (-)	Material friction factor, this is equal to f_w if the material is carried or f_v if the material is sliding.
f_p (-)	Service factor, see Table 9, page A-12.
f_r (-)	Chain rolling friction factor, see Table 6, page A-11, for estimated values of f_r, see Table 7, page A-11, to determine f_r after the specific chain selection has been made.
f_s (-)	Chain sliding friction factor, see Table 5, page A-11.
f_v (-)	Material vertical friction factor, see Table 4, page A-11.
f_w (-)	Chain friction factor, this is equal to f_r if the chain is rolling or f_s if the chain is sliding.
g (ft)	Width of conveyor trough.
HP (hp)	Horsepower required at the conveyor driving shaft, approximate values can be found using formulas F-1, F-2 and F-3, page A-5. For more accurate values refer to the appropriate formula in the conveyor layouts starting on page A-6.
h (in)	Height of material sliding against skirt boards.
J (lbs)	Conveyor or chain pull from material sliding against skirt boards, use formula D-1, page A-5.
L (pitches)	Length of chain pitches required if chain is pulled taut, use formula B-1, page A-5.
M (lbs/ft)	Weight per foot of conveyed material, use formula A-1 or A-2, page A-5.
N_h (-)	Number of teeth of driving or head sprocket.
N_t (-)	Number of teeth on driven or tail sprocket.
n (-)	Number of chain strands.
P (lbs)	Total chain or conveyor pull at head shaft, use the formula in the conveyor layouts starting on page A-6.
P_c (lbs)	Catenary tension, use formula C-2, page A-5.
P_d (lbs)	Design chain pull, see page A-9.
P_s (lbs)	Chain or conveyor required to pull material out of a hopper on a feeder conveyor.
P_{tu} (lbs)	Conveyor take-up tension, this value is usually known, if not, 200-300 pounds is a good estimate.
p (in)	Chain pitch.
Q (lbs)	Conveyor or chain pull from digging of material in the boot of an elevator, use formula E-1, page A-5.
q (lbs/ft^3)	Density of conveyed material, see Table 4, page A-11, for densities of various materials.
RPM (rpm)	Conveyor driving shaft speed.
S (ft/min)	Conveyor or chain speed, use formula A-3, page A-5.
T (ft-lbs)	Torque transmitted by the driving or head shaft, use formula G-2, page A-5.
TPH (tons/hr)	Conveyor capacity or conveyed material flow rate, use formula A-1, page A-5.
t (in-lbs)	Torque transmitted by the driving or head shaft, use formula G-1, page A-5.
U_a (ft)	Length of conveyor side skirt boards.
U_c (ft)	Horizontal length of unsupported catenary, see diagram, page A-6.
U_h (ft)	Length of hopper opening.
U_s(ft)	Horizontal length of supported return strand, see diagram, page A-6.
v (lbs)	Bucket, flight, scraper or other chain attachment weight.
W (lbs/ft)	Weight per foot of moving conveyor components, including chain flights, buckets, scrapers, etc., use formula I-1, page A-5.
w (lbs/ft)	Weight per foot of chain, estimated chain weights, see Table 3, page A-10. For specific chain weights refer to the appropriate chain section of this catalog.
X (ft)	Bucket, flight, scraper or other chain attachment spacing.
Y (ft)	Width of hopper opening.
Z (in)	Sag of catenary, see diagram, page A-6, use formula C-1, page A-5.
$\propto$ (degrees)	Angle of inclination of an inclined conveyor, see diagram, page A-7.

Engineering Formulas

A. Formulas for determining conveyor speed, capacity and material weight per foot of conveyor:

1. $M = \frac{33.3 \times TPH}{S}$

2. $M = \frac{CFM \times q}{S}$

3. $S = \frac{N_h \times p \times RPM}{12}$

B. Formula for determining chain length required:

1. $L = \frac{24 \times C}{p} + N \quad (N = N_t = N_h)$

This formula assumes sprockets of equal size and chain pulled taut. Additional pitches are required for catenary take-up, see formula C-1 below. For straight sidebar chains, chain length must be an even number of pitches.

C. Formulas for determining sag, excess chain and catenary tension:

1. $Z = \sqrt{4.5 \times U_c \times E}$ or $E = \frac{Z^2}{4.5 \times U_c}$

2. $P_c = \frac{1.5 \times W \times U_c^2}{Z}$

D. Formula for determining chain pull from skirt board friction:

1. $J = U_a \times h^2 \times f_h$

E. Formula for determining chain pull from digging in an elevator boot:

1. $Q = M \times D_t \times f_d$

Continuous Discharge Elevator – $f_d = 0.5$
Centrifugal Discharge Elevator – $f_d = 0.67$ (fine material)
1.0 (coarse material)

F. Formulas for determining horsepower:

1. $HP = \frac{t \times RPM}{63{,}025}$

2. $HP = \frac{T \times RPM}{5{,}252}$

3. $HP = \frac{P \times S}{33{,}000}$

G. Formulas for determining torque on driving shaft:

1. $t = \frac{P \times D_h}{2}$

2. $T = \frac{P \times D_h}{24} = \frac{t}{12}$

H. Formulas for determining sprocket pitch diameter:

1. $D_h = \frac{p}{\text{Sin}\,(180/N_h)}$

2. $D_t = \frac{p}{\text{Sin}\,(180/N_t)}$

I. Formula for determining conveyor component weight per foot of conveyor:

1. $W = (n \times w) + \left(\frac{v}{X}\right)$

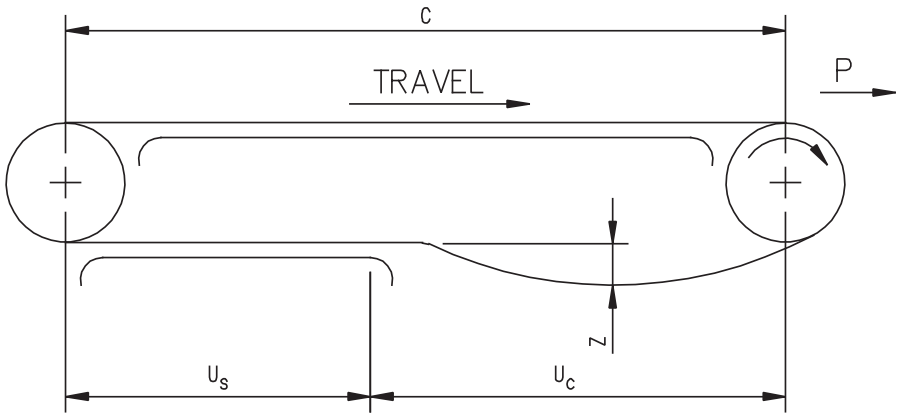
J. Formula for determining height of material sliding against skirt boards:

1. $h = \frac{12 \times M}{q \times g}$

Conveyor Layouts

Horizontal Conveyors

A conveyor, by definition, conveys a specific rate (TPH) of material. In the case of horizontal units the chain and material are not elevated so there is no additional chain pull to elevate them. However, additional tension from catenary sag and skirt board friction must be taken into account if applicable.



Catenaries over 15 ft. long are not advised.

$$P = \{[(2.1 \times W \times f_W) + (M \times f_m)] \times C\} + J$$

$$HP = \frac{1.15 \times S \times P}{33{,}000}$$

} if $U_S = C$

$$P = \{[(W \times f_W) + (M \times f_m)] \times C\} + (1.1 \times P_C) + J$$

$$HP = \frac{1.15 \times S \times (P\text{-}P_C)}{33{,}000}$$

} if $U_C = C$

$$P = \{[(W \times f_W) + (M \times f_m)] \times C\} + \{1.1 \times [(W \times f_W \times U_S) + P_C]\} + J$$

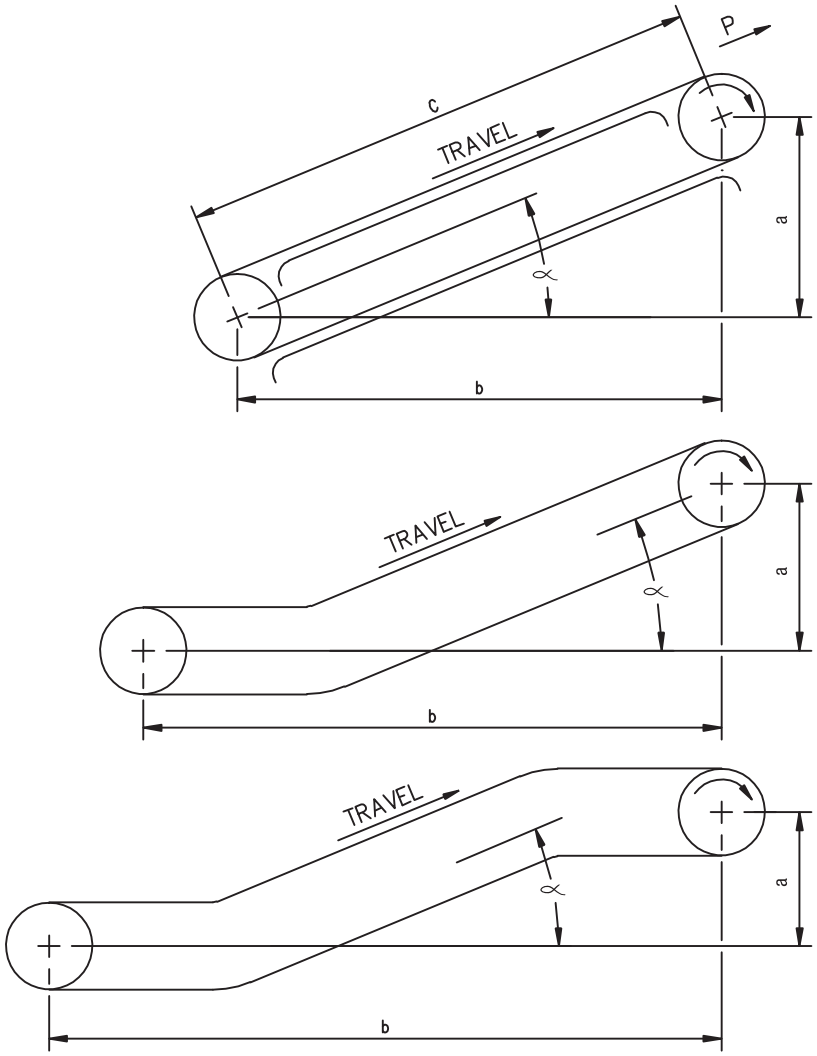
$$HP = \frac{1.15 \times S \times (P\text{-}P_C)}{33{,}000}$$

} if $U_S + U_C = C$

J = Load from friction of material sliding on skirt boards, if applicable use formula D-1, page A-5.

Conveyor Layouts
Inclined Conveyors

Inclined conveyors are similar to horizontal conveyors in that they are designed to handle material at a specific rate (TPH). In addition to catenary and skirt board tension, the chain pull required to elevate the chain and material must be taken into account. The formulas below apply to any combination of horizontal run plus vertical lift.



$$P = \frac{\{[(2.1 \times W \times f_w) + (M \times f_m)] \times b\} + (M \times a) - (0.1 \times W \times a) + J}{HP = \frac{1.15 \times S \times P}{33{,}000}} \quad \text{if } f_w > \frac{a}{b}$$

$$P = \frac{\{[(W \times f_w) + (M \times f_m)] \times b\} + [(W + M) \times a] + J}{HP = \frac{1.15 \times S \times [P + (W \times f_w \times b) - (W \times a)]}{33{,}000}} \quad \text{if } f_w < \frac{a}{b}$$

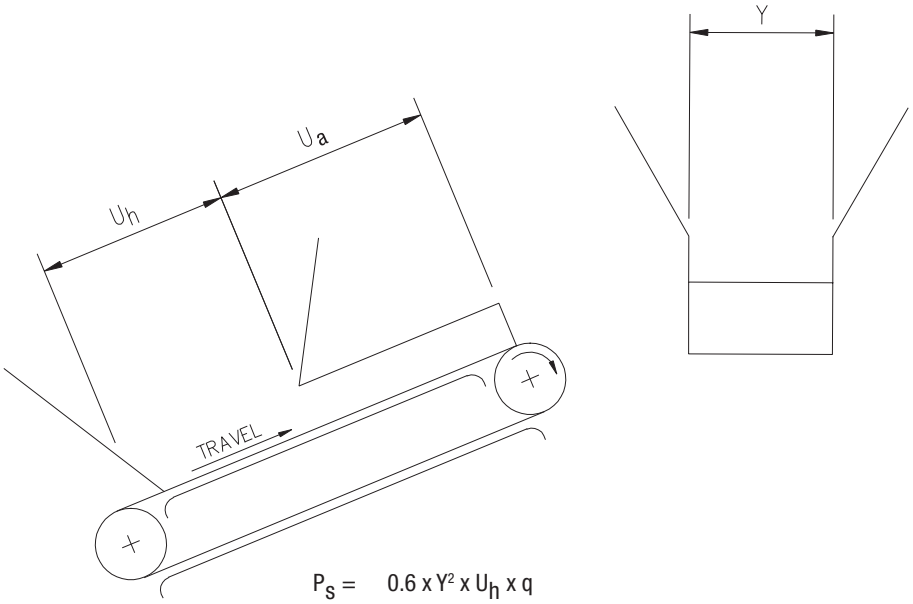
J = Load from friction of material sliding on skirt boards, if applicable use formula D-1, page A-5.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Conveyor Layouts

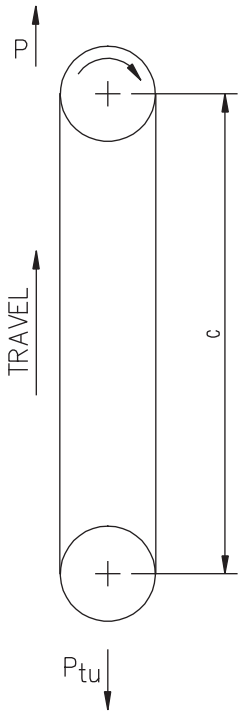
Feeders, Vertical Conveyors and Bucket Elevators

In a material flow, when material is being pulled from a hopper at a specific rate (TPH), the chain pull required to shear the material out of the hopper must be taken into account. This chain pull (Ps) is calculated as shown below and should be added to the total chain pull (P) of any of the conveyors on the previous pages.



$$P_S = 0.6 \times Y^2 \times U_h \times q$$

Vertical units, like conveyors, handle a specific rate (TPH) of material. There is no horizontal chain pull or additional tension from catenary sag or skirt board friction. However, in the case of bucket elevators, the additional load required to dig material out of the boot has to be calculated.



$$P = [(M + W) \times C] + (0.5 \times P_{tu}) + Q$$

$$HP = \frac{1.15 \times S \times [(M \times C) + Q]}{33{,}000}$$

Q = Load from digging of material in boot, if applicable use formula E-1, page A-5.

The design chain pull or P_d is calculated using the following formula:

$$P_d = P \times F_n \times F_p \times F_s$$

P = Total chain pull calculated from the formulas in the previous conveyor layouts.

F_n = Multiple Strand factor = $\frac{1.2}{n}$ (where n = 2 or greater)

F_p = Composite service factor is equal to the product of the applicable service factors (f_p).

f_p = Service factors: values of the applicable service factors are listed in Table 9, page A-12. Before Table 9 can be used effectively, an understanding of the following definitions is necessary.

UNIFORM OR STEADY LOAD Steady loading with only minor load fluctuations. See Group A, Table 8, page A-12.

MODERATE SHOCK LOAD Relatively smooth load fluctuations of large magnitude. See Group B, Table 8, page A-12.

HEAVY SHOCK LOAD Rapid load fluctuations of large magnitude. See Group C, Table 8, page A-12.

FREQUENT AND INFREQUENT SHOCK They mean different rates of peak load or shock occurrence for different applications.

The high speed drive, several hundred or a thousand RPM, expected to last several years or more would have Frequent Shock if it occurred only a few times a day, say fifty to one hundred times. On the other hand, if shock loading was not expected to occur at any given frequency but might happen occasionally such as once a month or once in six months due to accidental happenings, then the term Infrequent Shock would apply.

The slow speed drive used on heavy equipment with an expected chain life of two or three seasons of operation would place a different meaning on the terms Frequent and Infrequent. Several cycles, such as fifty or less, would likely be termed Infrequent. Whereas two or three hundred cycles per day would be termed Frequent.

In between speed conditions should be evaluated for their frequency patterns.

F_s = Speed factor from Table 10 or 11, page A-13.

Engineering Tables

TABLE 1 - CONVEYOR OPTIONS

Chain Conveyors and Elevators	Chain Sliding				Chain Rolling						Material Carried	Typical Speed Ft. Per Minute
	Material Sliding		Material Carried		Material Sliding			Material Carried				
	Horiz.	Incl.	Horiz.	Incl.	Horiz.	Incl.	Horiz. and Incl.	Horiz.	Incl.	Horiz. and Incl.	Vertical	
Apron Feeder	–	–	x	x	–	–	–	x	x	x	–	10/50
Apron Conveyor	–	–	x	x	–	–	–	x	x	x	–	50/100
ENDURO-FLITE® Conveyor	–	–	x	x	–	–	–	x	x	x	–	50/100
Drag Conveyor	x	x	–	–	–	–	–	–	–	–	–	50/100
Flight Conveyor	x	x	–	–	x	x	x	–	–	–	–	50/100
Slat Conveyor	–	–	x	x	–	–	–	x	x	x	–	50/150
Centrifugal Discharge Bucket Elevator	–	–	–	–	–	–	–	–	–	–	x	225/300
Continuous Bucket Elevator	–	–	–	–	–	–	–	–	–	–	x	125
Super Capacity Bucket Elevator	–	–	–	–	–	–	–	–	–	–	x	100/125

Material sliding conveyors push, drag or scrape material in a trough and are generally used for nonabrasive, smaller materials.
Material carried conveyors have the entire weight of the material supported or carried by the chain and are generally used for large, bulky and abrasive materials.

TABLE 2 - MAXIMUM RECOMMENDED CONVEYOR SPEEDS

No. of Spkt. Teeth	Pitch in Inches						
	2	4	6	9	12	18	24
6	254	180	147	120	104	85	68
7	297	210	171	140	121	99	80
8	340	240	196	160	138	113	91
9	382	270	220	180	155	127	103
10	425	300	245	200	173	141	115
11	466	330	270	220	190	156	125
12	509	360	294	240	207	170	–
13	551	390	318	260	224	184	–
14	594	420	343	280	242	198	–
15	636	450	367	300	259	212	–

Table values are feet per minute.

TABLE 3 - CHAIN TYPE SELECTION GUIDE AND TYPICAL CHAIN WEIGHTS

Application		Chain Type	Range of Weight of Chain Per Ft. Lbs.
Conveyor Type	Chain Loading		
Chain Sliding and Material Carried	Light	400 Class Pintle	2.0/8.0
	Light to Moderate	H Class Mill	2.5/10.0
	Moderate	700 Class Pintle	4.5/7.0
		Combination	2.0/16.0
	Moderate to Heavy	Hardened Steel Bushed	5.0/25.0
		Steel Bushed Roller	4.0/30.0
Chain Sliding and Material Sliding	Light to Moderate	H Class Mill	2.5/10.0
	Moderate to Heavy	Combination	2.0/16.0
		H Type Drag	8.0/20.0
		Combination Type Drag	10.0/20.0
Chain Rolling and Material Carried Vertical or Inclined Bucket Elevators	All Loading	Steel Bushed Roller	4.0/30.0
	Light	400 Class Pintle	2.0/8.0
		Combination	2.0/16.0
	Light to Moderate	Combination	2.0/16.0
	Moderate	700 Class Pintle	4.5/7.0
		Combination	2.0/16.0
		Hardened Steel Bushed	5.0/25.0
	Moderate to Heavy	Combination	2.0/16.0
		Hardened Steel Bushed	5.0/25.0
		Steel Bushed Roller	4.0/30.0

TABLE 4 - MATERIAL CHARACTERISTICS (q, f_v, f_h)

Material	Average Weight Per Ft.^{3} Lbs. (q)	Vertical Friction Factor (f_v)	Horizontal Friction Factor (f_h)
Alum, lumpy	50-60	.35-.45	.035-.040
Ash, dry 1/2" and under	35-40	.45-.55	.024-.028
Ash, wet 1/2" and under	45-50	.55-.65	.016-.020
Ash, dry 3" and under	35-40	.45-.55	.028-.032
Ash, wet 3" and under	45-50	.55-.65	.022-.026
Bagasse	7-8	.35-.45	.004-.006
Beans, whole	45-50	.30-.40	.054-.058
Cement, Portland	75-85	.60-.70	.082-.090
Cement, clinker	75-80	.65-.75	.078-.086
Coal, anthracite, egg	50-55	.25-.30	.030-.034
Coal, anthracite, nut and stove	50-55	.30-.35	.036-.040
Coal, anthracite, run of mine	50-55	.35-.40	.048-.052
Coal, anthracite, pea	50-60	.40-.45	.060-.064
Coal, anthracite, buckwheat	55-65	.50-.55	.070-.075
Coal, bituminous, sized	45-55	.45-.55	.045-.050
Coal, bituminous, run of mine	45-55	.55-.65	.047-.051
Coal, bituminous, slack, dry	40-50	.45-.55	.033-.037
Coal, bituminous, slack, wet	50-60	.65-.75	.031-.035
Coke, sized	23-32	.35-.45	.018-.022
Coke, mixed	25-35	.55-.60	.022-.026
Coke, breeze	25-35	.60-.70	.026-.030
Cottonseed, undelinted	18-25	.30-40	.010-.012
Grains	38-45	.35-.45	.042-.046
Gravel, dry, screened	90-100	.40-.50	.078-.082
Gravel, run of bank	100-125	.55-.65	.086-.090
Ice, crushed	35-45	.15-.20	.028-.032
Ice, cakes	57	.06-.10	–
Lime, ground	55-65	.35-.45	.034-.038
Lime, pebble	55-60	.45-.55	.062-.068
Sand, dry	90-100	.55-.65	.130-.140
Sand, damp	110-130	.80-.90	.160-.170
Sand, foundry, shakeout	85-95	.65-.75	.068-.072
Sand, foundry, tempered	90-100	.80-.90	.066-.070
Sawdust	10-13	.35-.45	.004-.006
Stone, dust	75-85	.45-.55	.085-.090
Stone, screened lumps	85-90	.55-.65	.110-.115
Stone, lumps and fines	85-90	.60-.70	.105-.110
Wood chips	12-20	.35-.45	.004-.006

TABLE 5 - CHAIN SLIDING FRICTION FACTORS (f_s)

Materials	Coefficient	
	Dry	Lubricated
Chain on Steel	0.33	0.20
Chain on Cast Iron or Steel	0.50	–
Chain on Hardwood	0.35	0.25
Chain on UHMW Polyethylene	0.25	0.15

TABLE 6 - APPROXIMATE CHAIN ROLLING FRICTION FACTORS (f_r)

Roller Outside Dia.	Coefficient	
	Dry	Lubricated
1½"	0.17	0.11
2"	0.20	0.13
2½"	0.16	0.10
3"	0.17	0.12
4"	0.16	0.11
5"	0.14	0.10
6"	0.17	0.12

To be used for preliminary chain selection only. To calculate (f_r) for a specific chain, see Table 7.

TABLE 7 - SPECIFIC CHAIN ROLLING FRICTION FACTORS (f_r)

Chain rolling friction can be determined by the following formula:

$$f_r = \frac{A \times d}{D}$$

f_r = Rolling friction of chain.
A = Factor from Table 7.
d = Diameter of bushing, inches.
D = Diameter of chain roller, inches.

Type of Bearing for Chain Rollers	Factor A	
	Rollers Not Lubricated	Rollers Lubricated
Cored Iron or Steel on Cold Finished Steel	0.50	0.35
Bored Iron or Steel on Cold Finished Steel	0.40	0.25
Bored Bronze Bushing on Cold Finished Steel	–	0.20
Plastic Bushed on Cold Finished Steel	0.25	–
Roller Bearings with Smooth Hardened Races	–	0.09
Ball Bearings with Smooth Hardened Races	–	0.06

Factor A is based on rollers with smooth faces operating on smooth, clean steel tracks and includes reasonable allowance for flange and hub frictions.

Cored Iron is based on smooth cored holes made with dried sand or painted cores.

Engineering Tables

TABLE 8 - LOAD CLASSIFICATIONS

Group A Uniform or Steady Load	Group B Moderate Shock Load	Group C Heavy Shock Load
Conveyors - Uniformly loaded or fed (apron, assembly, belt, flight, oven, screw) Machines - All types with uniform nonreversing loads Screens - Rotary (uniformly fed), traveling water intake Sewage Disposal Equipment - Inside service (uniformly fed)	Conveyors - Heavy-duty and not uniformly loaded (apron, assembly, belt, bucket, flight, oven, screw) Machines - All types with moderate shock and nonreversing loads Screens - Rotary (stone or gravel) Elevators - All types	Drag Conveyors Log Haul Conveyors Machines - All types with severe impact shock loads or speed variations and reversing service Metal Mills - Draw bench Mills - (rotary type) ball, cement kilns, rod mills, tumbling mills

TABLE 9 - SERVICE FACTOR (f_p) AND COMPOSITE SERVICE FACTOR (F_p)

F_n = Multiple strand factor = $\frac{1.2}{n}$ (where n = 2 or greater)

Conditions Affecting Chain Life Expectancy		Service Factors (f_p)
Frequency of Shock	Infrequent Shock	1
	Frequent Shock	1.2
Character of Chain Loading	A. Uniform or Steady Load	1
	B. Moderate Shock Load	1.2
	C. Heavy Shock Load	1.5
Atmospheric Conditions	Relatively Clean and Moderate Temperature	1
	Moderately Dirty and Moderate Temperature	1.2
	Exposed to Weather, Very Dirty, Abrasive, Mildly Corrosive and Reasonably High Temperatures	1.4
Daily Operating Range	8-10 Hours	1
	10-24 Hours	1.2

For definitions of Frequent or Infrequent Shock refer to page A-9. For definitions of chain loading refer to page A-9, or Table 8. The composite service factor (F_p) is equal to the product of the service factors (f_p), see the chain selection example on page A-14.

TABLE 10 - SPEED FACTORS (F_S) FOR CAST AND COMBINATION CHAINS

No. of Spkt. Teeth	Feet Per Minute																
	10	25	50	75	100	125	150	175	200	225	250	275	300	350	400	450	500
6	1.05	1.25	1.57	1.92	2.28	2.75	3.31	4.08	5.03	6.45	8.40	12.0	18.9	–	–	–	–
7	.971	1.10	1.29	1.46	1.64	1.84	2.07	2.34	2.62	2.98	3.39	3.92	4.52	6.32	9.92	19.2	–
8	.935	1.04	1.19	1.32	1.44	1.57	1.71	1.86	2.02	2.20	2.40	2.62	2.85	3.43	4.15	5.26	7.10
9	.909	.990	1.12	1.23	1.34	1.44	1.55	1.66	1.77	1.89	2.01	2.15	2.29	2.60	2.92	3.32	3.76
10	.885	.962	1.07	1.16	1.25	1.33	1.41	1.49	1.57	1.66	1.75	1.84	1.92	2.12	2.32	2.52	2.76
11	.870	.935	1.02	1.10	1.18	1.25	1.32	1.39	1.46	1.53	1.60	1.68	1.74	1.89	2.03	2.19	2.35
12	.847	.901	.990	1.06	1.13	1.20	1.26	1.32	1.38	1.45	1.51	1.56	1.62	1.74	1.86	1.99	2.11
14	.840	.885	.952	1.01	1.06	1.12	1.17	1.22	1.27	1.32	1.37	1.42	1.46	1.56	1.65	1.76	1.84
16	.830	.870	.926	.971	1.02	1.07	1.11	1.15	1.20	1.24	1.28	1.33	1.37	1.45	1.53	1.62	1.70
18	.824	.862	.909	.952	1.00	1.04	1.08	1.12	1.15	1.19	1.23	1.27	1.30	1.37	1.45	1.53	1.60
20	.820	.855	.901	.943	.980	1.02	1.05	1.09	1.12	1.16	1.19	1.23	1.26	1.33	1.39	1.47	1.53
24	.813	.840	.877	.909	.943	.971	1.00	1.03	1.06	1.09	1.12	1.16	1.19	1.25	1.31	1.38	1.44

TABLE 11 - SPEED FACTORS (F_S) FOR STEEL CHAINS

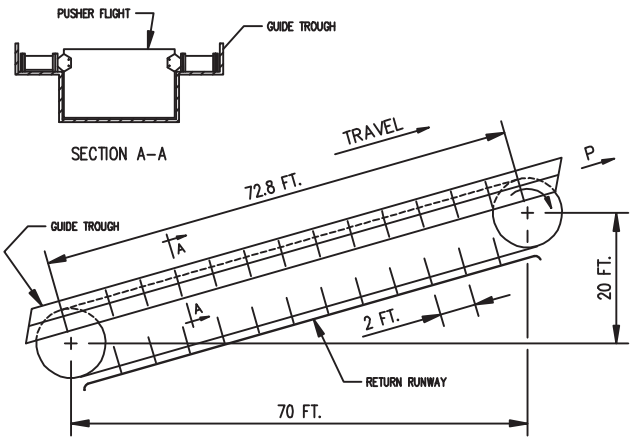
No. of Spkt. Teeth	Feet Per Minute																			
	10	25	50	75	100	125	150	175	200	225	250	275	300	400	500	600	700	800	900	1000
6	.917	1.09	1.37	1.68	2.00	2.40	2.91	3.57	4.41	5.65	7.35	10.6	16.7	–	–	–	–	–	–	–
7	.855	.971	1.13	1.27	1.44	1.61	1.81	2.04	2.29	2.60	2.96	3.42	3.95	8.62	–	–	–	–	–	–
8	.813	.909	1.04	1.16	1.26	1.37	1.49	1.63	1.76	1.93	2.10	2.29	2.48	3.62	6.21	–	–	–	–	–
9	.794	.870	.980	1.07	1.17	1.26	1.36	1.45	1.55	1.65	1.76	1.88	2.00	2.56	2.94	4.29	6.09	9.90	–	–
10	.775	.840	.943	1.02	1.09	1.16	1.24	1.31	1.37	1.45	1.53	1.61	1.68	2.03	2.41	2.81	3.31	3.82	4.48	5.37
11	.758	.820	.901	.971	1.03	1.09	1.15	1.22	1.28	1.34	1.40	1.46	1.52	1.78	2.05	2.33	2.63	2.96	3.37	3.82
12	.741	.787	.862	.926	.990	1.05	1.10	1.16	1.21	1.26	1.32	1.37	1.42	1.63	1.84	2.05	2.26	2.51	2.77	3.05
14	.735	.769	.833	.885	.935	.980	1.02	1.07	1.11	1.15	1.19	1.24	1.28	1.47	1.61	1.78	1.94	2.10	2.29	2.48
16	.725	.763	.813	.855	.893	.935	.971	1.01	1.05	1.08	1.12	1.16	1.19	1.34	1.48	1.63	1.77	1.93	2.09	2.28
18	.719	.752	.800	.833	.877	.909	.943	.980	1.01	1.04	1.08	1.11	1.14	1.27	1.40	1.53	1.67	1.80	1.95	2.11
20	.717	.746	.787	.826	.855	.893	.917	.952	.980	1.01	1.04	1.07	1.10	1.22	1.34	1.45	1.57	1.69	1.82	1.96
24	.714	.735	.769	.800	.820	.847	.877	.901	.935	.962	.980	1.01	1.04	1.15	1.26	1.37	1.48	1.56	1.71	1.84

Chain Selection Example

A detailed example of a typical conveyor chain selection following the Selection Procedure outlined on page A-3.

APPLICATION DETAILS

Select a chain to suit the following application. It is necessary to convey sized bituminous coal along an incline as shown in the figure below. A flow rate of 100 tons/hr. for 24 hr./day is required. It has been decided that a double strand flight conveyor, utilizing ½" x 6" x 24" steel pushers weighing 20.4 lbs. each and spaced at two foot intervals is to be used.



SELECTION PROCEDURE

1. **CONVEYOR PARAMETERS** Determine all applicable conveyor parameters.
   - **TYPE** As outlined in the problem statement.
   - **NUMBER OF STRANDS** 2 strands.
   - **OPERATING CONDITIONS** 24 hr./day operation, nonabrasive, noncorrosive, very dirty.
   - **CENTER DISTANCE** 72.8 ft., vertical rise 20 ft., horizontal run 70 ft.
   - **MATERIAL** Sized bituminous coal, see Table 4, page A-11, a typical material density of 45-55 lbs./cu. ft. (50 lbs./cu. ft. average) is found.
   - **CAPACITY** 100 tons/hr.
   - **CHAIN ATTACHMENTS** ½" x 6" x 24" steel pushers, 20.4 lbs. each, spaced on 2 ft. centers.

2. **CONVEYED MATERIAL WEIGHT** Determine the weight of the conveyed material per foot and conveyor speed. See Table 1, page A-10, to find the typical speed for a flight conveyor is 100 ft./min. Using this value and formula A-1, page A-5, determine M, the weight per foot of conveyor.

$$\mathbf{M = \frac{33.3 \times TPH}{S}} = \frac{33.3 \times (100)}{100} = 33.3 \text{ lbs./ft.}$$

3. **CHAIN TYPE** Determine the probable chain type. See Table 3, page A-10, for chain sliding, material sliding and moderate loading, a combination chain is selected as the probable chain. Note that combination chains range in weight from 2.0 to 16.0 lbs./ft. A weight of 8.0 lbs./ft. will be used in these calculations.

4. **CHAIN WEIGHT** Determine the weight per foot of conveyor components. Using formula I-1, page A-5, calculate W.

$$\mathbf{W = n \times w + \frac{v}{X}} = 2 \times 8.0 + \frac{20.4}{2} = 26.2 \text{ lbs./ft.}$$

5. **TRIAL CHAIN PULL** Calculate the trial chain pull. Referring to the conveyor layout for inclined conveyors, page A-7, calculate a trial value of P as follows:

   A. For chain sliding $f_W = f_S$, from Table 5, page A-11, it is found that $f_W = f_S = .33$ for unlubricated steel sliding on steel.

   B. We note that:

$$\frac{a}{b} = \frac{20}{70} = .29$$

   Therefore $f_W > a$, so the first set of formulas for inclined conveyors apply.

   C. For material sliding $f_m = f_v$, from Table 4, page A-11, it is found that $f_v = .45$ - $.55$ for bituminous coal. The average value of .50 will be used.

   D. Friction from the coal sliding against the sides of the trough is a source of chain loading in this application, therefore, J must be determined. Use formula J-1, page A-5, to find the value of h and formula D-1, page A-5, to calculate J. The values of f_h and q are found in Table 4, page A-11. For this application the skirt board length U_a is the same as the conveyor center distance C = 72.8 ft.

$$\mathbf{h = \frac{12 \times M}{q \times g}} = \frac{12 \times 33.3}{50 \times 2} = 4 \text{ in.}$$

$$\mathbf{J = U_a \times h^2 \times f_h} = (72.8) \times (4^2) \times (.050) = 58.2 \text{ lbs}$$

   E. Substitute the above values into the appropriate formula on page A-7 and solve for P.

$$\mathbf{P = \{[(2.1 \times W \times f_W) + (M \times f_m)] \times b\} + (M \times a) - (0.1 \times W \times a) + J}$$

$$P = \{[(2.1 \times 26.2 \times .33) + (33.3 \times 0.5)] \times 70\} + (33.3 \times 20) - (0.1 \times 26.2 \times 20) + J$$

$$P = [(18.16 + 16.6) \times 70] + 666 - 52.4 + 58.2$$

$$P = 3{,}105 \text{ Lbs.}$$

6. **CHAIN PITCH AND SPROCKET** This step does not apply in this example.

Chain Selection Example

7. **DESIGN CHAIN PULL** Calculate the design chain pull. The P_d is calculated as outlined on page A-9 as follows:

   A. Determine f_p factors from Table 9, page A-12.

Conditions	f_p
Infrequent Shock	-1.0
Uniform load	-1.0
Very dirty	-1.4
10-24 hr./day	-1.2

   B. Determine F_p

   F_p = product of f_p's = 1 x 1 x 1.4 x 1.2 = 1.68

   C. Determine F_s from Table 10, page A-13, for 100 ft./min. and 13 tooth sprockets.
   F_s = 1.09

   D. Determine F_n from the formula given:

$$F_n = \frac{1.20}{n} = \frac{1.20}{2} = .6$$

   E. Calculate P_d

   $P_d = P \times F_n \times F_p \times F_s$ = 3,105 x .6 x 1.68 x 1.09 = 3,412 lbs.

8. **CHAIN SELECTION** Make a specific chain selection. Refer to the Combination Chain section of this catalog, a chain is to be chosen which is approximately 3" pitch and has a rated working load which is greater than the calculated P_d. N131 Duramal is selected. N131 Duramal has a pitch of 3.075", its rated working load (3,750 lbs.) is larger than the P_d (3,412 lbs.) and the G19 attachments available for N131 are suitable for attaching the pushers.

9. **SPROCKET SELECTION** Make a specific sprocket selection. The details of sprocket selection are not covered here. Refer to the sprocket section of this catalog. A 13 tooth sprocket is available for N131 chain in cast iron chilled rim or flame cut flame hardened fabricated steel, therefore, the speed factor F_s determined in the trial calculations can be used again in part 10 below.

10. **FINAL DESIGN CHAIN PULL** Recalculate the design chain pull. Note from the Combination Chain section of the catalog that N131 Duramal chain with a G19 attachment on the steel sidebar every 2 ft. or 8th pitch has a weight per foot of 6.9 lbs. The estimated chain weight per foot of conveyor used in the trial P_d calculation was 8.0 lbs./ft. Recalculate the P_d using 6.9 lbs./ft. to insure that the P_d for the specific chain selection is less than the rated working load. Recalculation yields P_d = 3,294 lbs. < 3,750 lbs. rated working load.

11. **CHAIN LENGTH** Calculate the chain length required. Use formula B-1, page A-5, to determine the chain length required.

$$L = N_h + \frac{24 \times C}{P} = 13 + \frac{24 \times 72.8}{3.075} = 581 \text{ pitches/strand}$$

Since N131 Duramal is a straight sidebar chain an even number of pitches is required for the chain to couple together. Also, for the pusher flights to be spaced evenly every 2 ft. (every 8th pitch) the number of pitches must be evenly divisible by 8, therefore 584 pitches and 73 flights would be required.

Based on the above, the following should be specified on the order for the required chain: 584 pitches (149.65 ft.) of N131 Duramal chain with G19 right-hand attachments every 8th pitch on outside steel sidebar. 584 pitches (149.65 ft.) of N131 Duramal chain with G19 left-hand attachments every 8th pitch on outside steel sidebar. Either pin and cottered or riveted construction should be specified.

General Information

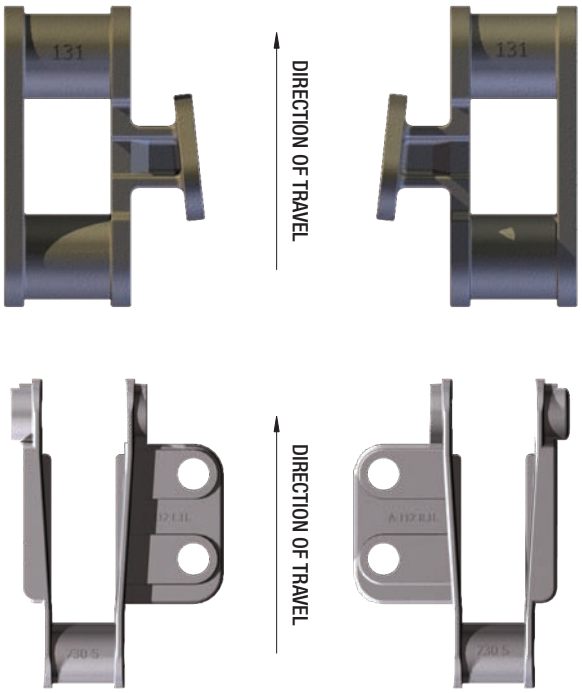
RIGHT AND LEFT-HAND ATTACHMENTS

Side attachments are made right-hand and left-hand on chains which are designed so that they cannot be reversed or turned over on the sprockets, and on other chains when the attachment itself is not symmetrical, such as A1, A42, G6 and others.

To determine whether attachments used in connection with double strand elevators and conveyors are right or left-hand, face the ascending side of the elevator, or the top side of the upper run of the conveyor, moving away from you, and the attachments on the right-hand side of the carrier are right-hand and those on the left-hand side are left-hand.

Another method of determining the hand of an attachment, is to hold the link with the side that runs against the sprocket wheel away from you, the barrel on top and the pin below. In this position a right-hand attachment will be on the right side of the link and a left-hand attachment on the left side of the link.

The illustrations show both right-hand and left-hand attachments on various classes of chain. The information given above should make it possible to determine the hand of attachments for any purpose for which they may be required.



LEFT-HAND **RIGHT-HAND**

CARE AND MAINTENANCE OF CHAIN

Proper maintenance of any chain installation should include correct lubrication, periodic inspection and prompt adjustment for normal wear.

Periodic inspection of the chain and sprockets is required to detect any deviation from normal wear before serious damage takes place. The cost of such inspection is repaid many times in extended chain life and in freedom from failure.

No general rule can be given for the frequency of inspection. The frequency should be influenced by the conditions of operation.

LUBRICATING CONVEYOR CHAIN

As a general rule lubrication should be provided for all conveyor and elevator chains. A well lubricated chain will have an operating life much longer than that of an unlubricated chain. The lubricant should have a viscosity to enable it to reach internal surfaces under normal conditions. For temperatures up to 160° F, SAE 30 oil is recommended. Applying a lubricant to conveyor and elevator chains is often difficult, as they are usually operated in the open and exposed to the material being conveyed. The nature of the surrounding atmosphere is the principal consideration in selecting the method of lubrication to be used.

CLEAN ATMOSPHERE Chains operating in a relatively clean atmosphere can be lubricated by brush or drip-feed oilers or by applying the lubricant manually with a brush or oil can.

ATMOSPHERE LADEN WITH LINT OR NONABRASIVE DUST Where large volumes of lint or nonabrasive dust are present, a brush or wiper can be used to clean the chain and apply new lubricant. Otherwise the lint or dust will clog the chain joint clearance and prevent penetration of the oil into the joints.

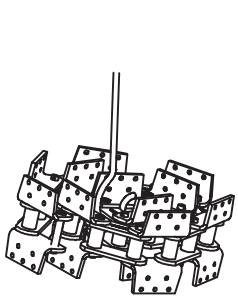
ABRASIVE ATMOSPHERE If abrasives come in contact with the chain, lubrication becomes more difficult. When lubricants are applied externally, abrasive particles tend to adhere to the chain surfaces and act as a lapping or grinding compound. Under extreme conditions, it is sometimes advisable to avoid chain lubrication.

ELEVATED TEMPERATURES Petroleum oils should not be used to lubricate chains operating in temperatures exceeding 300° F. Under certain conditions, chain operating in high temperature atmospheres can be effectively lubricated using finely divided graphite or molybdenum disulphide in a volatile carrier, which upon evaporation of the volatile carrier leaves a thin deposit of solid lubricant on the chain joint surfaces.

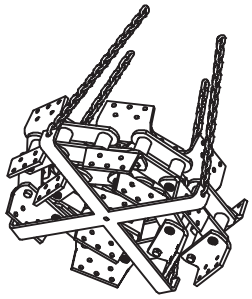
Consult a lubricant manufacturer for recommendations when chains are required to operate at elevated temperatures or under other difficult conditions.

PROPER CHAIN HANDLING

Chain can become twisted if not properly handled. Never pick up a chain by hooking in the center of the coil. Support the whole coil by strapping underneath or by running a bar through the coil and lift using the bar as shown below.

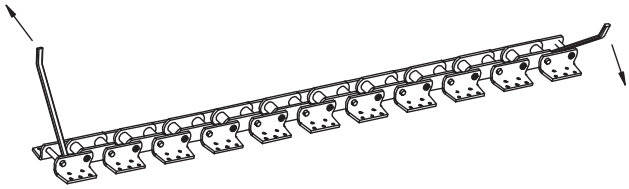


IMPROPER

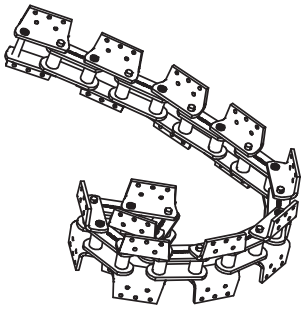


PROPER

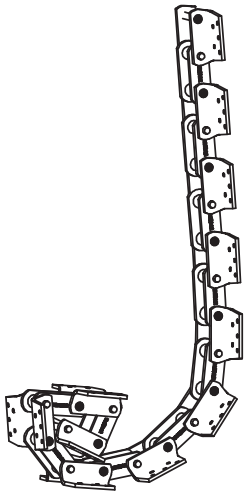
If the chain does become twisted, it can be straightened by using pry bars at both ends and twisting in the opposite direction. This works best when the chain is stretched out on the floor as shown below.



For shipping and handling, chains are coiled in lengths of about 10 feet long. When installing a chain into a conveyor or elevator, do not feed it in on its side. The coil should be standing on edge in order to avoid twisting of the chain as shown below.



IMPROPER



PROPER

CHAIN INSTALLATION

When installing a chain in a conveyor or elevator, try to stretch the chain out on the floor if at all possible. Here the strands can be coupled conveniently and accessories such as elevator buckets can be bolted to the chain prior to installation. Find where the conveyor is most accessible and thread the chain in at that point. In the case of bucket elevators, remove the hood and lower the chain down over the head sprocket or feed the chain in the casing at the access panel in the boot section and hoist the chain up over the head sprocket.

CHAIN REPLACEMENT

When replacing a conveyor or elevator chain, locate the most convenient spot in the conveyor, usually the boot section on a bucket elevator. Uncouple the used chain and attach the new chain to it. Thread the new chain in by jogging the drive or pulling on the loose end of the old chain.

General Information

FIELD ASSEMBLY OF CHAIN

Lubricate the sidebar holes with moly-paste, 30W oil, WD40 or another type of lubricant. Place the pin in the chain joint and push pin in as far as possible. Line up the pin flats where applicable and tap the pin with a hammer until snug.

Secure the chain joint to prohibit lateral movement. Place a spacer bar between the outer sidebars and clamp it in place so that the sidebars cannot move in relationship to each other. Press or drive the pin into the chain until the head meets the sidebar. The pin can be installed with a portable hydraulic press or driven in with a sledge hammer.

COTTERED CONSTRUCTION CHAINS Install the cotter with a hammer and bend the end(s) enough to secure the cotter in the hole.

RIVETED CONSTRUCTION CHAINS Heat the end of the pin with a rosebud or torch until the pin end is red in color. Rivet the pin end with a portable hydraulic press or peen over with a hammer.

If the chain does not flex freely, hit the head end and rivet end alternately with a hammer to establish clearance.

The integrity of the press fits must be maintained. Grinding of pins or modifying sidebar pin holes to facilitate assembly will void the warranty.

CHAIN ATTACHMENT WELDING

Welding surfaces should be clean and free of all foreign materials such as scale, rust, dirt or oil.

Electrode selection is very important. Most chains have mild steel attachments welded to them. An E7018 low hydrogen electrode should be used. For attachments other than mild steel contact Webster or your local welding technician. Good welding practice dictates that electrodes are stored in a dry atmosphere or baked prior to use. This will prevent the absorption of hydrogen in the form of moisture in the air. This can cause brittle welds or excessive porosity in the welds.

Arcs should not be struck on the sidebars, instead arc should be struck on the attachment. Arc scars on sidebars can produce early chain failure.

Tack welds should never be used in areas that will not be welded in the finished product. Avoid placing tack welds in potentially high stressed areas.

When possible weld attachment to the sidebar horizontally and not along the vertical plane, see Figure 1. When welding horizontally, start at either side of the attachment and weld toward center to prevent craters at the ends due to stopping of weld, see Figure 2. Overlap start/stop or backfill craters as required.

While not generally required for small attachments, preheating and postheating are recommended for large or heavily loaded attachments. No welding should be performed on parts when the part temperature is below 70° F.

PREHEAT Performed to reduce possibility of cracking both surface and subsurface of weld. Parts to be welded, link and attachment, are heated uniformly to temperature dictated by material thickness and carbon content. Usually in the temperature range of 100 – 300° F when required.

POSTHEAT Performed to reduce residual stresses and to temper hard, brittle phases formed during cooling or quenching. Postheat is applied after welding has been completed. Generally, postheat temperatures are higher than those used for preheat. This is usually in the temperature range of 700° F and higher.

The preferred shape of the weld bead contour is convex. A convex weld is stronger and less subject to cracking than concave forms.

Weld size should be approximately ¾ the thickness of the thinnest part being welded as a general rule.

Welds should not extend above the mounting surfaces of attachments and should not interfere with articulation of the chain joint.

Attachments should be located with fixtures to assure proper positioning, especially on double strand conveyors to distribute load evenly.

Upon inspection, welds should be free of cracks, undercutting, slag inclusions and excessive porosity. Weld beads should be free of pin holes, have uniformly fine surface ripples and have little or no indication of where the weld stops or starts. Weld edges should indicate complete fusion without overlap or undercut. Welds should be clean, free from spatter, slag, excessive oxides and arc scars.

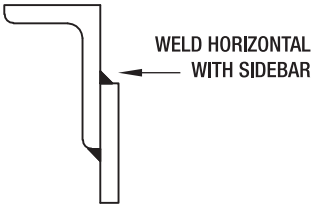


FIGURE 1

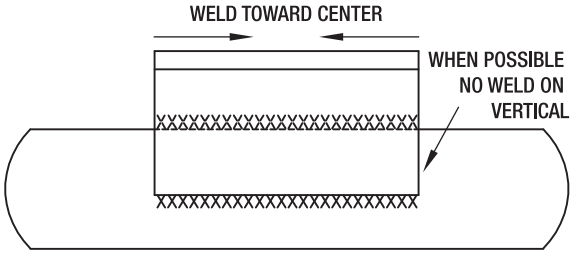


FIGURE 2

FRACTION CONVERSIONS

Fraction of an Inch	Decimals of an Inch	Millimeters
1/64	0.015625	0.397
1/32	0.03125	0.794
3/64	0.046875	1.191
1/16	0.0625	1.588
5/64	0.078125	1.984
3/32	0.09375	2.381
7/64	0.109375	2.778
1/8	0.125	3.175
9/64	0.140625	3.572
5/32	0.15625	3.969
11/64	0.171875	4.366
3/16	0.1875	4.763
13/64	0.203125	5.159
7/32	0.21875	5.556
15/64	0.234375	5.953
1/4	0.25	6.350
17/64	0.265625	6.747
9/32	0.28125	7.144
19/64	0.296875	7.541
5/16	0.3125	7.938
21/64	0.328125	8.334
11/32	0.34375	8.731
23/64	0.359375	9.128
3/8	0.375	9.525
25/64	0.390625	9.922
13/32	0.40625	10.32
27/64	0.421875	10.72
7/16	0.4375	11.11
29/64	0.453125	11.51
15/32	0.46875	11.91
31/64	0.484375	12.30
1/2	0.5	12.70

FRACTION CONVERSIONS

Fraction of an Inch	Decimals of an Inch	Millimeters
33/64	0.515625	13.10
17/32	0.53125	13.49
35/64	0.546875	13.89
9/16	0.5625	14.29
37/64	0.578125	14.68
19/32	0.59375	15.08
39/64	0.609375	15.48
5/8	0.625	15.88
41/64	0.640625	16.27
21/32	0.65625	16.67
43/64	0.671875	17.07
11/16	0.6875	17.46
45/64	0.703125	17.86
23/32	0.71875	18.26
47/64	0.734375	18.65
3/4	0.75	19.05
49/64	0.765625	19.45
25/32	0.78125	19.84
51/64	0.796875	20.24
13/16	0.8125	20.64
53/64	0.828125	21.03
27/32	0.84375	21.43
55/64	0.859375	21.83
7/8	0.875	22.23
57/64	0.890625	22.62
29/32	0.90625	23.02
59/64	0.921875	23.42
15/16	0.9375	23.81
61/64	0.953125	24.21
31/32	0.96875	24.61
63/64	0.984375	25.00
1	1.0	25.40

Conversion Charts

WEIGHT CONVERSION CONSTANTS FOR METRIC AND US UNITS

Metric to US Units	US Units to Metric
Grams x .03527 = Ounces	Ounces x 28.35 = Grams
Kilograms x 35.27 = Ounces	Ounces x .02835 = Kilograms
Kilograms x 2.20462 = Pounds	Pounds x .45359 = Kilograms
Kilograms/Cubic Meter x .06243 = Pounds/Cubic Foot	Pounds/Cubic Foot x 16.01848 = Kilograms/Cubic Meter
Metric Tons (1000 Kg.) x 1.10231 = Net Tons (2000 lbs.)	Net Tons (2000 lbs.) x .90719 = Metric Tons (1000 Kg.)
Metric Tons (1000 Kg.) x .98421 = Long Tons (2240 lbs.)	Long Tons (2240 lbs.) x 1.01605 = Metric Tons (1000 Kg.)
Newtons x .22481 = Pounds Force	Pounds Force x 4.44822 = Newtons
Newtons/Millimeter^2 x 145.03829 = Pounds Force/Inch^2	Pounds Force/Inch^2 x .00689 = Newtons/Millimeter^2

LENGTH CONVERSION CONSTANTS FOR METRIC AND US UNITS

Metric to US Units	US Units to Metric
Millimeters x .039370 = Inches	Inches x 25.4001 = Millimeters
Meters x 39.370 = Inches	Inches x .0254 = Meters
Meters x 3.2808 = Feet	Feet x .30480 = Meters
Meters x 1.09361 = Yards	Yards x .91440 = Meters
Meters/Second x 132.2772 = Feet/Minute	Feet/Minute x .00756 = Meters/Second
Kilometers x 3280.8 = Feet	Feet x .0003048 = Kilometers

AREA CONVERSION CONSTANTS FOR METRIC AND US UNITS

Metric to US Units	US Units to Metric
Square Millimeters x .00155 = Square Inches	Square Inches x 645.163 = Square Millimeters
Square Centimeters x .155 = Square Inches	Square Inches x 6.45163 = Square Centimeters
Square Meters x 10.76387 = Square Feet	Square Feet x .0929 = Square Meters
Square Meters x 1.19599 = Square Yards	Square Yards x .83613 = Square Meters

Notes

Webster FS Series and CoilWeb® Vibrating Conveyors

DESIGN BENEFITS

- Will readily handle hot or abrasive materials.
- Will handle fragile materials (potato chips, cereal flakes, etc.) without degradation.
- Smooth continuous trough, no pockets for material to accumulate in, no jamming of material.
- Conveyor is normally self-cleaning.
- No return strand to carry over.
- Simple construction with minimum number of moving parts.
- Moving parts are not in contact with material.
- Minimum safety hazard to persons working on or near conveyor.
- Pan is usually widest part of conveyor.
- Is easily enclosed, even at transfer points.
- Discharge end may be tapered to spread material.
- Abrupt discharge.
- Little headroom required for change in direction or discharge to other equipment.
- Problems at discharge or transfer points are minimized because of relatively low conveying speed, low headroom required and abrupt discharge. If problems do occur they may be easily corrected by modifying end of pan.
- Multiple discharge points are possible.
- Can perform special operations (scalping, dedusting, magnetic separation, lump breaking, washing, heating, cooling, drying, etc.) while conveying.
- Unit machines have been completely assembled and tested at the factory. Minimum work and time required at installation.

DESIGN LIMITATIONS

- Not all materials can be conveyed.
- Is not a positive type of conveyor, conveying speed obtained may vary with different materials.
- Slope up which material can be conveyed is limited.
- Substantial foundation or supporting structure or special construction required because of unbalanced forces.
- Limited length of conveyor per drive.

DESIGN FEATURES

- **CONTROLLED VIBRATION** The movement of material on the pan of a vibrating conveyor is dependent on the vibratory motion of the pan. On all Webster vibrating conveyors amplitude, direction and frequency of the vibratory motion are selected and controlled to give a gentle hopping action to the material being conveyed so as to minimize material degradation, wear of the conveying surface, noise level and drive forces. The amplitude and frequency of vibration are also selected so that oversize motors are not required for starting.
- **NATURAL FREQUENCY** When the stiffness of the springs which support and guide the pan is selected so the natural or resonant frequency of the pan-spring system is very nearly the same as the operating frequency of the conveyor, most of the power required to vibrate the empty pan is alternately stored and released by the springs. It is only necessary for the drive to furnish the power required to overcome frictional forces and to convey material. This results in minimum power requirements, minimum drive forces and a uniform distribution of inertia forces over the length of the conveyor. All Webster vibrating conveyors employ this principle of operation.

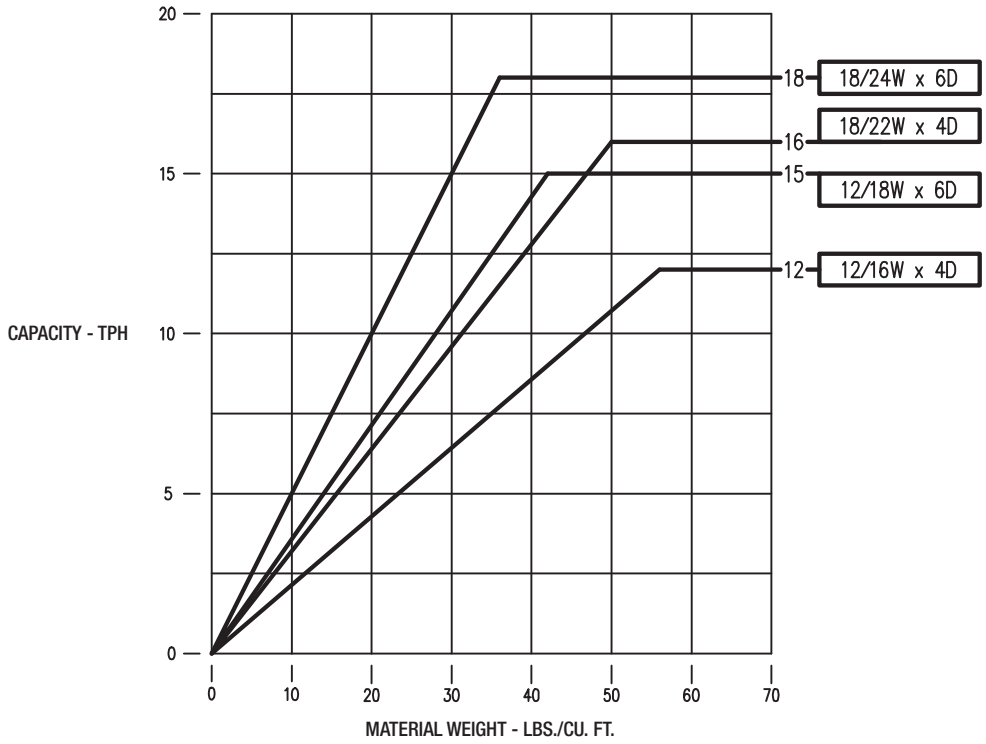
Model FSL Selection

The motor size and capacity charts are based on a conveying speed of 25 FPM at ½" stroke and 585 RPM operating frequency. The nominal rated capacity of these standard Webster model FSL vibrating conveyors is shown on the following chart.

CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Base Size	Stroke	Operating Frequency	Motor Size (1200 RPM)			
Width	Depth	Thk.				1 HP	2 HP	3 HP	5 HP
12/16	4"	10 Ga.	Narrow	½"	585 RPM	29'-0"	74'-0"	122'-0"	—
12/18	6"	10 Ga.	Narrow	½"	585 RPM	24'-0"	63'-0"	104'-0"	—
18/22	4"	3/16"	Wide	½"	585 RPM	15'-0"	40'-0"	66'-0"	101'-0"
18/24	6"	3/16"	Wide	½"	585 RPM	13'-0"	35'-0"	59'-0"	90'-0"

CAPACITY CHART



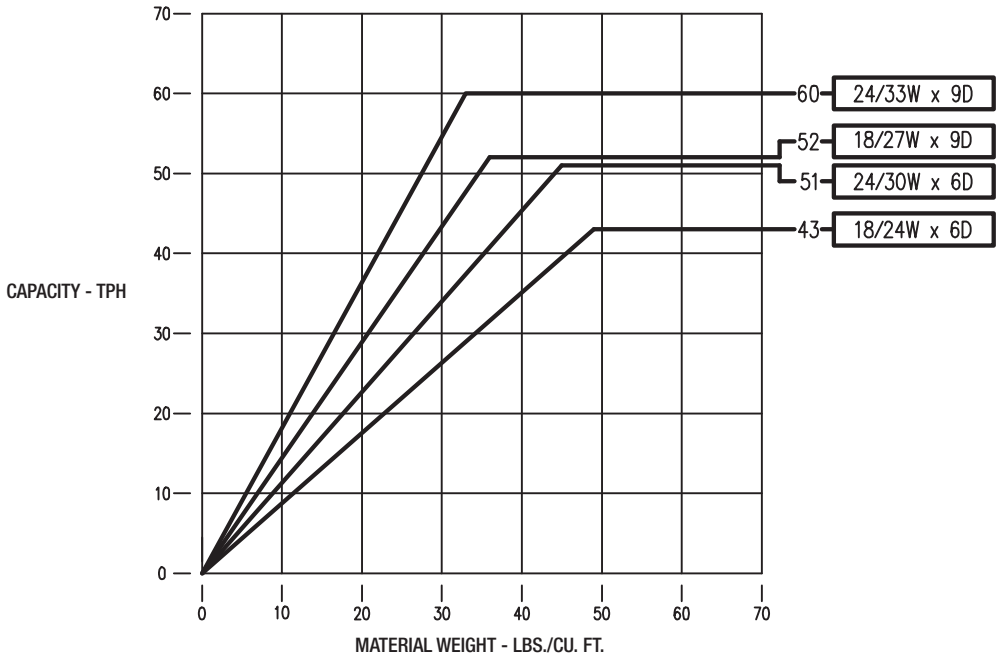
Model FSM Selection

The motor size and capacity charts are based on a conveying speed of 45 FPM at 9/16" stroke and 585 RPM operating frequency. The nominal rated capacity of these standard Webster model FSM vibrating conveyors is shown on the following chart.

CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Base Size	Stroke	Operating Frequency	Motor Size (1200 RPM)			
Width	Depth	Thk.				2 HP	3 HP	5 HP	7½ HP
18/24	6"	3/16"	Wide	9/16"	585 RPM	25'-0"	43'-0"	67'-0"	99'-0"
18/24	6"	1/4"	Wide	9/16"	585 RPM	19'-0"	32'-0"	51'-0"	75'-0"
18/27	9"	3/16"	Wide	9/16"	585 RPM	21'-0"	37'-0"	57'-0"	85'-0"
18/27	9"	1/4"	Wide	9/16"	585 RPM	16'-0"	27'-0"	43'-0"	64'-0"
24/30	6"	3/16"	Wide	9/16"	585 RPM	20'-0"	35'-0"	56'-0"	83'-0"
24/30	6"	1/4"	Wide	9/16"	585 RPM	15'-0"	27'-0"	42'-0"	63'-0"
24/33	9"	3/16"	Wide	9/16"	585 RPM	17'-0"	31'-0"	49'-0"	73'-0"
24/33	9"	1/4"	Wide	9/16"	585 RPM	13'-0"	23'-0"	37'-0"	55'-0"

CAPACITY CHART



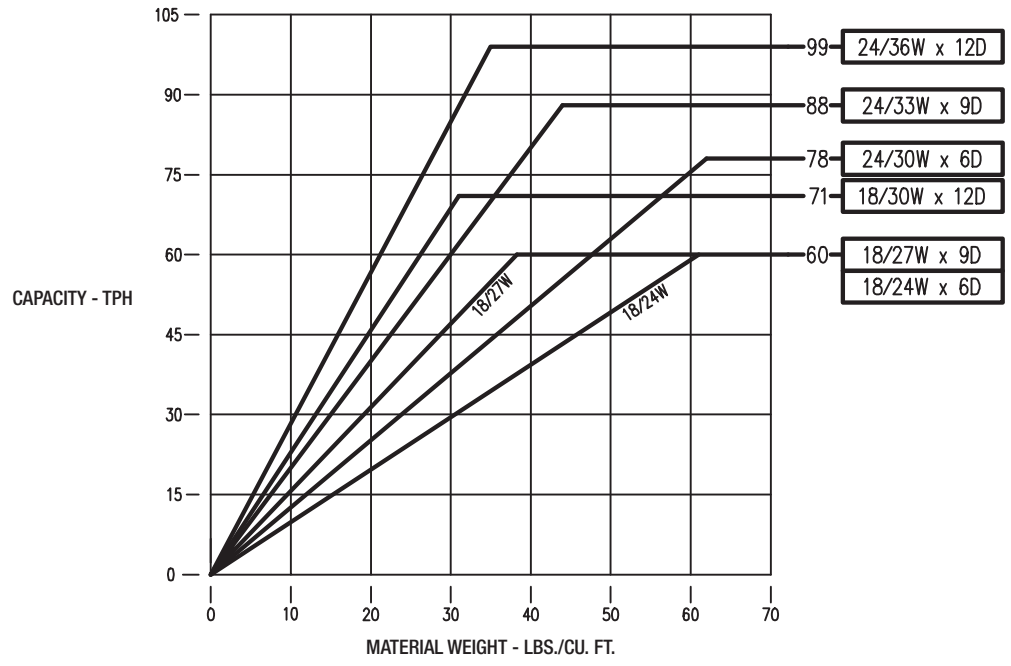
Model FSH Selection

The motor size and capacity charts are based on a conveying speed of 50 FPM at ⅝" stroke and 550 RPM operating frequency. The nominal rated capacity of these standard Webster model FSH vibrating conveyors is shown on the following chart.

CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Base Size	Stroke	Operating Frequency	Motor Size (1200 RPM)					
Width	Depth	Thk.				3 HP	5 HP	7½ HP	10 HP	15 HP	20 HP
18/24	6"	¼"	Narrow	⅝"	550 RPM	27'-0"	44'-0"	66'-0"	88'-0"	121'-0"	—
18/27	9"	¼"	Narrow	⅝"	550 RPM	23'-0"	38'-0"	57'-0"	76'-0"	104'-0"	134'-0"
18/30	12"	¼"	Narrow	⅝"	550 RPM	20'-0"	32'-0"	48'-0"	64'-0"	87'-0"	113'-0"
24/30	6"	5/16"	Narrow	⅝"	550 RPM	18'-0"	29'-0"	44'-0"	58'-0"	79'-0"	102'-0"
24/33	9"	5/16"	Narrow	⅝"	550 RPM	16'-0"	26'-0"	39'-0"	51'-0"	70'-0"	91'-0"
24/36	12"	5/16"	Narrow	⅝"	550 RPM	14'-0"	23'-0"	35'-0"	46'-0"	63'-0"	81'-0"

CAPACITY CHART



Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

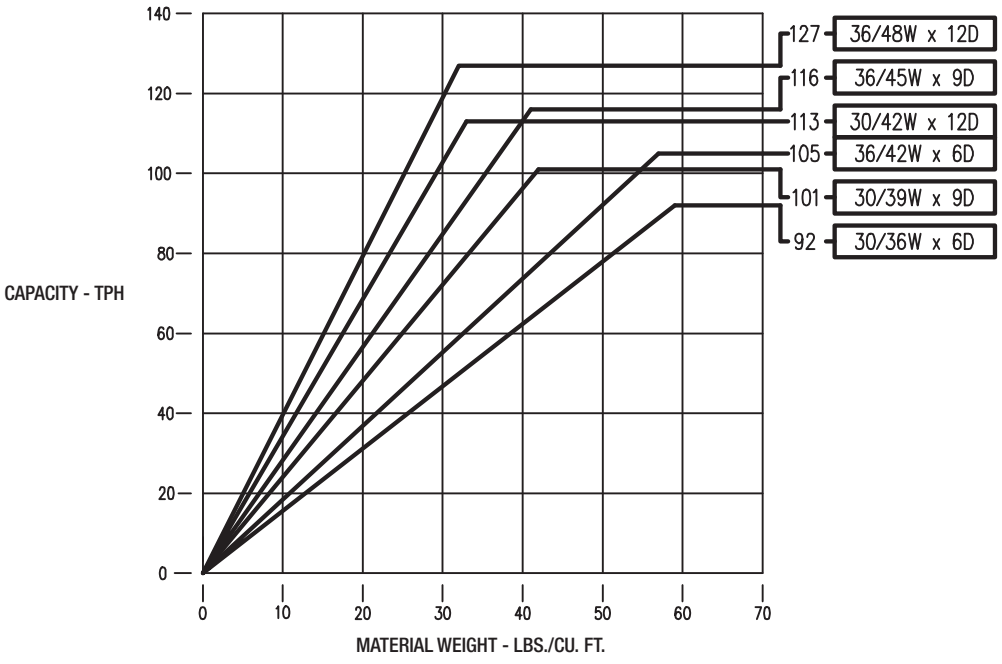
Model FSH Selection

The motor size and capacity charts are based on a conveying speed of 50 FPM at ⅝" stroke and 550 RPM operating frequency. The nominal rated capacity of these standard Webster model FSH vibrating conveyors is shown on the following chart.

CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Base Size	Stroke	Operating Frequency	Motor Size (1200 RPM)					
Width	Depth	Thk.				3 HP	5 HP	7½ HP	10 HP	15 HP	20 HP
30/36	6"	5/16"	Wide	⅝"	550 RPM	13'-0"	23'-0"	36'-0"	48'-0"	67'-0"	87'-0"
30/39	9"	5/16"	Wide	⅝"	550 RPM	12'-0"	21'-0"	32'-0"	44'-0"	60'-0"	79'-0"
30/42	12"	5/16"	Wide	⅝"	550 RPM	11'-0"	18'-0"	29'-0"	39'-0"	54'-0"	71'-0"
36/42	6"	5/16"	Wide	⅝"	550 RPM	11'-0"	20'-0"	31'-0"	42'-0"	58'-0"	76'-0"
36/45	9"	5/16"	Wide	⅝"	550 RPM	10'-0"	18'-0"	28'-0"	38'-0"	53'-0"	69'-0"
36/48	12"	5/16"	Wide	⅝"	550 RPM	9'-0"	16'-0"	26'-0"	35'-0"	49'-0"	63'-0"

CAPACITY CHART



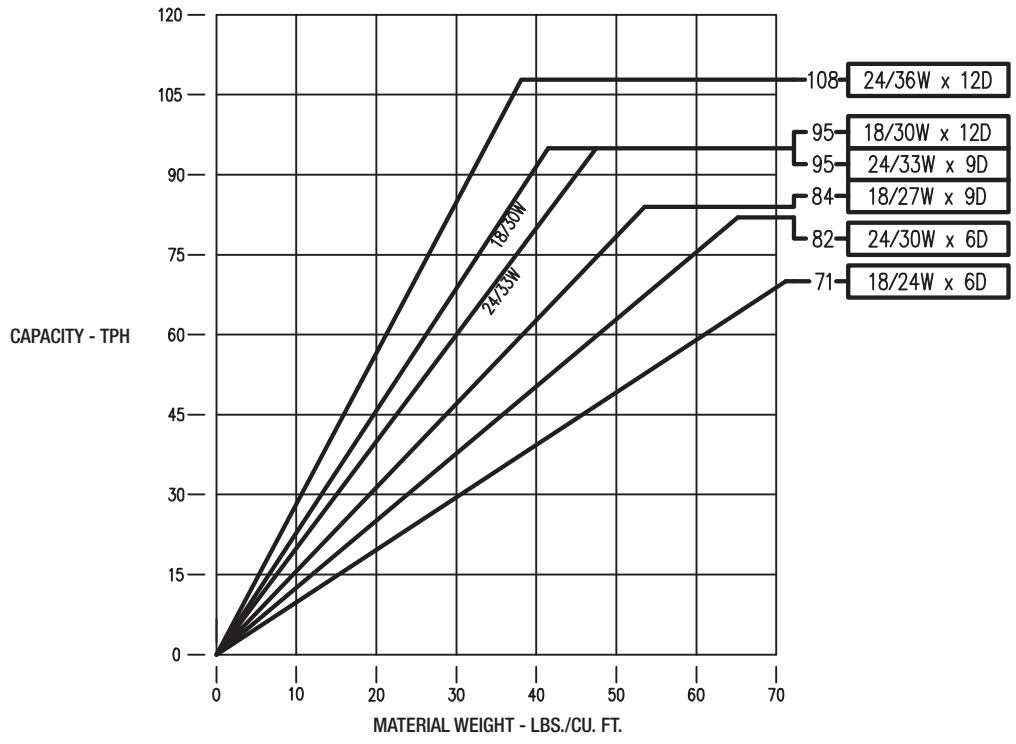
Model CoilWeb® Selection

The motor size and capacity charts are based on a conveying speed of 50 FPM at ⅞" stroke and 420 RPM operating frequency. The nominal rated capacity of these standard Webster model CoilWeb® vibrating conveyors is shown on the following chart.

UNBALANCED CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Stroke	Operating Frequency	Motor Size (1200 RPM)				
Width	Depth	Thk.			1½ HP	2 HP	3 HP	5 HP	7½ HP
18/24	6"	¼"	⅞"	420 RPM	29'-0"	34'-0"	66'-0"	103'-0"	150'-0"
18/27	9"	¼"	⅞"	420 RPM	26'-0"	31'-0"	59'-0"	93'-0"	136'-0"
18/30	12"	¼"	⅞"	420 RPM	22'-0"	26'-0"	51'-0"	80'-0"	117'-0"
24/30	6"	¼"	⅞"	420 RPM	24'-0"	29'-0"	57'-0"	89'-0"	131'-0"
24/33	9"	¼"	⅞"	420 RPM	21'-0"	26'-0"	50'-0"	79'-0"	117'-0"
24/36	12"	¼"	⅞"	420 RPM	19'-0"	23'-0"	45'-0"	72'-0"	105'-0"

CAPACITY CHART



Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

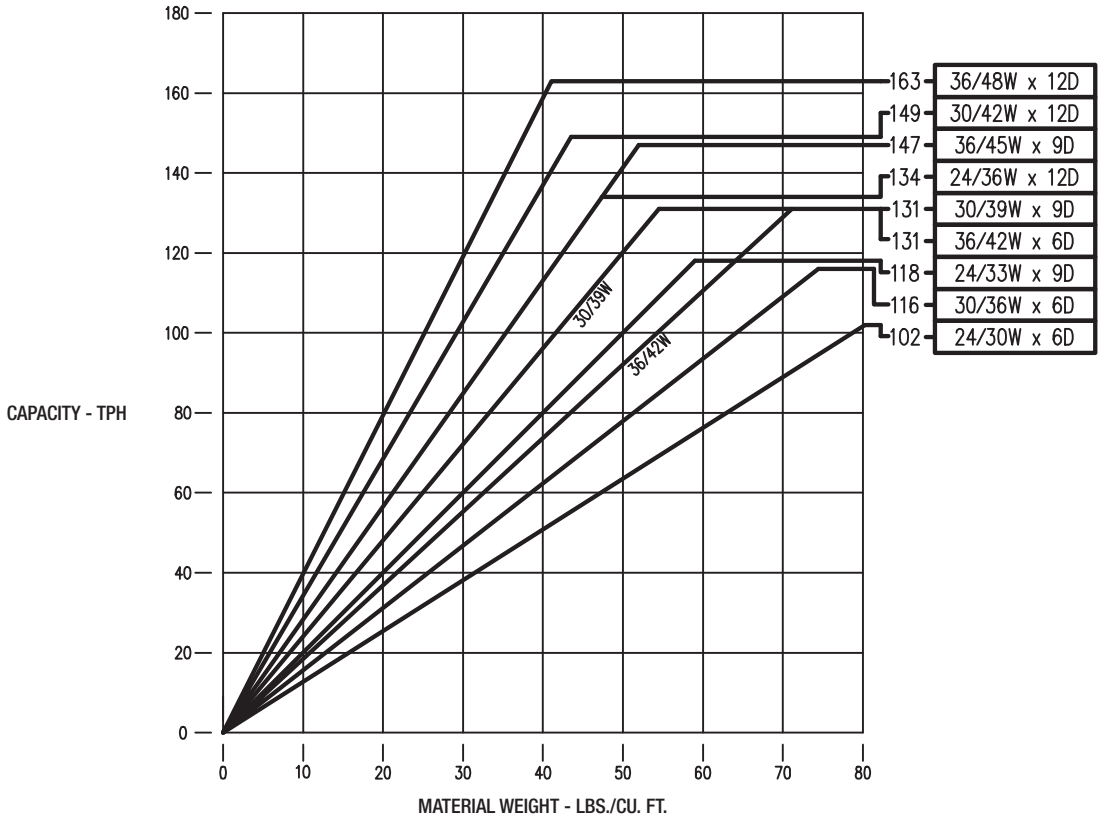
Model CoilWeb® LS Selection

The motor size and capacity charts are based on a conveying speed of 50 FPM at ⅞" stroke and 420 RPM operating frequency. The nominal rated capacity of these standard Webster model CoilWeb® LS vibrating conveyors is shown on the following charts.

UNBALANCED CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Stroke	Operating Frequency	Motor Size (1200 RPM)					
Width	Depth	Thk.			3 HP	5 HP	7½ HP	10 HP	15 HP	20 HP
24/30	6"	⅜"	⅞"	420 RPM	44'-0"	64'-0"	91'-0"	131'-0"	191'-0"	238'-0"
24/33	9"	⅜"	⅞"	420 RPM	39'-0"	57'-0"	80'-0"	116'-0"	169'-0"	210'-0"
24/36	12"	⅜"	⅞"	420 RPM	35'-0"	51'-0"	72'-0"	104'-0"	151'-0"	188'-0"
30/36	6"	⅜"	⅞"	420 RPM	38'-0"	55'-0"	78'-0"	113'-0"	165'-0"	205'-0"
30/39	9"	⅜"	⅞"	420 RPM	34'-0"	49'-0"	70'-0"	101'-0"	148'-0"	184'-0"
30/42	12"	⅜"	⅞"	420 RPM	31'-0"	45'-0"	63'-0"	92'-0"	134'-0"	167'-0"
36/42	6"	⅜"	⅞"	420 RPM	33'-0"	48'-0"	69'-0"	99'-0"	145'-0"	181'-0"
36/45	9"	⅜"	⅞"	420 RPM	30'-0"	44'-0"	62'-0"	90'-0"	132'-0"	164'-0"
36/48	12"	⅜"	⅞"	420 RPM	27'-0"	40'-0"	57'-0"	83'-0"	121'-0"	150'-0"

CAPACITY CHART



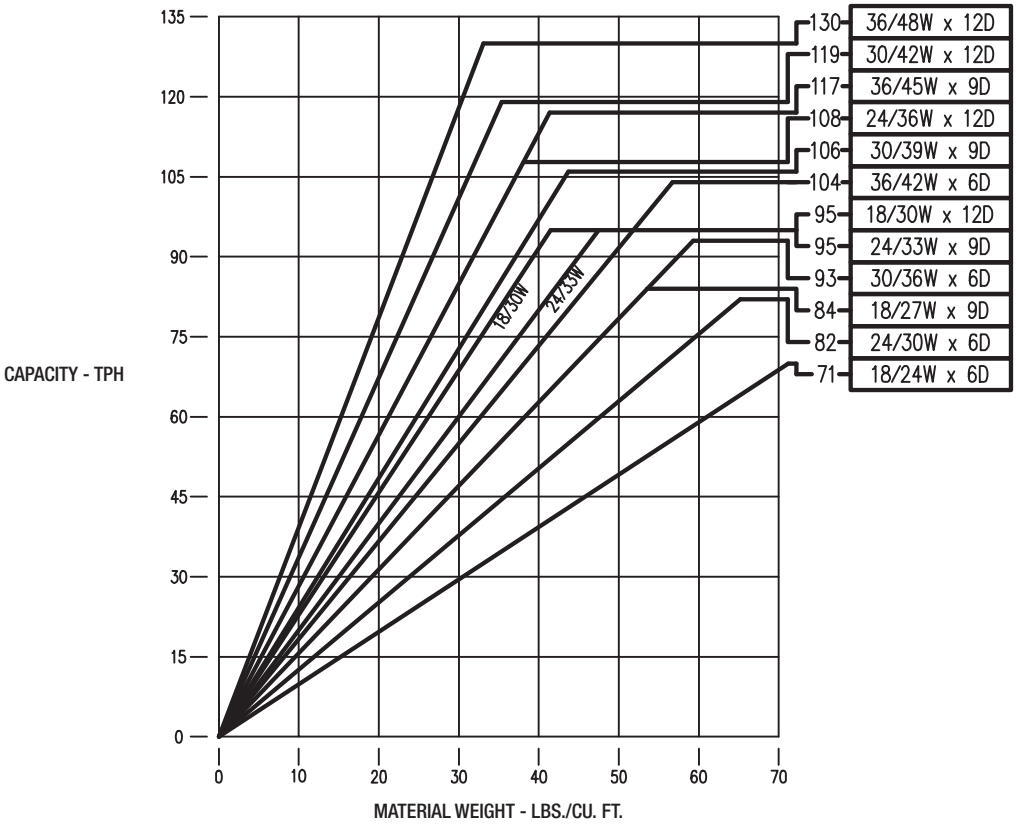
Model CoilWeb® LS Selection

The motor size and capacity charts are based on a conveying speed of 50 FPM at ⅞" stroke and 420 RPM operating frequency. The nominal rated capacity of these standard Webster model CoilWeb® LS vibrating conveyors is shown on the following charts.

BALANCED CONVEYOR LENGTH AND MOTOR SIZE

Pan Size			Stroke	Operating Frequency	Motor Size (1200 RPM)				
Width	Depth	Thk.			5 HP	7½ HP	10 HP	15 HP	20 HP
24/30	6"	¼"	⅞"	420 RPM	42'-0"	61'-0"	89'-0"	126'-0"	163'-0"
24/33	9"	¼"	⅞"	420 RPM	38'-0"	54'-0"	79'-0"	112'-0"	145'-0"
24/36	12"	¼"	⅞"	420 RPM	34'-0"	49'-0"	71'-0"	101'-0"	131'-0"
30/36	6"	¼"	⅞"	420 RPM	36'-0"	52'-0"	76'-0"	108'-0"	139'-0"
30/39	9"	¼"	⅞"	420 RPM	33'-0"	47'-0"	69'-0"	97'-0"	126'-0"
30/42	12"	¼"	⅞"	420 RPM	30'-0"	43'-0"	62'-0"	89'-0"	115'-0"
36/42	6"	¼"	⅞"	420 RPM	32'-0"	46'-0"	67'-0"	95'-0"	122'-0"
36/45	9"	¼"	⅞"	420 RPM	29'-0"	42'-0"	61'-0"	86'-0"	112'-0"
36/48	12"	¼"	⅞"	420 RPM	26'-0"	38'-0"	56'-0"	80'-0"	103'-0"

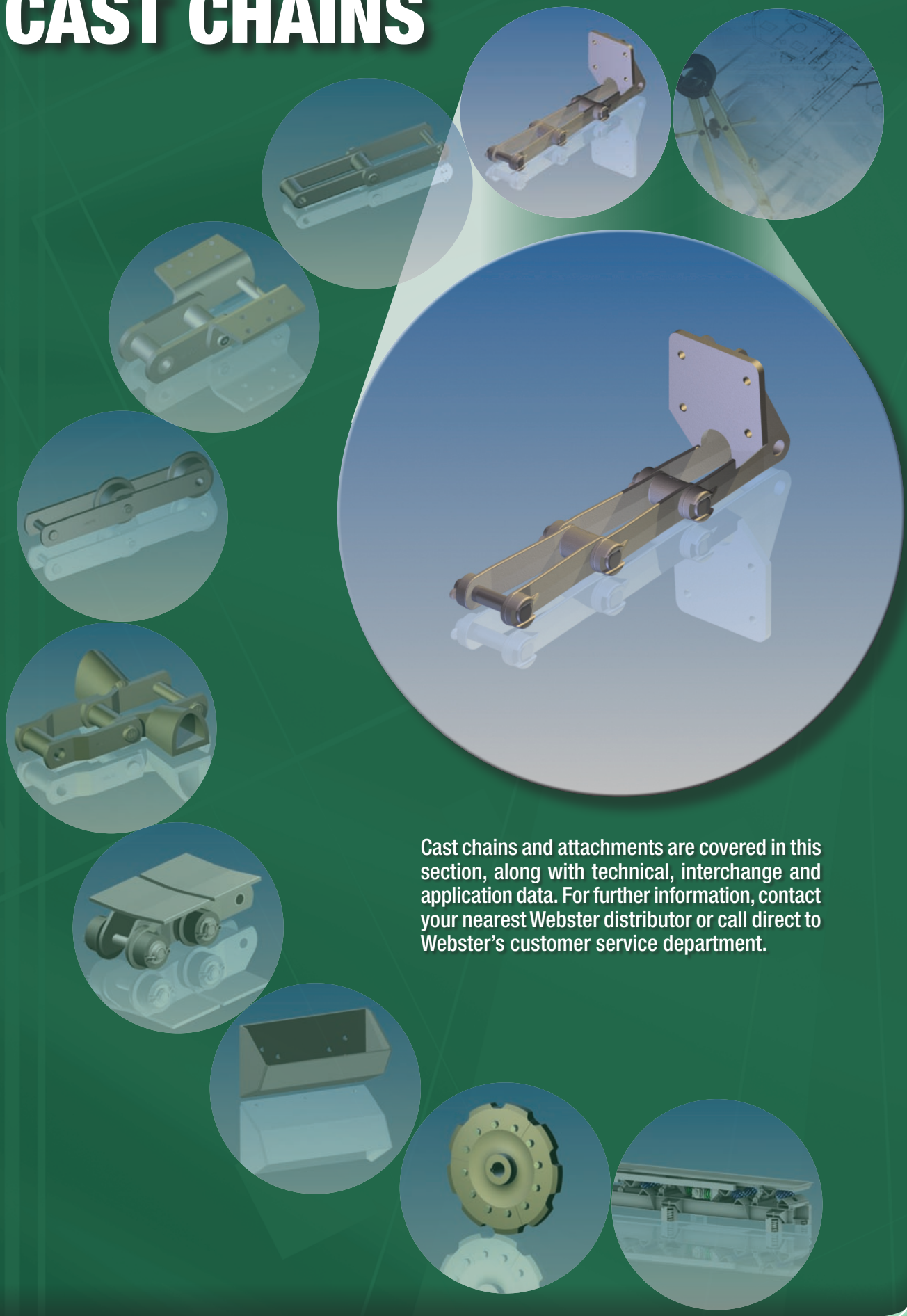
CAPACITY CHART



Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Notes

CAST CHAINS



Cast chains and attachments are covered in this section, along with technical, interchange and application data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

400 Class Pintle Chains



400 class pintle chains are of one-piece cast offset link construction joined together by steel pins. The pins are securely locked against turning in the sidebars by generous head stops that are cast on the links. The head stops are positioned to provide maximum locking effect when the chain is under load. This confines the wear to the part of the pin inside the barrel of the link, where it is distributed over the maximum area. This insures the best durability of the chain.

MATERIAL

400 class pintle chains are links cast of high grade copper bearing malleable iron or Duramal. Duramal is a heat treated malleable iron having greater strength and superior resistance to wear and abrasion. Duramal chains have heat treated pins.

ASSEMBLY

Riveted construction is furnished unless cottered construction is requested.

INTERCHANGEABILITY

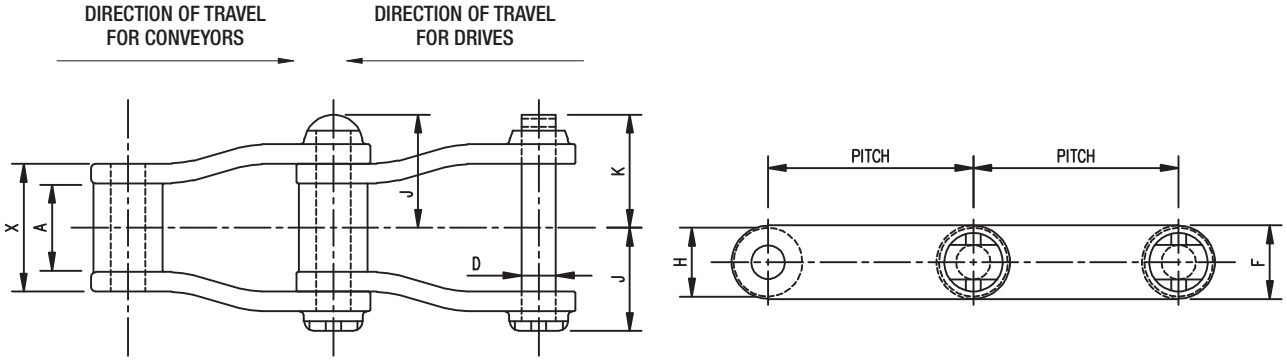
400 class pintle chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

When furnished with attachments, 400 class pintle chains are normally used for conveyors and elevators where much slower speeds are recommended.

OPERATION

The maximum speed of this chain is generally 450 FPM, but depends upon size of sprockets. For Drive Service see Table 10, Section A. For Conveyor Service see Table 2, Section A.

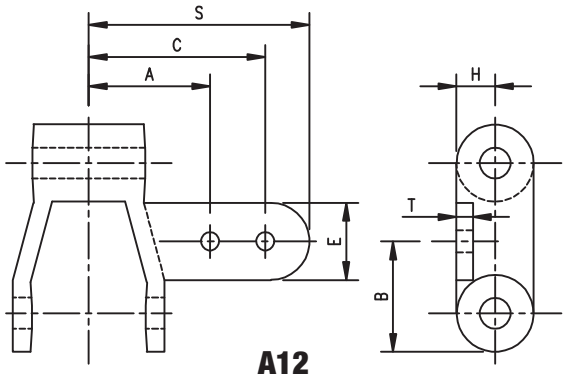


Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.		Rated Working Load in Lbs.★		Dimensions in Inches							Attachment Numbers
								Barrel Length	Sidebar Width	Max. Spkt. Width	Pin Dia.	Barrel Dia.	℄ To Cotter End	℄ To Head or Rivet End	
				Malleable	Duramal	Malleable	Duramal	X	F	A	D	H	K	J	
442	1.375	88	1.4	6,000	7,500	830	995	1 1/16	3/4	5/8	5/16	9/16	1 1/16	1	
445	1.630	74	1.5	6,000	7,500	830	995	1 1/16	23/32	11/16	5/16	5/8	1 1/16	1	F2, H2, K1
452	1.506	80	2.0	7,000	8,750	1,055	1,265	1 1/8	27/32	5/8	3/8	11/16	1 1/16	1	D5, K1
455	1.630	74	1.9	7,300	9,125	1,055	1,265	1 1/8	13/16	11/16	3/8	5/8	1 1/8	1 1/32	F2, K1
462	1.634	73	2.5	9,000	11,250	1,500	1,800	1 7/16	15/16	7/8	7/16	13/16	1 5/16	1 1/4	A12, G1, K1
477	2.308	52	2.0	9,600	12,000	1,365	1,640	1 1/4	1	11/16	7/16	13/16	1 9/32	1 5/32	F2, G1, G19, K1
488	2.609	46	2.9	11,000	13,750	1,775	2,130	1 5/8	15/16	15/16	7/16	7/8	1 7/16	1 5/16	F2, G19, G19SPC, K1, K2
4103	3.075	39	5.7	22,000	27,500	3,515	4,218	1 7/8	1 1/2	1 1/8	3/4	1 1/4	1 27/32	1 25/32	A22, F2, F29, K2
4124	4.063	30	8.5	33,000	41,250	4,570	5,485	2 1/4	1 3/4	1 1/4	13/16	1 11/16	2 13/32	2 5/32	F8

400 Class Pintle Chain Attachments

A12↔

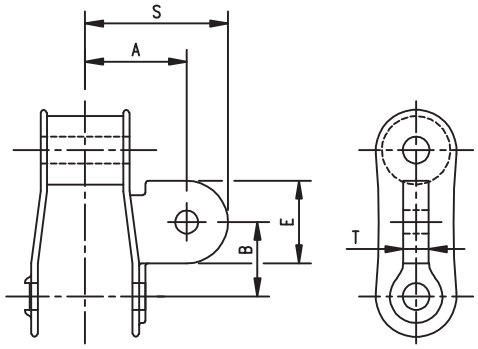
Chain No.	A	B	C	E	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
462	1 3/8	13/16	2	7/8	7/16	2 1/2	3/16	1.8	1/4



A12

A22

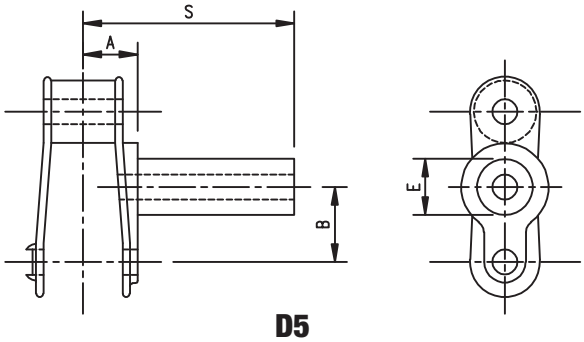
Chain No.	A	B	E	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
4103	2	1 7/16	1 5/8	2 13/16	1/2	7.2	5/8



A22

D5↔

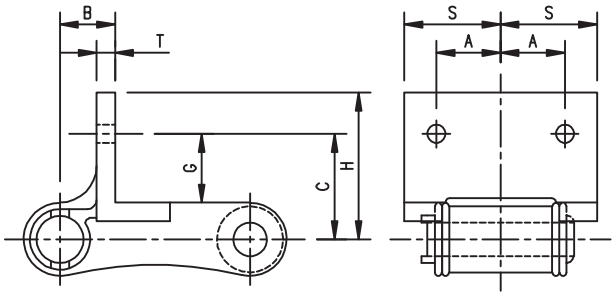
Chain No.	A	B	E	S	Weight Per Foot-Lbs. Δ
452	15/16	3/4	9/16	2 1/2	3.2



D5

F2

Chain No.	A	B	C	G	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
445	17/32	5/8	15/16	9/16	1 1/4	25/32	5/32	2.0	3/16
455	17/32	5/8	15/16	1/2	1 1/4	7/8	5/32	2.7	3/16
477	7/8	3/4	1 7/16	15/16	2	1 5/16	1/4	3.7	5/16
488	1	1 1/8	1 13/32	15/16	2 1/32	1 1/2	1/4	4.5	5/16
4103	1 7/64	1 1/4	2	1 1/4	2 11/16	1 9/16	5/16	8.1	3/8



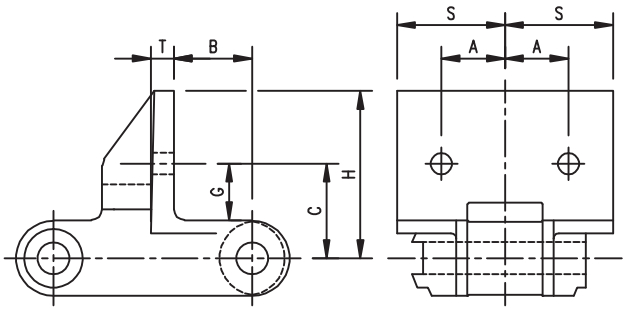
F2

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

400 Class Pintle Chain Attachments

F8

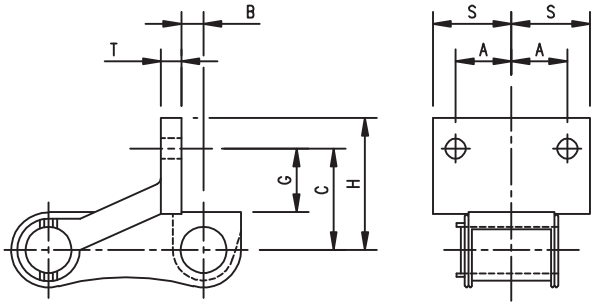
Chain No.	A	B	C	G	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
4124	1 15/32	1 13/16	2 3/16	1 5/16	3 7/8	2 1/2	17/32	9.6	1/2



F8

F29

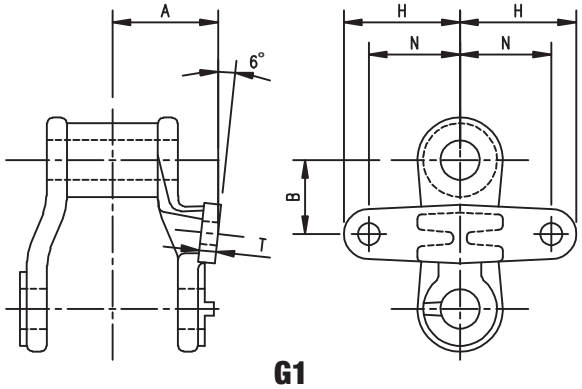
Chain No.	A	B	C	G	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
4103	1 7/64	7/16	2 1/64	1 17/64	2 5/8	1 9/16	13/32	9.6	3/8



F29

G1

Chain No.	A	B	H	N	T	Weight Per Foot-Lbs. Δ	Bolt Size
462	1 1/4	13/16	1 3/8	1	3/16	3.5	1/4
477	1 3/8	1 5/32	1 3/4	1 5/16	1/4	3.0	5/16



G1

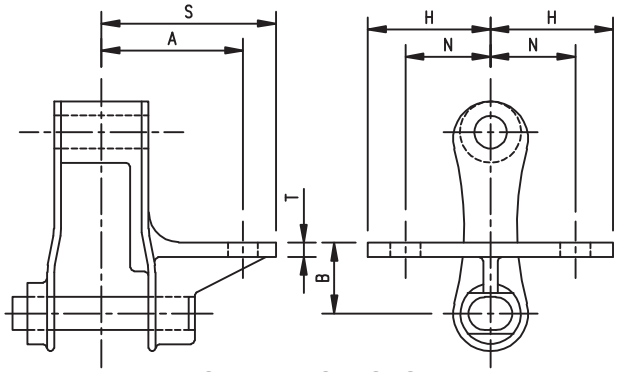
G19

Chain No.	A	B	H	N	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
477	1 3/4	1 3/8	1 5/8	1 1/8	2 5/16	3/16	3.0	7/16
488	1 15/16	1 3/8	1 13/16	1 5/16	2 11/16	1/4	3.9	3/8

G19SPC

488	2	1 7/8	1 3/16	11/16	2 1/2	3/8	3.8	3/8

Attachment faces opposite direction shown.

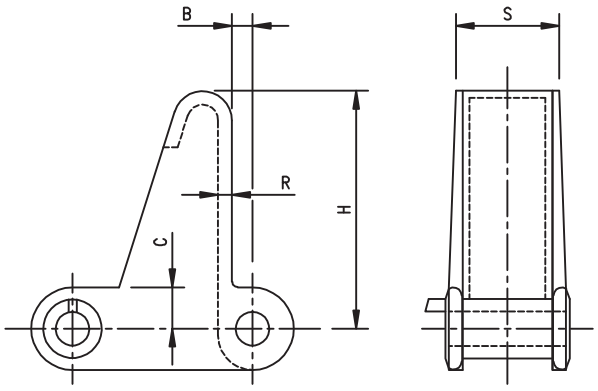


G19 and G19SPC

400 Class Pintle Chain Attachments

H2

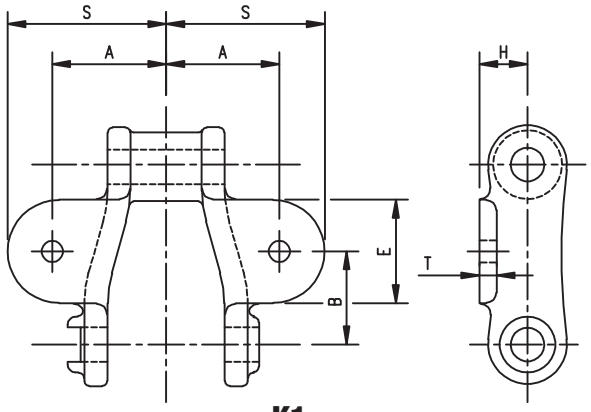
Chain No.	B	C	H	R	S	Weight Per Foot-Lbs. Δ
445	3/16	3/8	2 5/32	1/8	15/16	2.7



H2

K1

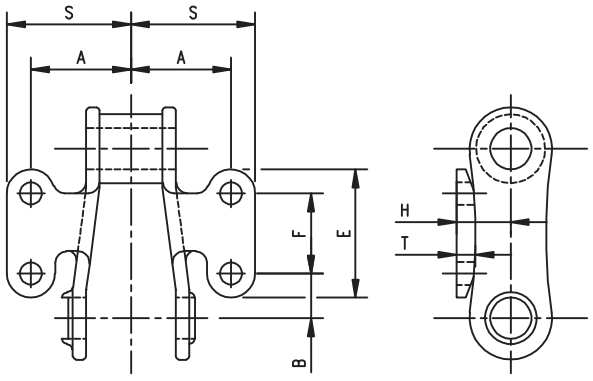
Chain No.	A	B	E	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
445	1 1/32	3/4	15/16	7/16	1 7/16	5/32	2.1	3/16
452	1 1/32	3/4	3/4	27/64	1 3/8	5/32	2.5	3/16
455	1	3/4	7/8	7/16	1 7/16	5/32	2.3	1/4
462	1 7/32	13/16	7/8	1/2	1 23/32	5/32	3.2	1/4
477	1 1/2	1 5/32	1 3/8	11/16	1 31/32	1/8	2.9	1/4□
488	1 7/8	1 5/16	1 3/8	11/16	2 3/8	5/32	3.9	5/16



K1

K2

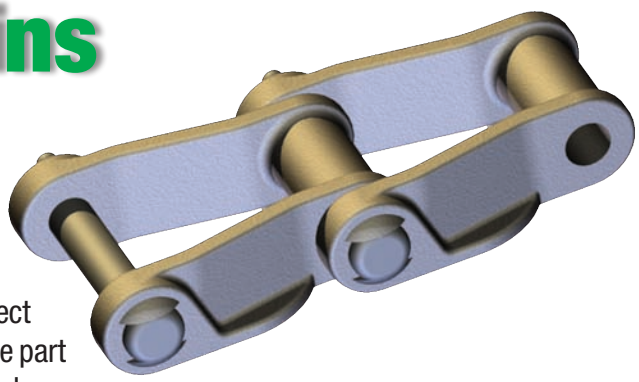
Chain No.	A	B	E	F	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
488	1 13/16	21/32	2 1/8	1 1/4	21/32	2 1/4	3/16	4.6	5/16
4103	2 1/16	13/16	2 5/8	1 1/2	13/16	2 5/8	5/16	8.6	1/2



K2

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

H Class Mill Chains



H class mill chains are of one-piece cast offset link construction joined together by steel clipped head pins. The pins are securely locked against turning in the sidebars by generous head stops cast on the links. The head stops are positioned to provide maximum locking effect when the chain is under load. This confines the wear to the part of the pin inside the barrel of the link, where it is distributed over the maximum area. This insures the best durability of the chain.

MATERIAL

Links are cast of high grade copper bearing malleable iron or Duramal. Duramal is a heat treated malleable iron having greater strength and superior resistance to wear and abrasion. Duramal chains have heat treated pins.

ASSEMBLY

Riveted construction is furnished unless cottered construction is requested.

INTERCHANGEABILITY

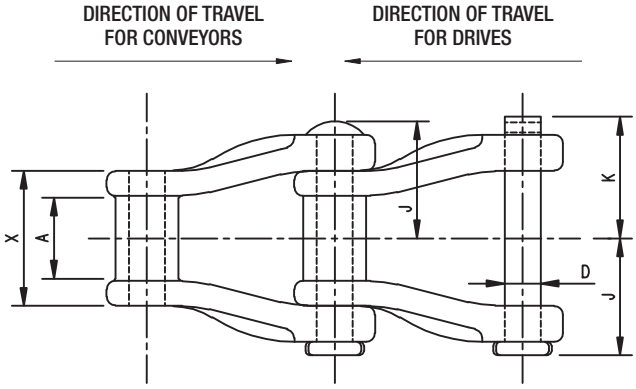
H class mill chains are interchangeable with other standard makes of corresponding sizes and numbers.

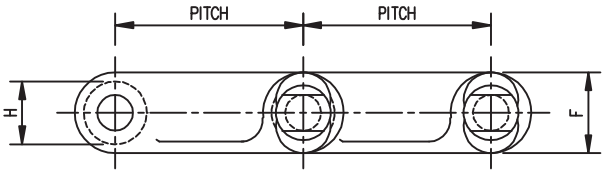
APPLICATION

H class mill chains are used primarily for drag conveyor service in the lumber, pulp and paper industries. They are also desirable for transfer and conveying purposes. The pin joint permits operation in a moderately dusty or abrasive atmosphere.

OPERATION

The maximum speed of this chain is generally 450 FPM, but depends upon size of sprockets. For Drive Service see Table 10, Section A. For Conveyor Service see Table 2, Section A.





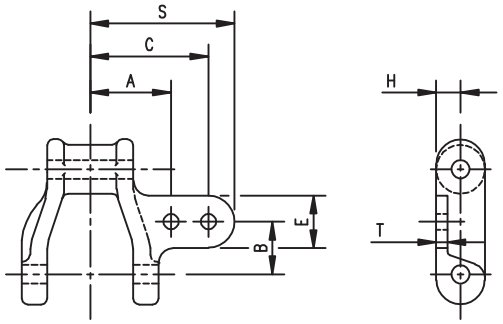
Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.		Rated Working Load in Lbs.★		Dimensions in Inches							Attachment Numbers
								Barrel Length	Sidebar Width	Max. Spkt. Width	Pin Dia.	Barrel Dia.	℄ To Cotter End	℄ To Head or Rivet End	
				Malleable	Duramal	Malleable	Duramal	X	F	A	D	H	K	J	
H60	2.308	52	2.1	7,000	8,750	1,170	1,400	1½	¾	¾	5/16	¾	1 7/16	1⅜	F4, H2, K1, RR
H62	1.654	73	2.4	7,000	8,750	1,030	1,235	1 5/16	13/16	⅞	5/16	13/16	1⅛	1 3/32	A12
H74	2.609	46	3.0	10,000	12,500	1,525	1,830	1⅝	1	1	⅜	⅞	1 9/16	1 7/16	F4, H2, K1, R1
H78	2.609	46	4.2	16,000	20,000	2,340	2,810	1⅞	1⅛	1⅛	½	⅞	⅞	1 19/32	E20, F4, G19, H1, H2, K1, K2, R1, RR
H82	3.075	39	5.5	20,000	25,000	3,080	3,695	2 3/16	1¼	1¼	9/16	1 7/32	2 1/16	1⅞	F4, H2, K1, K2, M1
H85	4.000	30	3.3	12,500	15,625	2,080	2,600	2⅝	1	1⅞	7/16	31/32	2	1 15/16	
H124	4.000	30	8.8	30,000	37,500	5,000	6,000	2¾	1 9/16	1⅝	¾	1 7/16	2 7/16	2¼	F4, K1

H62 has wear shoes omitted.

H Class Mill Chain Attachments

A12↔

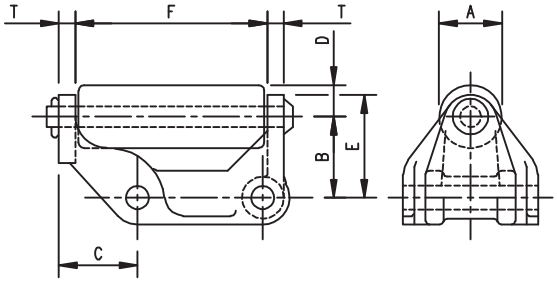
Chain No.	A	B	C	E	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
H62	1 11/32	7/8	1 31/32	7/8	13/32	2 13/32	3/16	3.3	1/4



A12

E20

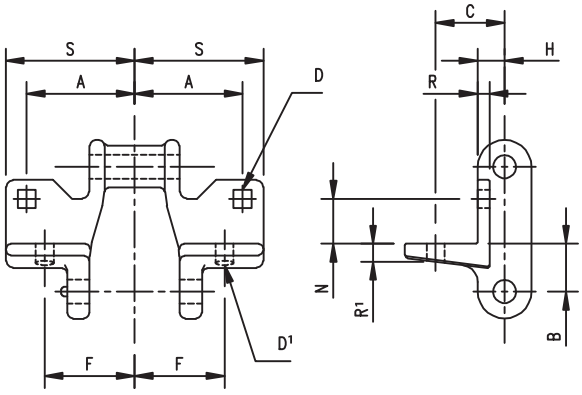
Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ΔΔ
H78	1 5/16	1 11/16	1 3/4	21/32	2 1/8	4	11/32	11.7



E20

F4

Chain No.	A	B	C	F	H	N	R	R¹	S	Weight Per Foot-Lbs. Δ	Bolt Size D	Bolt Size D¹
H60	1 31/32	7/8	1 1/4	1 17/32	3/8	3/4	3/16	5/16	2 3/8	4.7	3/8□	3/8
H74	2 1/16	1 3/16	1 7/16	1 5/8	1/2	5/8	1/4	3/8	2 7/16	6.0	5/16□	3/8
H78	2 1/4	1	1 7/16	1 7/8	9/16	15/16	1/4	3/8	2 11/16	8.1	3/8□	3/8
H82	2 1/2	1 1/4	1 1/2	2 1/16	5/8	7/8	9/32	3/8	3	8.9	3/8□	3/8
H124	2 21/32	1 1/2	1 5/8	2 3/16	13/16	1 1/16	9/32	1/2	3 1/8	11.8	3/8□	3/8



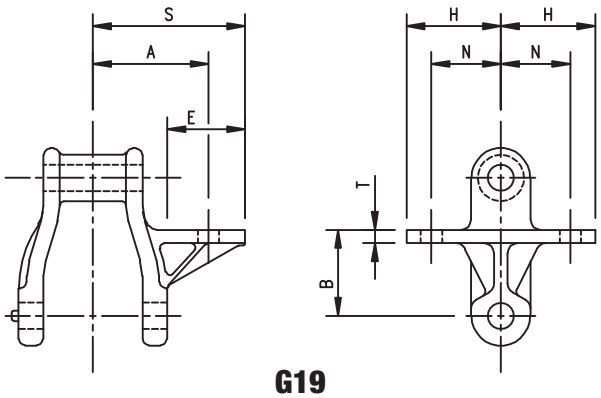
F4

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

H Class Mill Chain Attachments

G19 ↔

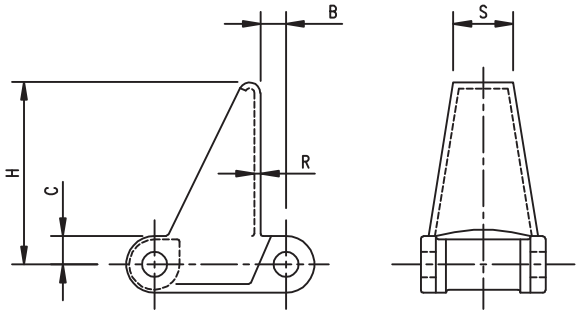
Chain No.	A	B	E	H	N	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
H78	2 3/16	1 5/8	1 1/4	1 25/32	1 5/16	2 7/8	1/4	5.9	3/8



G19

H1

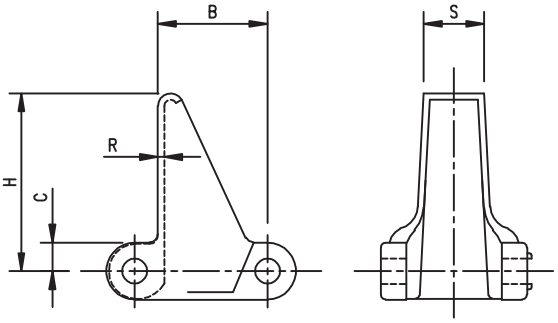
Chain No.	B	C	H	R	S	Weight Per Foot-Lbs. Δ
H78	1/2	9/16	3 5/8	1/8	1 3/16	6.8



H1

H2

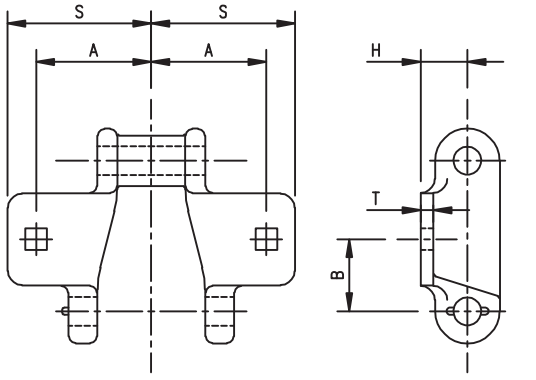
Chain No.	B	C	H	R	S	Weight Per Foot-Lbs. Δ
H60	2 1/8	3/8	2 7/16	3/32	1	3.4
H74	2 1/4	1/2	3 1/16	1/8	1 3/16	5.7
H78	2 5/32	9/16	3 1/2	1/8	1 3/16	6.5
H82	2 5/8	5/8	3 3/8	1/8	1 9/16	8.9



H2

K1

Chain No.	A	B	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
H60	1 1/2	1 1/16	3/4	2	3/16	2.8	5/16 ■
H74	1 7/16	1 1/4	1 1/16	1 15/16	7/32	3.5	5/16 □
H78	2	1 1/4	1 3/16	2 1/2	7/32	5.6	3/8 ■
H82	2 1/8	1 1/2	1 5/16	2 11/16	7/32	6.5	3/8 ■
H124	3	1 15/16	1	4	5/16	9.5	5/8 □

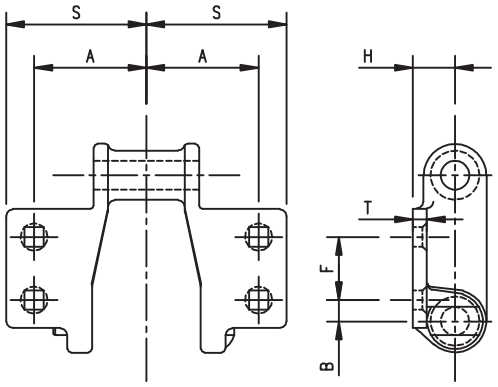


K1

H Class Mill Chain Attachments

K2

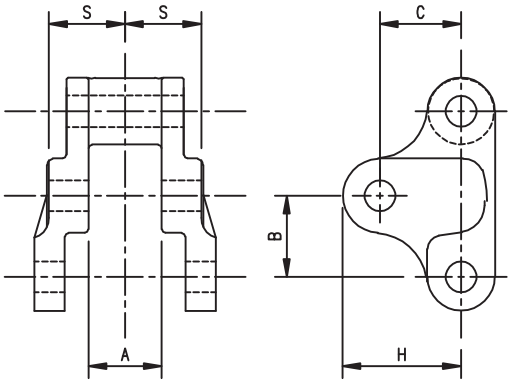
Chain No.	A	B	F	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
H78	2	3/8	1 1/8	3/4	2 1/2	1/4	6.7	5/16
H82	2 1/8	3/4	1 5/16	7/8	2 11/16	5/16	7.6	3/8 ■



K2

M1

Chain No.	A	B	C	H	S	Weight Per Foot-Lbs. Δ	Bolt Size
H82	1 7/16	1 1/2	1 1/2	2 3/16	1 13/32	8.9	5/8



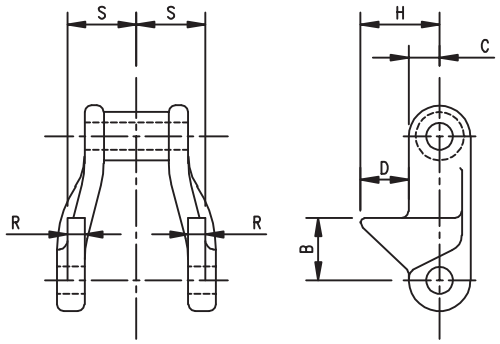
M1

R1 ↔

Chain No.	B	C	D	H	R	S	Weight Per Foot-Lbs. Δ
H74	1 1/4	1/2	1	1 1/2	1/4	1 1/4	3.4
H78	1 1/8	9/16	7/8	1 7/16	1/4	1 1/4	4.5

RR

H60	1 1/16	3/8	15/16	1 5/16	1/4	1 3/32	2.5
H78	1 1/8	9/16	7/8	1 7/16	1/4	1 1/4	5.0



R1 and RR

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

700 Class Pintle Chains



700 class pintle chains are of one-piece cast offset link construction joined together by steel clipped head pins. The pins are securely locked against turning in the sidebars by generous head stops cast on the links. The head stops are positioned to provide maximum locking effect when the chain is under load. This confines the wear to the part of the pin inside the barrel of the link, where it is distributed over the maximum area. This insures the best durability of the chain.

MATERIAL

Links are cast of high grade Duramal. Duramal is a heat treated copper bearing malleable iron having greater strength and superior resistance to wear, abrasion and corrosion. Pins are heat treated.

ASSEMBLY

Cottered construction is furnished unless riveted construction is requested.

INTERCHANGEABILITY

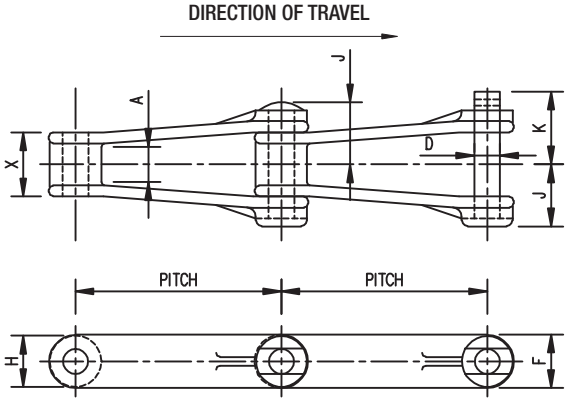
700 class pintle chains are interchangeable with other standard makes of corresponding sizes and numbers.

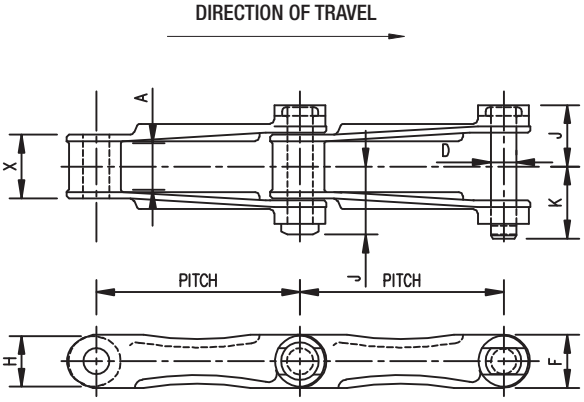
APPLICATION

700 class pintle chains are extensively used in water and wastewater treatment installations. The pin joint construction permits operation in a moderately dusty or abrasive atmosphere.

OPERATION

700 class pintle chains are adapted to loads ranging from normal to heavy and for speeds up to 300 FPM. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.





NCS

Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs. Duramal	Rated Working Load in Lbs.★ Duramal	Dimensions in Inches: Barrel Length X	Sidebar Width F	Max. Spkt. Width A	Pin Dia. D	Barrel Dia. H	℄ To Cotter End K	℄ To Head or Rivet End J	Attachment Numbers
720	6.000	20	4.2	27,500	3,860	1⅞	1½	1⅛	11⁄16	1⅜	1⅞	1 11⁄16	A42, F2, F2MSPC, F3
720S	6.000	20	5.2	40,000	4,245	1⅞	1 9⁄16	1⅛	¾	1 7⁄16	2⅛	1 13⁄16	A11, A12, A42, AD474, AM116, F2, F3, F22-6, F22-8, M1
720NCS★	6.000	20	5.4	37,500	4,245	1⅞	1 9⁄16	1⅛	¾	1 7⁄16	2⅛	1 13⁄16	F3, F22-6, F22-8, K2, M1
730★★	6.000	20	6.0	40,000	4,500	2	1¾	1⅛	¾	1½	2 1⁄16	1⅞	A42, AD474, F2, F3, K2, M1
730S★	6.000	20	6.0	40,000	4,500	2	1¾	1¼	¾	1½	2 1⁄16	1 13⁄16	A42, A111, A112
730NCS★★★	6.000	20	6.0	40,000	4,500	2	1¾	1 5⁄32	¾	1½	2 3⁄32	1 25⁄32	F3, F22-7, F22-8

NCS suffix denotes curved sidebars and pear-shaped barrels.

700 Class Pintle Chain Attachments

A11

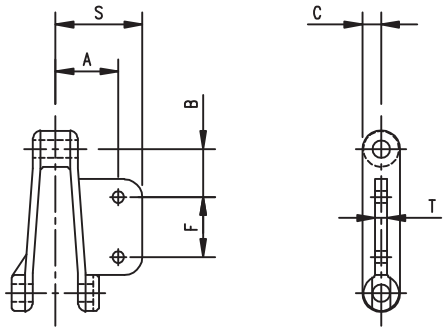
Chain No.	A	B	C	F	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720S	2⅝	2	25/32	2½	3⅝	½	8.5	½

A111↔

730S	2⅛	2⅜	⅞	2⅛	2⅞	⅝	7.5	⅝

A112↔

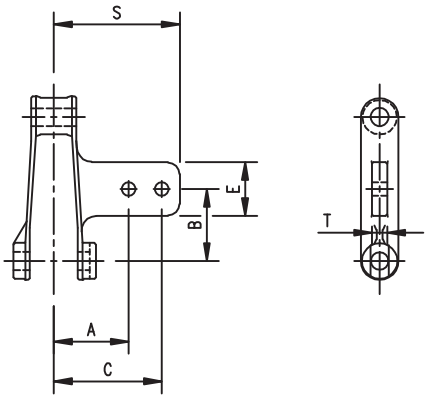
730S	2¾	2⅜	⅞	2⅛	3½	⅝	8.2	¾



A11, A111 and A112

A12

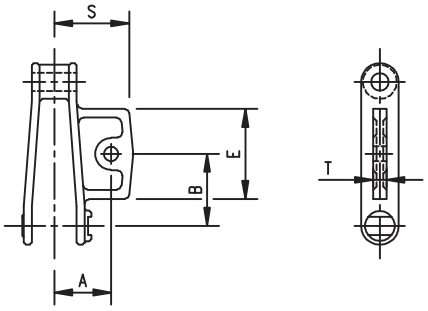
Chain No.	A	B	C	E	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720S	3⅛	3	4½	2¼	5¼	⅝	8.2	½



A12

A42

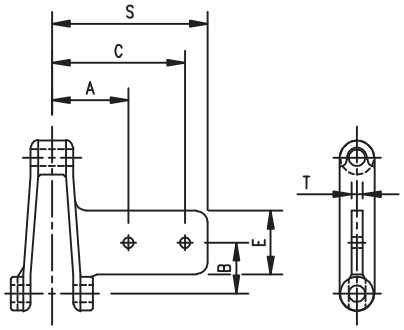
Chain No.	A	B	E	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720	2⅜	3	3¾	3⅛	9/16	5.5	⅝
720S	2⅜	3	3¾	3⅛	9/16	5.5	⅝
730	2 7/16	3	3⅞	3 3/16	⅝	7.3	⅝
730S↔	2 7/16	3	3⅞	3 3/16	⅝	7.3	⅝



A42

AD474

Chain No.	A	B	C	E	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720S	3⅜	2¼	5⅞	2 13/16	6⅞	½	8.7	½
730	3½	2¼	6	2 15/16	7	½	9.5	½



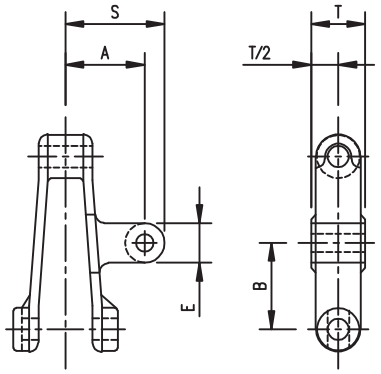
AD474

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

700 Class Pintle Chain Attachments

AM116

Chain No.	A	B	E	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720S	2¾	3	1⅜	3⅞16	1⅞	8.2	⅝



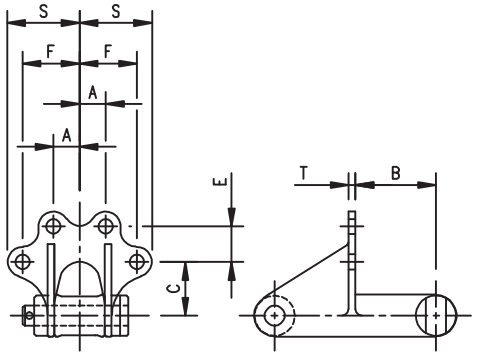
AM116

F2

Chain No.	A	B	C	E	F	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720	31/32	3	2	1⅝16	2⅞16	2⅛	¼	6.5	½
720S	31/32	3	2	1⅝16	2⅞16	2⅛	¼	6.9	⅜
730↔	31/32	3	2	1⅝16	2¾	2⅛	5/16	7.5	⅜

F2MSPC

720	1¾	2	2⅛	1⅝	2⅛	2⅛	⅜	6.5	⅜



F2 and F2MSPC

F3

Chain No.	A	B	C	E	H	S	T	Weight Per Foot-Lbs. Δ	Bolt Size
720	1⅞	2⅞	2⅞16	2½	5½	2⅝16	⅜	13.8	½
720S	1⅞	3	2⅜	2½	5½	2⅞16	⅜	13.4	½
720NCS	1⅞	3	2⅜	2½	6	2⅞16	¼	13.8	½
730	1⅞	3	2⅝	2½	6	2⅝16	9/32	14.0	½
730NCS	1⅞	3	2⅝	2½	6	2⅝16	9/32	14.0	½

F22-6

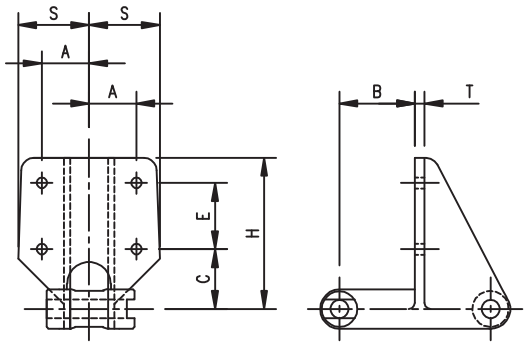
720S	1⅞	3	2⅜	2⅝	6	2⅞16	⅜	13.9	⅜
720NCS↔	1⅞	3	2⅜	2⅝	6	2⅞16	¼	13.8	⅜

F22-7

730NCS	1⅞	3	2⅝	3⅝	7⅞	2½	9/32	14.2	½

F22-8

720S	1⅞	3	2⅜	4½	8	2⅞16	5/16	13.9	⅜
720NCS↔	1⅞	3	2⅜	4½	8	2⅞16	5/16	13.8	⅜
730NCS	1⅞	3	2⅜	4½	8	2⅝16	5/16	15.2	⅜

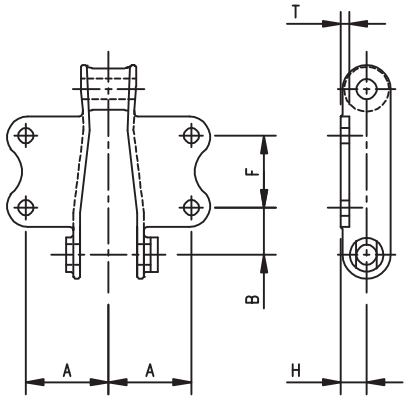


F3, F22-6, F22-7 and F22-8

700 Class Pintle Chain Attachments

K2

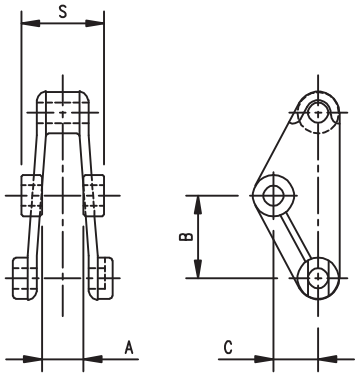
Chain No.	A	B	F	H	T	Weight Per Foot-Lbs. Δ	Bolt Size
720NCS	3	1 11/16	2 5/8	15/16	5/16	8.6	1/2
730	3	1 11/16	2 5/8	15/16	5/16	8.6	1/2



K2

M1

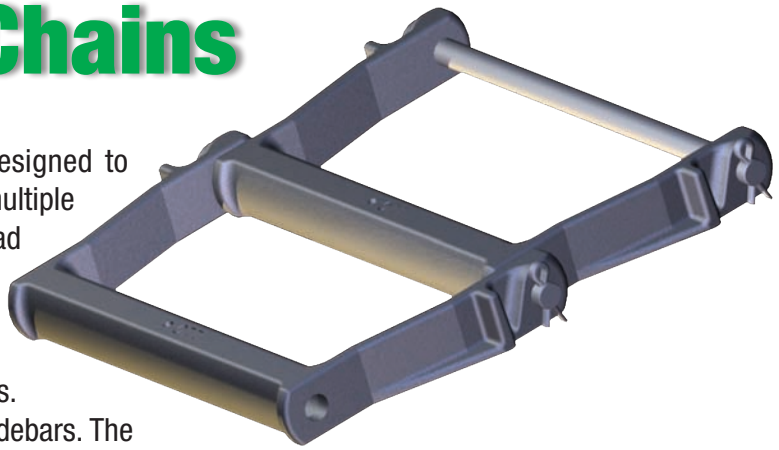
Chain No.	A	B	C	S	Weight Per Foot-Lbs. Δ	Bolt Size
720S	1 1/2	3	1 1/2	3	6.9	3/4
720NCS	1 1/2	3	1 1/2	3	6.9	3/4
730	1 1/2	3	1 5/8	3	7.9	3/4



M1

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

H Type Drag Chains



H type drag chains have links that are designed to operate in troughs or runways, in single or multiple strands. The underside of the links are broad to provide liberal wear surface. The riveted pins are made of medium carbon steel and have clipped heads, which are securely fitted between the lugs cast on the sidebars. This prevents the pins from turning in the sidebars. The pins articulate in the barrel which distributes the wear over the maximum area.

MATERIAL

Links are cast of high grade Duramal. Duramal is a heat treated copper bearing malleable iron having greater strength and superior resistance to wear and abrasion. Pins are heat treated.

ASSEMBLY

Riveted construction is furnished unless cottered construction is requested.

INTERCHANGEABILITY

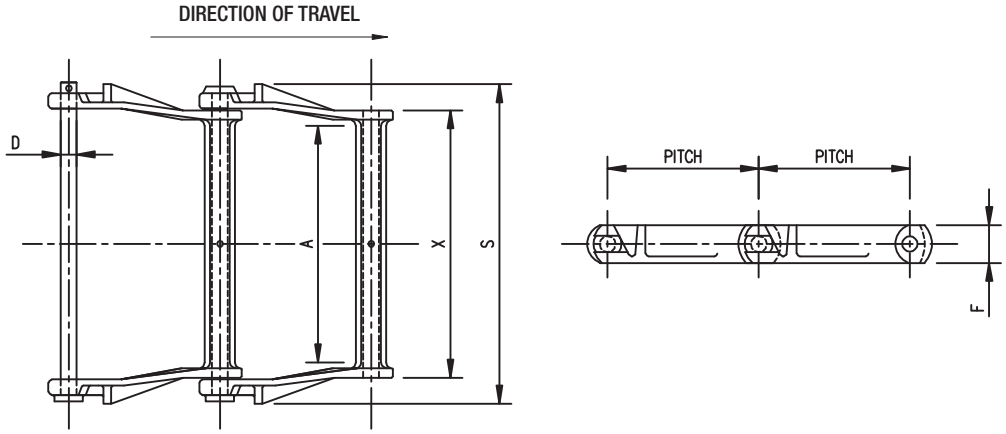
H type drag chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

H type drag chains are designed for heavy-duty operation imposed by drag conveyor service. It is usually dragged in troughs and used for moving sawdust, refuse, fine coal, ash and other materials in places where an economical installation is required. Multiple strands may be used to handle larger capacities.

OPERATION

The maximum speed recommended is 100 FPM. 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.★	Dimensions in Inches					Attachment Numbers
						Barrel Length	Sidebar Width	Max. Spkt. Width	Pin Dia.	Overall Width	
				Duramal	Duramal	X	F	A	D	S	
H102	5.000	24	10.7	35,000	5,830	7¾	1½	6⅜	⅝	9⅞	WING
H104P	6.000	20	8.0	35,000	5,830	5⁵⁄₁₆	1½	4⅛	⅝	7¹¹⁄₁₆	C4, WING
H104W	6.000	20	8.0	35,000	5,830	5⁵⁄₁₆	1½	4⅛	⅝	7⅜	
H110	6.000	20	13.3	35,000	5,830	10⅝	1½	9	⅝	12¹¹⁄₁₆	C1, C3, WING
H112	8.000	15	10.8	35,000	5,830	10⅝	1½	9	⅝	12¾	WING
H113	6.000	20	16.7	37,500	6,400	10⅝	1⁹⁄₁₆	9	¾	12¾	
H116	8.000	15	14.6	35,000	5,830	14⁷⁄₁₆	1⅝	12½	⅝	16¹¹⁄₁₆	
H120	6.000	20	18.5	47,500	7,920	10⅛	2	8¾	¾	12¾	
H480	8.000	15	18.1	50,000	8,330	12¹¹⁄₁₆	2	11⅛	¾	16	

H Type Drag Chain Attachments

C1

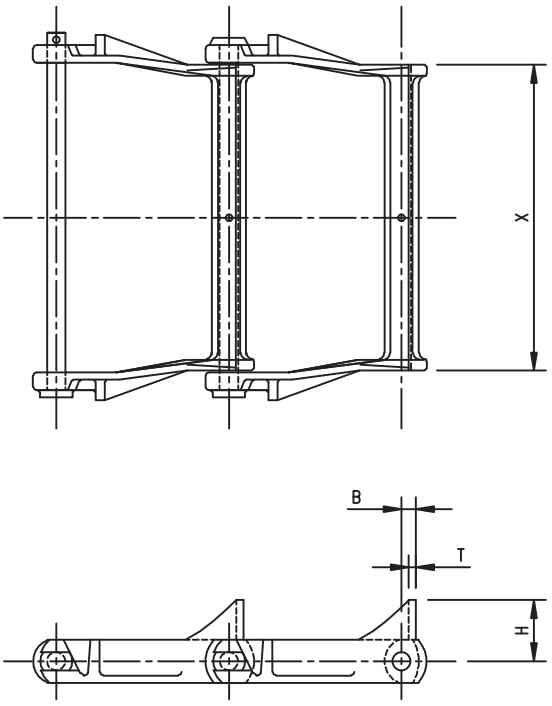
Chain No.	B	H	T	X	Weight Per Foot-Lbs. Δ
H110	½	2⅛	¼	10⅝	14.6

C3

H110	9/16	2⅛	1⅛	10⅝	15.8

C4

H104P	½	3¼	⅜	5⅝	9.9

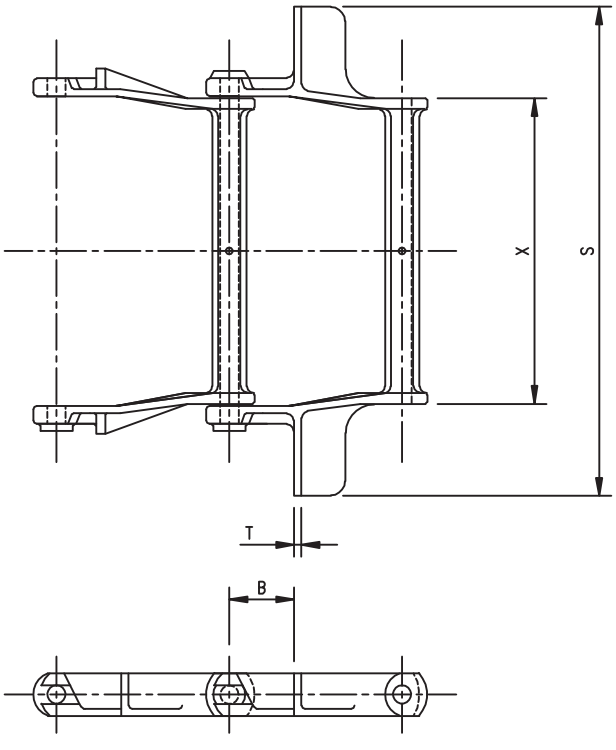


C1, C3 and C4

WING

Chain No.	B	S	T	X	Weight Per Foot-Lbs. Δ
H102	1¾	14¼	¼	7¾	12.9
H104P	2¼	11½	3/16	5⅝	9.6
H110	2¼	17	¼	10⅝	14.6
H112	5½	23¼	½	10⅝	22.5

H112 special extra wide attachment faces opposite direction shown.



WING

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Combination Type Drag Chains



Combination type drag chains are designed with sections heavier than comparable sizes of H type drag chain. The double offset wear shoes on the cast link provide wear surfaces for both carrying and return runs, thus increasing chain life.

Combination type drag chains have higher working load ratings and provide long, dependable service under severe operating conditions. Due to their rectangular design, the rugged center links provide maximum resistance to distortion from chain pulls encountered in drag conveyor service. The cast block links are copper bearing Duramal and the pins are heat treated.

ASSEMBLY

Riveted construction is furnished unless cottered construction is requested.

INTERCHANGEABILITY

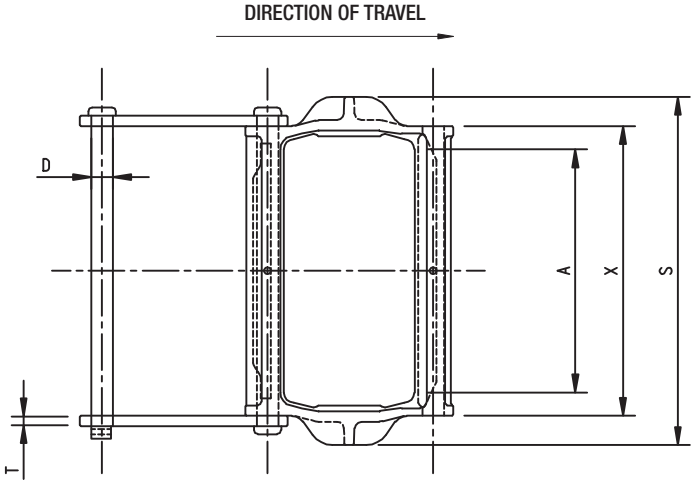
Combination type drag chains are interchangeable with other standard makes of corresponding sizes and numbers.

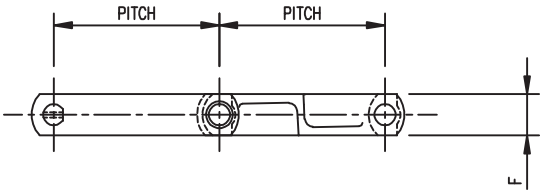
APPLICATION

Combination type drag chains operate in troughs and are primarily used to handle nonabrasive materials in the lumber, pulp and paper industries. If the service is intermittent it can be used for the conveying of ash and other small abrasive materials.

OPERATION

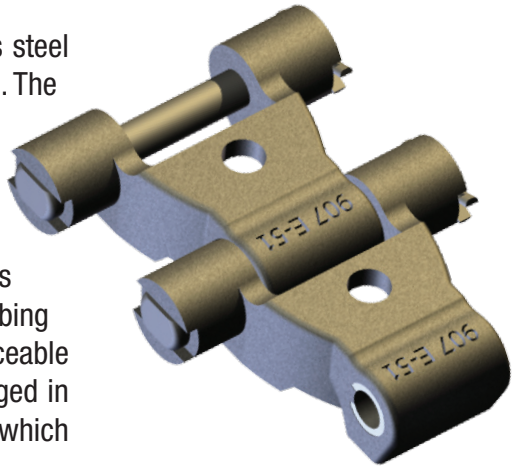
The construction of this chain permits it to travel in one direction only. A maximum speed of 100 FPM is recommended. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.





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.★	Dimensions in Inches					
						Barrel Length	Sidebar Width	Max. Spkt. Width	Pin Dia.	Overall Width	Sidebar Thk.
				Duramal	Duramal	X	F	A	D	S	T
6104	6.000	20	10.0	52,500	8,750	5½	1½	3 13/16	¾	7½	⅜
6110	6.000	20	13.5	52,500	8,750	10½	1½	9	¾	12¾	⅜
8116	8.000	15	14.0	52,500	8,750	14 5/16	1⅝	12⅜	¾	16½	⅜
8480	8.000	15	20.0	70,000	11,670	12¾	2	10½	⅞	15⅞	½

900 and 900R Class Intermediate Carrier Chains



900 class intermediate carrier chains have heat treated stainless steel bushings keyed in the barrel and medium carbon heat treated pins. The pins are securely locked in the Duramal links with lugs cast on to make a tight fit with the clipped head pins. The barrel of the link has a generous wear surface and the open end wear shoes prevent tilting to relieve part of the pin load. The chain can be furnished with stainless steel pins. 900R chain has outboard rollers to engage the double sprocket teeth, which eliminates the scrubbing action with the sprockets. It has heat treated stainless steel replaceable pins, bushings and rollers, so that all of these parts can be changed in the field easily. These links are made of copper bearing Duramal, which gives extended life.

ASSEMBLY

Cottered construction is furnished unless riveted construction is requested.

INTERCHANGEABILITY

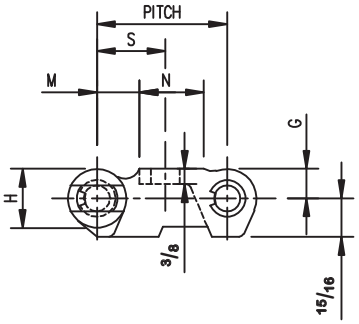
900 class intermediate carrier chains are interchangeable with other standard makes of corresponding sizes and numbers.

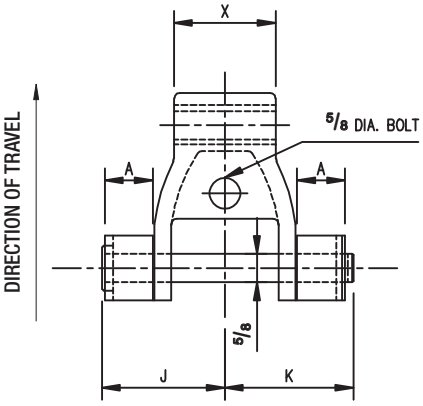
APPLICATION

900 class intermediate carrier chains were designed primarily for sugar mill service. Multiple strands may have overlapping, beaded slats mounted on them to form a continuous apron for an intermediate carrier conveyor.

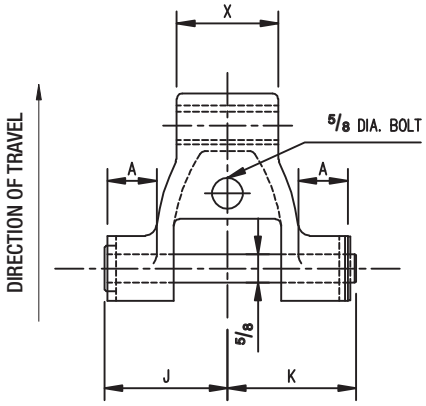
OPERATION ON DOUBLE SPROCKETS

Webster's one-piece double sprocket assures accurate alignment of the chain on the sprocket. They are available in cast iron chilled rim and in solid or split construction for ease of assembly. For longer chain and sprocket life it is recommended that no less than 12 tooth sprockets be used.





R51



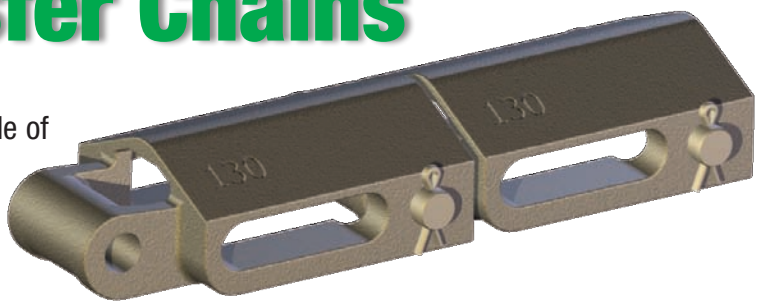
E51

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.★	Dimensions in Inches								
						Barrel Length	℄ To Top	Max. Spkt. Width	Barrel Dia.	℄ To Cotter End	℄ To Head or Rivet End	℄ Pin To Attachment Surface	Width of Surface	℄ Pin To ℄ Attachment Hole
				Duramal	Duramal	X	G	A	H	K	J	M	N	S
907-E51	3.170	38	11.6	31,250	4,920	2¼	23/32	1 3/32	1 7/16	2 27/32	2 23/32	1 3/64	1½	1 21/32
907-R51	3.170	38	14.2	31,250	4,920	2¼	23/32	1 1/16	1 13/32	3 1/16	2 15/16	1 3/64	1½	1 21/32

907-E51 chain with bushings in both the barrel and pin ends can be furnished.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Rooftop Transfer Chains



Rooftop transfer chains of this series are made of riveted construction. The clipped heads of the pins fit between two lugs cast on the sidebars of the chain links. This prevents the pins from turning in the sidebars, thus insuring minimum elongation of pitch and maximum durability.

MATERIAL

Links are cast of high grade malleable iron or Duramal. Duramal is a heat treated copper bearing malleable iron having greater strength and superior resistance to wear and abrasion. Duramal chains have heat treated pins.

INTERCHANGEABILITY

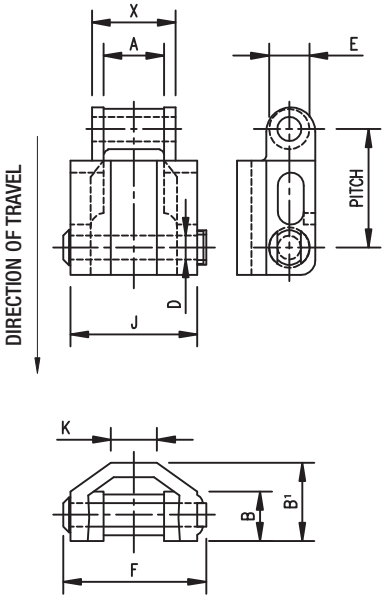
Rooftop transfer chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

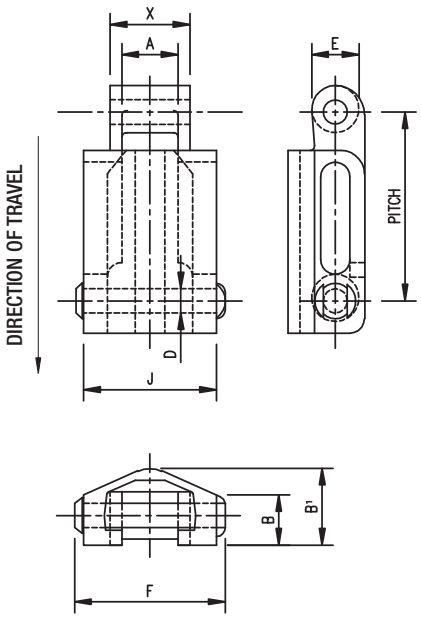
Rooftop transfer chain is used chiefly in two or more strands on transfer conveyors handling lumber, boxes, packages, barrels, bars, etc. Only the bevel tops of the links project above the guides, permitting loading and unloading to be done transversely.

OPERATION

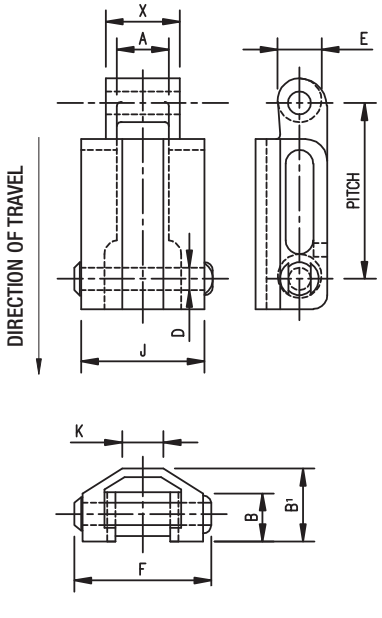
Rooftop transfer chains are made to operate in only one direction and therefore are not recommended for installations that require reverse operation. The load carried and frequency of operation determine the speeds, but generally the recommended speed is 100 FPM. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.



H78B



130

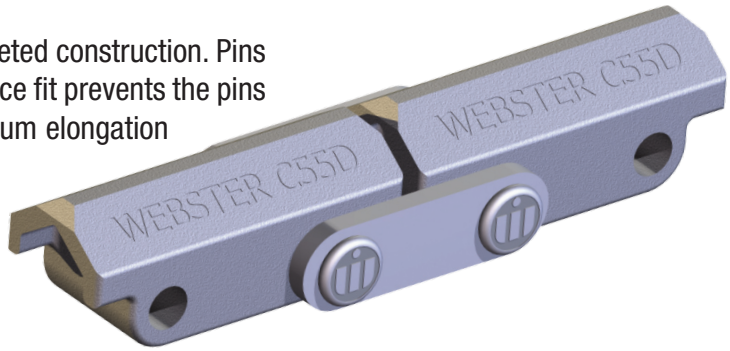


138

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.★	Dimensions in Inches								
						Barrel Length	Height at Side	Overall Height	Max. Spkt. Width	Pin Dia.	Barrel Dia.	Overall Width	Chain Width	Bevel Width
				Malleable	Malleable	X	B	B¹	A	D	E	F	J	K
H78B	2.609	46	6.1	16,000	2,350	1 13/16	1 1/16	1 11/16	1 1/8	1/2	7/8	3 3/16	2 13/16	1
130	4.000	30	5.2	15,000	2,110	1 11/16	1 1/16	1 5/8	1	1/2	1	3 3/8	2 13/16	—
138	4.000	30	5.8	15,000	2,110	1 5/8	1 3/32	1 21/32	1	1/2	15/16	3 3/8	2 3/4	15/16

Combination Rooftop Transfer Chain

Combination rooftop transfer chain is made of riveted construction. Pins are press fit into the steel sidebars. The interference fit prevents the pins from turning in the sidebars, thus insuring minimum elongation of pitch and maximum durability.



MATERIAL

Links are made of high grade malleable iron. Pins and sidebars are not heat treated.

INTERCHANGEABILITY

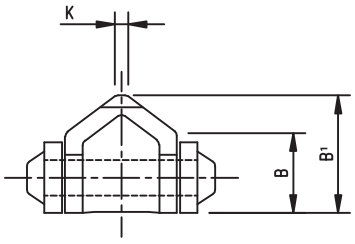
Combination rooftop transfer chain is interchangeable with other standard makes of corresponding sizes and numbers.

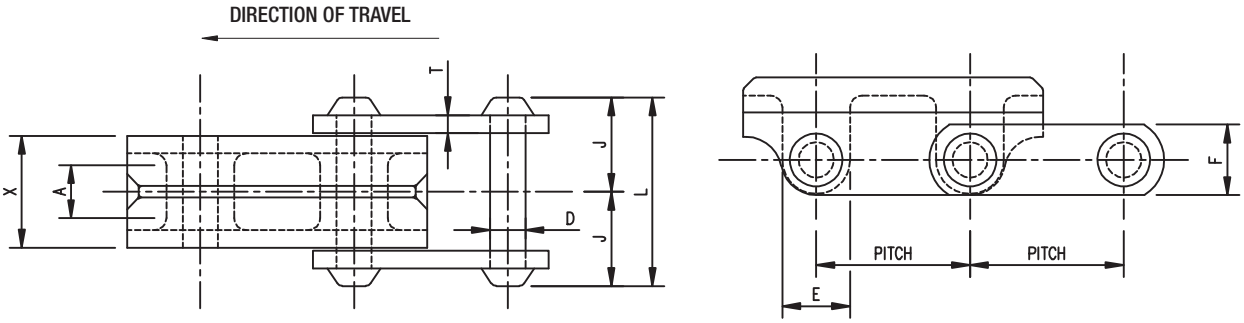
APPLICATION

Combination rooftop transfer chain is used chiefly in two or more strands on transfer conveyors handling lumber, boxes, packages, barrels, bars, etc. The bevel tops of the links project above the guides, permitting loading and unloading to be done transversely.

OPERATION

Combination rooftop transfer chain is made to run in either direction and therefore recommended for installations that require reverse operation. The load carried and frequency determines the proper speeds, but generally the recommended maximum speed is 100 FPM. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.



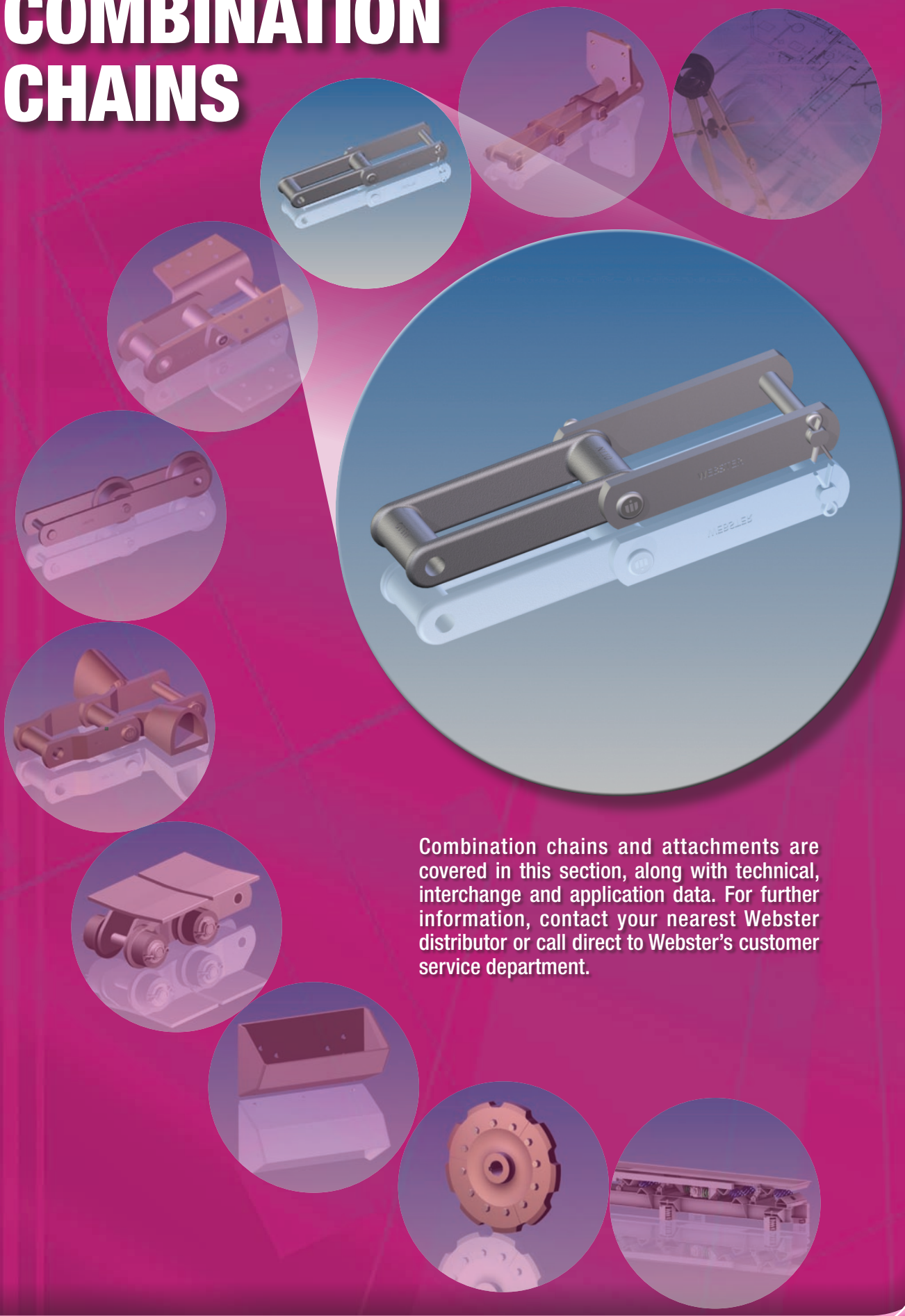


Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.★	Dimensions in Inches										
						Barrel Length	Height at Side	Overall Height	Max. Spkt. Width	Pin Dia.	Barrel Dia.	Overall Width	℄ To Head or Rivet End	Bevel Width	Sidebar Width	Sidebar Thk.
				Malleable	Malleable	X	B	B¹	A	D	E	L	J	K	F	T
C55D	1.631	74	3.2	9,000	1,140	1 3/16	7/8	1 1/4	11/16	3/8	23/32	2 1/8	1 1/16	1/8	3/4	3/16

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

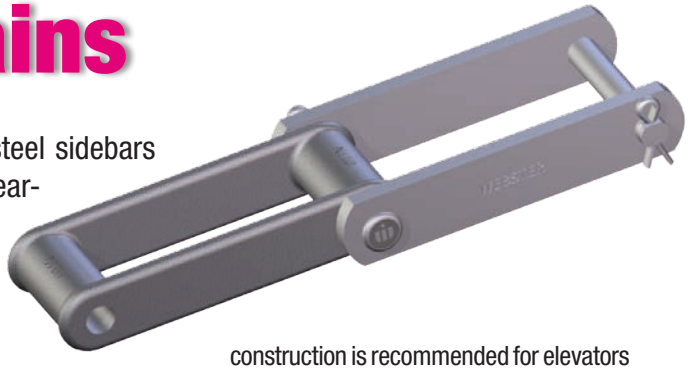
Notes

COMBINATION CHAINS



Combination chains and attachments are covered in this section, along with technical, interchange and application data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

Combination Chains



Combination chains are made of cast block links and steel sidebars alternately spaced. The N combination chains have pear-shaped barrels to provide additional metal where the chain engages the sprocket teeth to increase the service life of the chain. Combination chains are well suited for abrasive, gritty or corrosive materials and are a less expensive option to their all steel counterparts (HSB).

MATERIAL

The cast links are high grade copper bearing Duramal with holes smoothly cored for a close fit over the pins. Duramal chains have heat treated pins with Duramal block links. Super Duramal chains have heat treated pins and sidebars with Duramal block links. Chains are also available with block links of file hard Duramal.

ASSEMBLY

Riveted construction is recommended for wood yards and sawmills. Cottered construction is recommended for elevators and conveyors. Riveted or cottered construction must be specified. Chain pins will be alternating, except on C55, N77, N131 and C188 chains.

INTERCHANGEABILITY

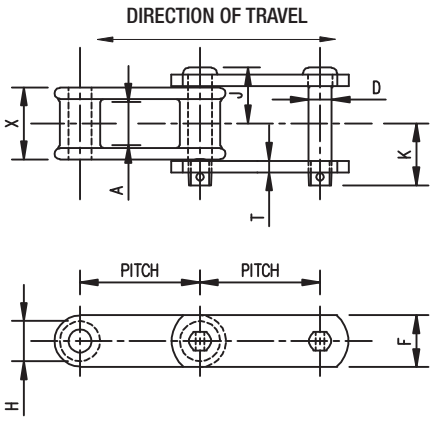
Combination chains are interchangeable with other standard makes of corresponding sizes and numbers.

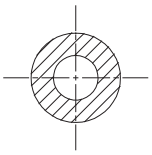
APPLICATION

Combination chain is well suited for the handling of stone, cement, gravel and other abrasive materials. It is used extensively in elevating and conveying service where a strong durable, yet inexpensive, chain is required.

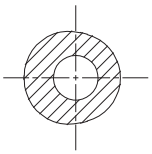
OPERATION

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





BARREL
CROSS SECTION



BARREL
CROSS SECTION
OF "N" CHAINS

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.★	Dimensions in Inches								Common Attachment Numbers	
						Barrel Length	Sidebar Width	Max. Spkt. Width	Pin Dia.	Nominal Barrel Dia.	℄ To Cotter End	℄ To Head or Rivet End	Sidebar Thk.		
				Duramal	Duramal	X	F	A	D	H	K	J	T	Block Link	Sidebar
C55	1.631	74	2.0	11,250	1,370	1 7/32	3/4	11/16	3/8	23/32	1 1/16	1	3/16		
N77	2.308	52	2.2	13,750	1,640	1 1/4	7/8	11/16	7/16	23/32	1 5/32	1	3/16	F2	K1
N102B	4.000	30	6.7	30,000	5,000	2 7/8	1 1/2	1 15/16	5/8	1	2 3/16	2 1/16	3/8	K2	K2, S1
N102½	4.040	30	9.4	45,000	6,600	2 15/16	1 3/4	2	3/4	1 3/8	2 3/8	2 1/8	3/8	A42, F2, G6, K2, K3, K22	A42, F2, K2, K3, K22, S1
N110	6.000	20	6.0	30,000	5,000	2 7/8	1 1/2	1 15/16	5/8	1 1/4	2 3/16	2 1/16	3/8	A53, F22-10, K2	A42, F1, F2, F4, F24, K2
N111#	4.760	25	9.7	45,000	7,500	3 3/8	1 3/4	2 3/8	3/4	1 7/16	2 19/32	2 11/32	3/8	F2, K2, K22	F2, K1, K2, K22, S1
N111SPC##	4.760 7.240	20	8.5	45,000	7,500	3 3/8	1 3/4	2 3/8	3/4	1 7/16	2 19/32	2 11/32	3/8	F2, K2	K2
N131	3.075	39	6.5	30,000	3,750	2	1 1/2	1 1/8	5/8	1 1/4	1 13/16	1 5/8	3/8	F2, G6, K1, K2	A42, G19, K1, K2, S1
N132#	6.050	20	14.4	62,500	10,400	4 3/8	2	3 1/8	1	1 3/4	3 7/32	3 1/32	1/2	K2, RF14	F2, K2, S1
C188	2.609	46	3.6	17,500	2,340	1 9/16	1 1/8	15/16	1/2	7/8	1 11/32	1 7/32	1/4	F2, G6, G19, G19SPC, K1, K2, K22	A22, A42, G27, K1, K2, K1/K2, K22, S1

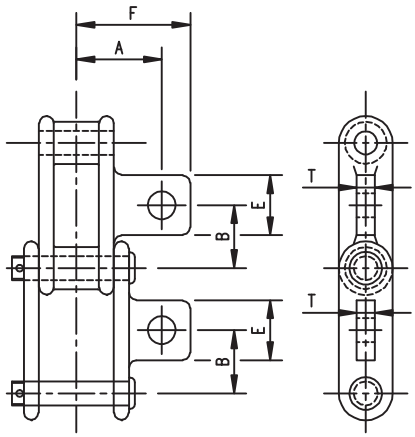
Common Combination Chain Attachments

A22 ↔

Chain No.	A	B	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
C188ΛΛ	1 7/16	1 5/16	1 1/4	2 1/16	3/8	—	3.8	3/8

A42 ↔

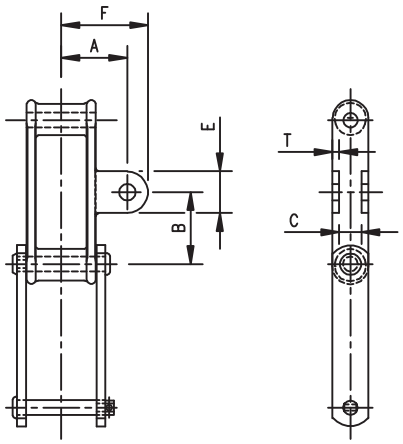
N102½Λ	2 9/16	2 1/64	1 3/4	3 7/16	1/2	10.2	10.3	5/8
N110ΛΛ	2 1/2	3	1 3/4	3 1/4	9/16	—	6.5	5/8
N131ΛΛ	2 1/2	1 17/32	1 1/2	3 1/8	3/8	—	7.2	1/2
C188ΛΛ	1 25/32	1 5/16	1 1/4	2 3/8	3/8	—	4.8	3/8



A22 and A42

A53 ↔

Chain No.	A	B	C	E	F	T	Weight Per Foot-Lbs. ▲	Bolt Size
N110	2 3/4	3	15/16	1 3/4	3 5/8	9/32	6.2	5/8



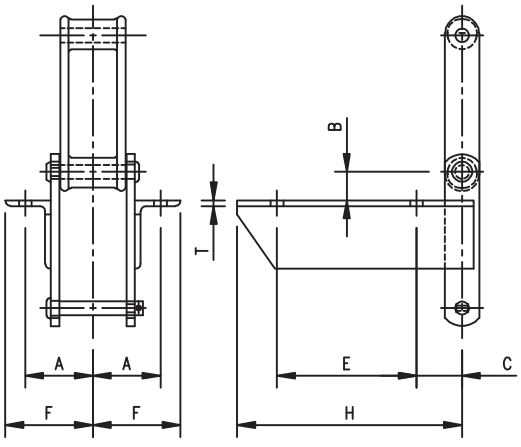
A53

F1

Chain No.	A	B	C	E	F	H	T	Weight Per Foot-Lbs. ▲▲	Bolt Size
N110	3	1 1/4	2	—	3 27/32	2 3/4	1/4	7.8	1/2

F24

N110	2 19/32	3	2	6 1/8	3 15/32	9 1/8	3/8	13.5	1/2



F1 and F24

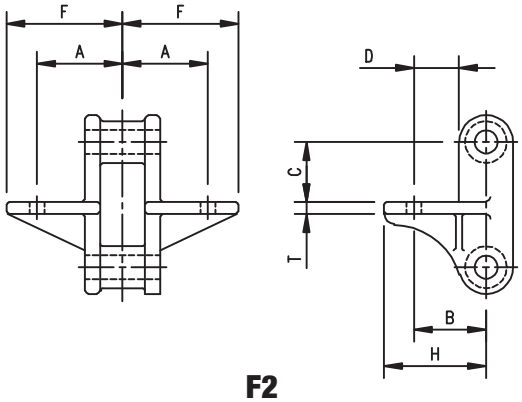
Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Combination Chain Attachments

F2

Chain No.	A	B	C	D	F	H	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
N77	7/8	1 3/8	1 1/4	15/16	1 5/16	1 15/16	1/4	2.9	—	5/16
N102½Λ	2 7/8	2	1 1/4	1 1/8	3 7/16	3 1/16	5/16	12.5	13.1	½
N110ΛΛ	2 11/16	1 3/4	3	1	3 5/8	2 3/4	1/4	—	6.5	½
N111Λ	3 3/16	2	1 3/4	1 1/8	3 7/8	3	3/8	11.0	13.5	3/8
N111SPCΛ	3 3/16	2	1 3/4	1 1/8	3 7/8	3	3/8	9.5	—	3/8
N131Λ	2 5/16	1 11/16	15/16	15/16	3 1/8	2 3/4	5/16	9.4	—	3/8
C188Λ	1	1 1/2	1 1/4	15/16	1 7/16	2 3/16	1/4	4.8	—	5/16
N132ΛΛ	4 3/16	2 3/16	3	13/16	5 7/32	3 3/16	1/4	—	15.0	½

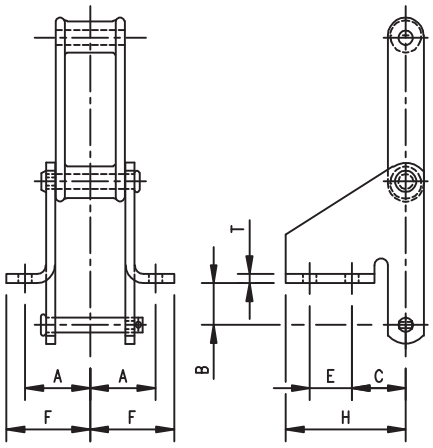
C188 extends across top of block link.



F2

F4

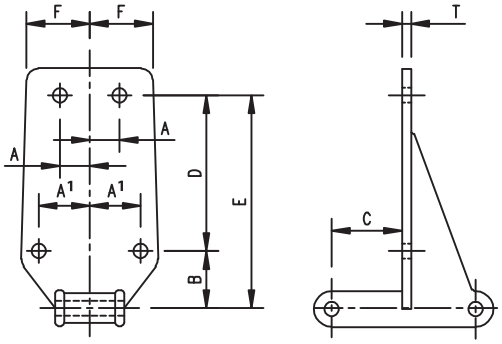
Chain No.	A	B	C	E	F	H	T	Weight Per Foot-Lbs. ▲▲	Bolt Size
N110	2 23/32	1 3/4	2 1/4	1 3/4	3 1/2	5 3/4	3/8	10.0	½



F4

F22-10

Chain No.	A	A¹	B	C	D	E	F	T	Weight Per Foot-Lbs. ▲	Bolt Size
N110Λ	1 1/4	2 1/8	2 3/8	2 15/16	6 1/2	10	2 5/8	3/8	14.6	½

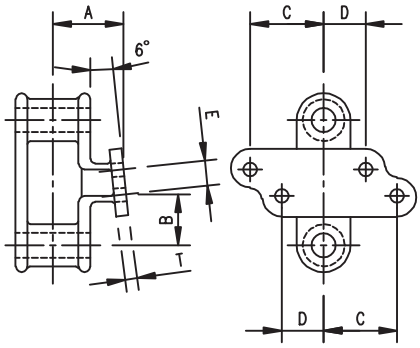


F22-10

Common Combination Chain Attachments

G6↔

Chain No.	A	B	C	D	E	T	Weight Per Foot-Lbs. ▲	Bolt Size
N102½Λ	2 11/16	1 9/16	1¾	1 1/16	⅞	5/16	11.1	⅜
N131Λ	2 1/16	1¼	1 17/32	⅞	9/16	9/32	8.0	⅜
C188Λ	1½	1 1/32	1 17/32	⅞	9/16	¼	4.8	¼



G6

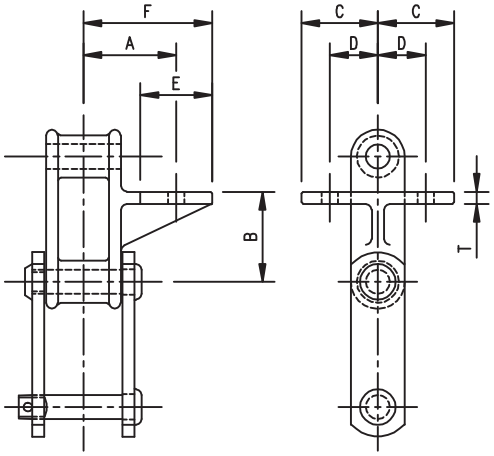
G19

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
N131ΛΛ	2⅜	2 3/16	2	1 7/16	—	2 29/32	¼	—	8.1	⅜
C188Λ	1 15/16	1⅞	1 19/32	1	1½	2 11/16	¼	4.6	—	5/16

G19SPC

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
C188	1 15/16	1⅞	1 19/32	¾	1½	2 11/16	¼	4.6	—	5/16

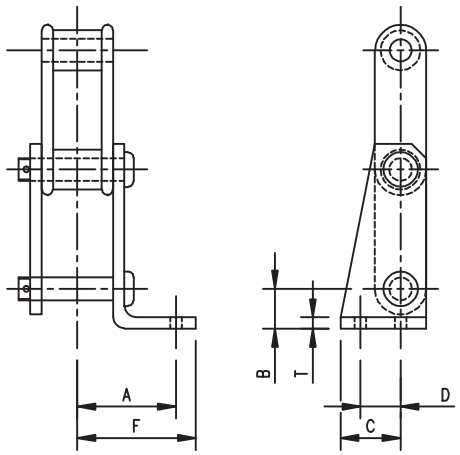
Meets ASME B29.400 dimensional standard.



G19 and G19SPC

G27↔

Chain No.	A	B	C	D	F	T	Weight Per Foot-Lbs. ▲▲	Bolt Size
C188ΛΛ	2 5/32	⅞	1 5/16	⅞	2 19/32	¼	4.4	5/16



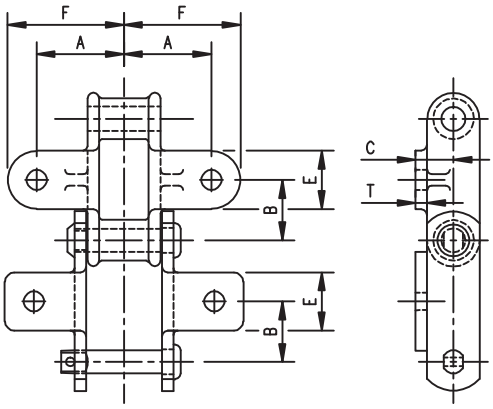
G27

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Combination Chain Attachments

K1

Chain No.	A	B	C	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
N77Λ	1½	1⁵⁄₃₂	²¹⁄₃₂	1⅛	2¹⁄₁₆	⁷⁄₃₂	—	2.2	⅜
N111ΛΛ	3⅛	2⅜	1⅛	2⅞	3²⁹⁄₃₂	⅜	—	10.5	⅜□
N131	2¹⁄₁₆	1¹⁷⁄₃₂	1¹⁄₁₆	1⅝	2¾	⁵⁄₁₆	8.0	7.2	⅜
C188Λ	1⅞	⁵⁄₁₆	¹³⁄₁₆	1¼	2½	¼	4.6	4.4	⅜



K1

K2

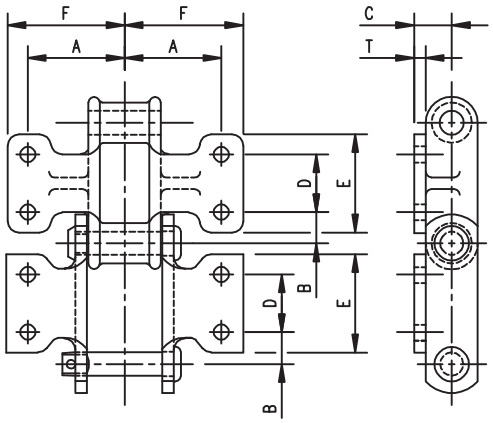
Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
N102BΛ	2²¹⁄₃₂	1⅛	1¹⁄₁₆	1¾	2¾	3⁵⁄₁₆	¼	7.8	7.2	⅜
N102½Λ	2²¹⁄₃₂	1⁹⁄₆₄	1¹⁄₁₆	1¾	2¾	3⁵⁄₁₆	⁵⁄₁₆	10.7	9.9	⅜
N110Λ	2²¹⁄₃₂	2⅛	1¹⁄₁₆	1¾	3	3¼	¼	7.2	7.3	⅜
N111Λ	3⅛	1⁷⁄₃₂	1⅛	2⁵⁄₁₆	3⅝	3¾	⁵⁄₁₆	10.5	10.7	½
N111SPCΛ	3⅛	1⁷⁄₃₂	1⅛	2⁵⁄₁₆	3⅝	3¾	⁵⁄₁₆	10.0	10.0	½
N131	2¹⁄₁₆	²⁵⁄₃₂	1¹⁄₁₆	1½	2⅝	2¾	⁵⁄₁₆	8.0	7.6	½
N132Λ	3¾	1²¹⁄₃₂	1¼	2¾	4⅛	4¹⁷⁄₃₂	⅜	14.9	15.2	½
C188Λ	2³⁄₃₂	¹¹⁄₁₆	¹³⁄₁₆	1¼	2⅛	2¹⁷⁄₃₂	¼	4.6	4.8	⁵⁄₁₆

K3

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
N102½Λ	2²¹⁄₃₂	1⁹⁄₆₄	1³⁄₁₆	1¾	2¾	3⁵⁄₁₆	⁷⁄₁₆	11.6	10.5	½

K22

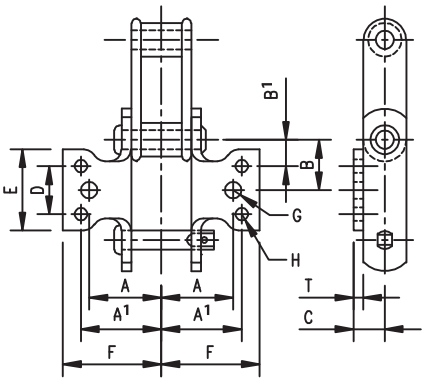
Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ▲	Weight Per Foot-Lbs. ▲▲	Bolt Size
N102½Λ	2²¹⁄₃₂	1⁹⁄₆₄	1¹⁄₁₆	1¾	2¾	3⁵⁄₁₆	⁵⁄₁₆	10.7	9.9	½
N111Λ	3⅛	1⁷⁄₃₂	1⅛	2⁵⁄₁₆	3⅝	3¾	⁵⁄₁₆	10.4	10.6	⅜□
C188Λ	2³⁄₃₂	¹¹⁄₁₆	¹³⁄₁₆	1¼	2⅛	2¹⁷⁄₃₂	¼	4.6	4.8	⅜



K2, K3 and K22

K1/K2

Chain No.	A	A¹	B	B¹	C	D	E	F	G	H	T	Weight Per Foot-Lbs. ▲▲	Bolt Size K1	Bolt Size K2
C188ΛΛ	1⅞	2³⁄₃₂	1⁵⁄₁₆	¹¹⁄₁₆	¹³⁄₁₆	1¼	2⅛	2⁹⁄₁₆	⁷⁄₁₆	¹¹⁄₃₂	¼	4.4	⅜	⁵⁄₁₆

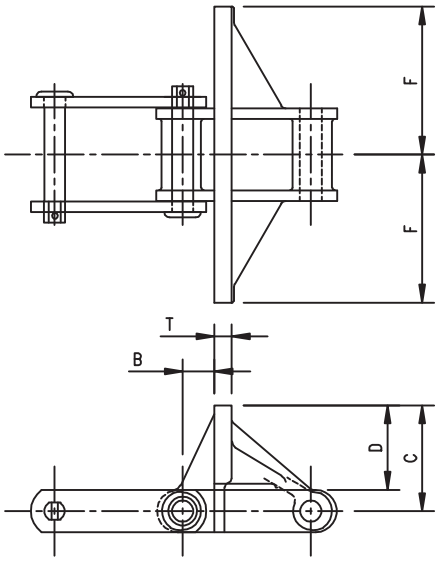


K1/K2

Common Combination Chain Attachments

RF14

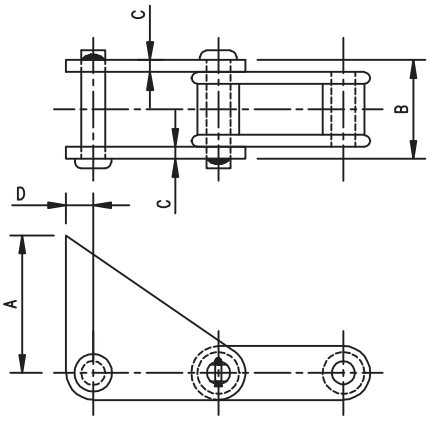
Chain No.	B	C	D	F	T	Weight Per Foot-Lbs. ▲
N132Λ	1½	5	4	7	13/16	32.3



RF14

S1 ↔

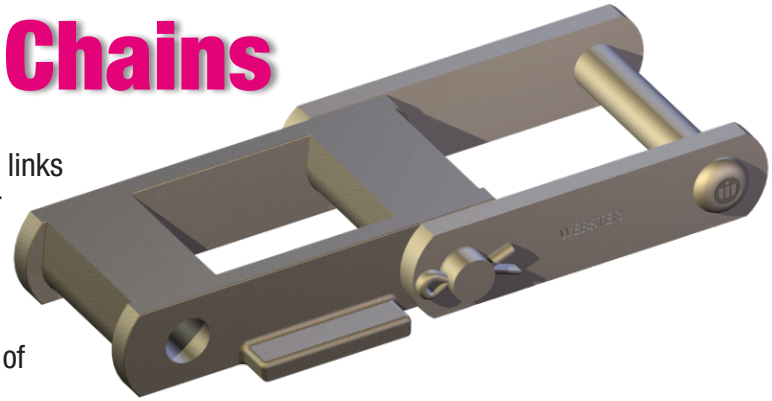
Chain No.	A	B	C	D	Weight Per Foot-Lbs. ▲▲
N102BΛΛ	3¾	3 11/16	⅜	13/16	9.4
N102½ΛΛ	3¾	3¾	⅜	⅞	12.0
N111ΛΛ	4⅜	4 3/16	⅜	⅞	10.5
N131ΛΛ	3¼	2 13/16	⅜	25/32	7.8
N132ΛΛ	5	5 7/16	½	1⅛	15.9
C188ΛΛ	2 11/16	2⅛	¼	⅝	4.4



S1

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

WS and DW Combination Chains



WS and DW combination chains have block links that are designed to provide extra wear surfaces for sliding on both the carrying and return runs of wood yard conveyors. This makes it possible to eliminate the return idler sprockets which cause internal wear of the chain parts.

MATERIAL

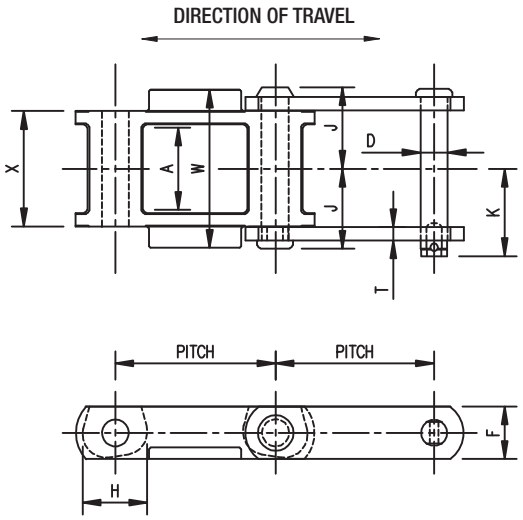
The cast links are high grade Duramal. Sidebars are medium carbon steel. Pins are heat treated medium carbon alloy steel. Electroplated chain pins are recommended to retard corrosion and are available on request.

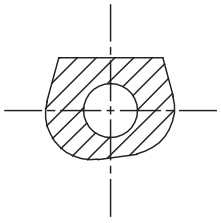
ASSEMBLY

Riveted construction is furnished unless cottered construction is requested. Many standard combination chain attachments, without wear shoes, are available.

OPERATION

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



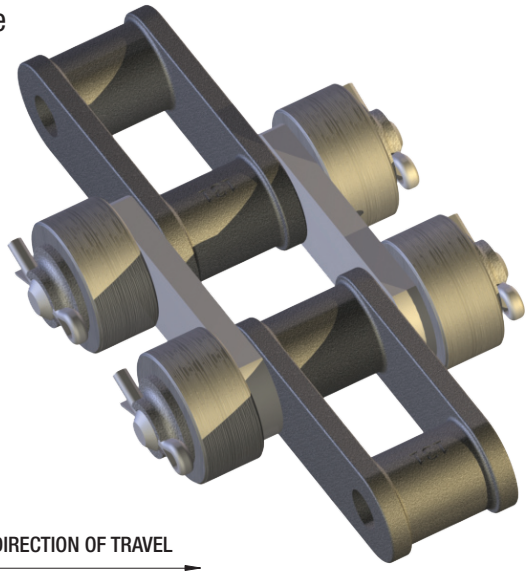


BARREL
CROSS SECTION
OF "DW" CHAINS

Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs. Duramal	Rated Working Load in Lbs.★ Duramal	Dimensions in Inches: Barrel Length X	Sidebar Width F	Max. Spkt. Width A	Pin Dia. D	Nominal Barrel Dia. H	℄ To Cotter End K	℄ To Head or Rivet End J	Overall Width of Wear Shoes W	Sidebar Thk. T
DW111	4.760	25	10.6	45,000	7,500	3⅜	1¾	2⅜	¾	1 7/16	2 19/32	2 11/32	4¾	⅜
N131WS	3.075	39	7.2	30,000	3,750	2	1½	1⅛	⅝	1¼	1 13/16	1⅝	3	⅜
DW132	6.050	20	16.7	62,500	10,400	4⅜	2	3⅛	1	1¾	3 7/32	3 1/32	6	½
N132WS	6.050	20	14.8	62,500	10,400	4⅜	2	3⅛	1	1¾	3 7/32	3 1/32	6	½
C188WS	2.609	46	4.0	17,500	2,340	1 9/16	1⅛	15/16	½	⅞	1 11/32	1 7/32	2½	¼

Outboard Roller Combination Chains

Outboard roller combination chains are an adaptation of the standard combination chain. The pins are extended to receive steel rollers. This eliminates sliding friction and helps reduce chain pull. Some standard combination chain attachments can be included in this chain.



MATERIAL

The cast links are high grade copper bearing Duramal. Sidebars are medium carbon steel. Pins are heat treated medium carbon alloy steel. Electroplated chain pins are recommended to retard corrosion and will be furnished on request.

ASSEMBLY

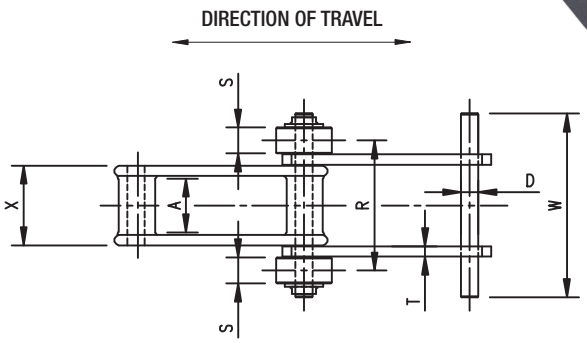
Cottered construction is furnished unless riveted construction is requested.

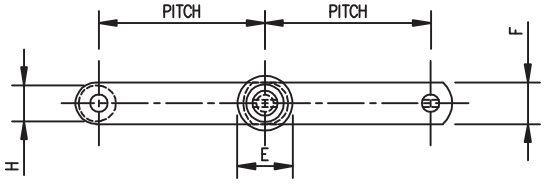
APPLICATION

Outboard roller combination chains are used for light single strand car hauls, truck pushers and assembly line conveyors in the automotive industry.

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 Ultimate Strength in Lbs.	Rated Working Load in Lbs.★	Dimensions in Inches									
					Barrel Length	Sidebar Width	Max. Spkt. Width	Pin Dia.	Nominal Barrel Dia.	Roller Dia.	Overall Cotter Width	℄ To Rollers	Roller Face Width	Sidebar Thk.
			Duramal	Duramal	X	F	A	D	H	E	W	R	S	T
CRN110	6.000	20	30,000	4,800	2⅞	1½	1 15⁄16	⅝	1¼	2	6⅝	4 11⁄16	⅞	⅜
CRN111	4.760	25	45,000	7,500	3⅜	1¾	2⅜	¾	1 7⁄16	2¼	7⅜	5¼	15⁄16	⅜
CRN131	3.075	39	30,000	3,750	2	1½	1⅛	⅝	1¼	2	5¾	3 13⁄16	⅞	⅜
CRN132	6.050	20	62,500	10,400	4⅜	2	3⅛	1	1¾	3	9	6⅝	1⅛	½
CR188	2.609	46	17,500	2,340	1 9⁄16	1⅛	15⁄16	½	⅞	1½	4⅜	2 13⁄16	⅝	¼

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Notes

HARDENED STEEL BUSHED (HSB) CHAINS



Hardened steel bushed (HSB) chains and attachments are covered in this section, along with technical, interchange and application data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.





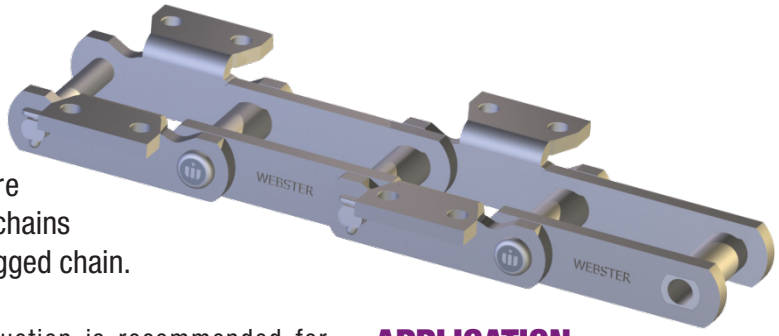








HSB Chains



Hardened steel bushed (HSB) chains are designed as a substitute for combination chains where conditions require a heavier, more rugged chain.

MATERIAL

Sidebars are medium carbon heat treated steel. Pins are alloy heat treated steel. Pins of ¾" diameter and larger are also induction hardened. Bushings are furnished in case hardened steel to provide maximum wear resistance and chain life.

ASSEMBLY

Riveted construction is recommended for wood yards and sawmills. Cottered construction is recommended for elevators and conveyors. Chain pins will be alternating, except on HSB131 and HSB188.

INTERCHANGEABILITY

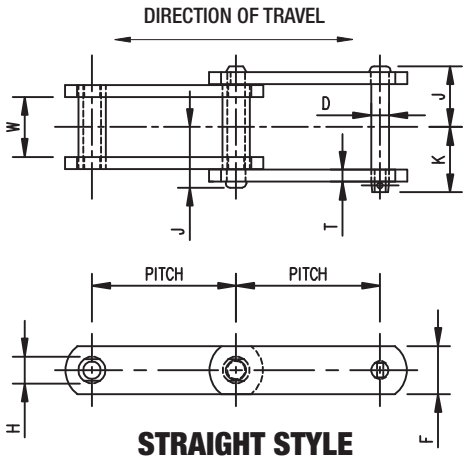
HSB chains are interchangeable with other standard makes of corresponding sizes and numbers. They are also a direct upgrade to combination chains of the same number.

APPLICATION

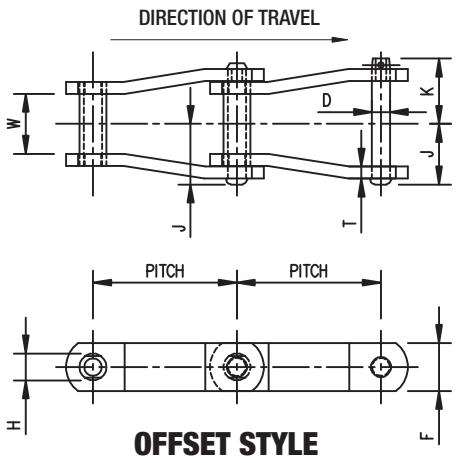
HSB chains are used for bucket elevators, wood yard conveyors and other types of conveyors and elevators operating under gritty and abrasive conditions. These chains have proven themselves in operation for long life and low maintenance.

OPERATION

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



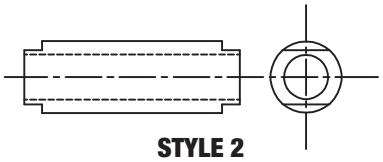
STRAIGHT STYLE



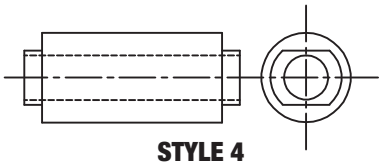
OFFSET STYLE

Chain No.	Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	Sidebars			Inside Sidebars
							Thk.	Height		
							T	F	Material	W
HSB188	S	2.609	46	3.8	25,000	2,730	¼	1⅛	M.C.H.T.	1 1/16
HSB1663	S	2.609	46	7.4	38,000	3,200	⅜	1½	M.C.H.T.	1 1/16
HSB131	S	3.075	39	7.4	40,000	4,380	⅜	1½	M.C.H.T.	1¼
HSB102B	S	4.000	30	6.9	40,000	6,290	⅜	1½	M.C.H.T.	2⅛
HSB825	O	4.000	30	8.7	60,000	5,900	⅜	2	M.C.H.T.	1½
HSB102½	S	4.040	30	9.4	50,000	7,700	⅜	1¾	M.C.H.T.	2 3/16
HSB6472	S	4.040	30	9.8	72,000	6,125	⅜	2	M.C.H.T.	1¼
HSB4933	S	4.040	30	11.0	72,000	9,200	⅜	2	M.C.H.T.	2¼
HSB111	S	4.760	25	10.2	50,000	8,850	⅜	2	M.C.H.T.	2⅝
HSB111SPC###	S	4.760 7.240	20	8.8	50,000	8,850	⅜	2	M.C.H.T.	2⅝
HSB5131	S	5.000	24	6.2	40,000	4,380	⅜	1½	M.C.H.T.	1¼

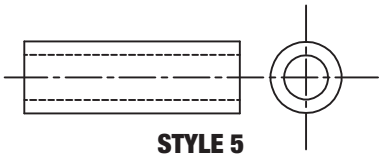
BUSHINGS



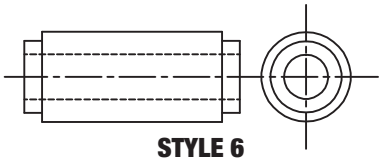
STYLE 2



STYLE 4

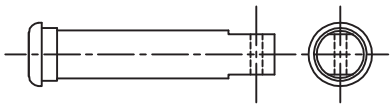


STYLE 5

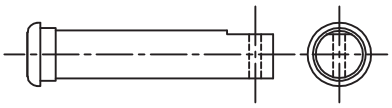


STYLE 6

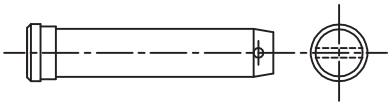
PINS



STYLE A



STYLE B



STYLE F

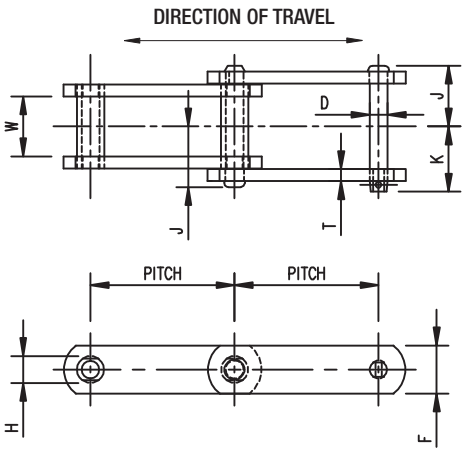
Abbreviations of Material and Treatment

M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H.. . . . . Low Carbon, Case Hardened
ALY.C.H.. . . . . Alloy Steel, Case Hardened

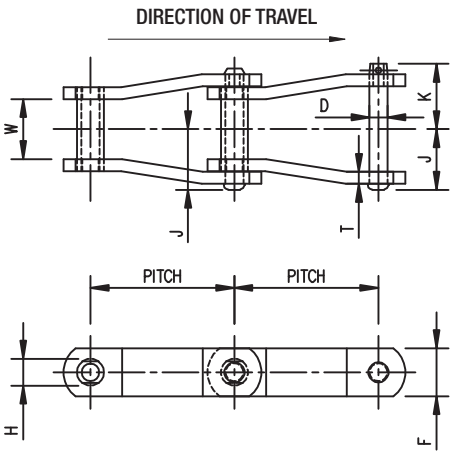
Chain No.	Overall Width		Pins			Bushings			Common Attachment Numbers
	℄ To Cotter End	℄ To Head or Rivet End	Dia.			Outside Dia.			
	K	J	D	Style	Material	H	Style	Material	
HSB188	1 11/32	1 7/32	1/2	A	ALY.H.T.	7/8	2	L.C.C.H.	A1, A2, A22, K1, K2
HSB1663	1 19/32	1 15/32	1/2	F	ALY.H.T.	7/8	5	L.C.C.H.	
HSB131	1 13/16	1 5/8	5/8	A	ALY.H.T.	1 1/4	4	L.C.C.H.	A1, A2, A42, K1, K2
HSB102B	2 3/16	2 1/16	5/8	A	ALY.H.T.	1	2	L.C.C.H.	A1, A2, A2M, A22, K1, K2, K2M
HSB825	2 1/32	1 25/32	3/4	A	ALY.I.H.	1 1/8	2	ALY.C.H.	A2, A42, K2
HSB102½	2 3/8	2 1/8	3/4	A	ALY.I.H.	1 3/8	2	ALY.C.H.	A2, A2M, K2, K2M
HSB6472	1 25/32	1 21/32	7/8	A	ALY.I.H.	1 3/8	2	ALY.C.H.	
HSB4933	2 15/32	2 5/32	7/8	A	ALY.I.H.	1 3/8	2	ALY.C.H.	
HSB111	2 19/32	2 11/32	3/4	A	ALY.I.H.	1 7/16	6	L.C.C.H.	A1, A2M, K1, K2M
HSB111SPC###	2 19/32	2 11/32	3/4	A	ALY.I.H.	1 7/16	6	L.C.C.H.	K2
HSB5131	1 13/16	1 5/8	5/8	A	ALY.H.T	1 1/4	4	L.C.C.H.	

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

HSB Chains



STRAIGHT STYLE

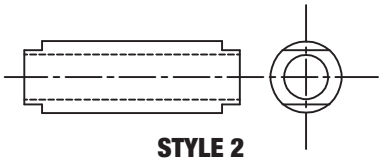


OFFSET STYLE

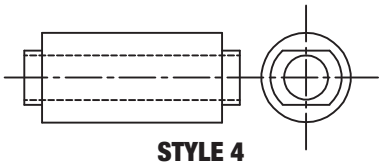
Chain No.	Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	Sidebars			Inside Sidebars
							Thk.	Height		
							T	F	Material	W
HSB1316	S	6.000	20	5.9	40,000	4,650	⅜	1½	M.C.H.T.	1⅜
HSB2730	S	6.000	20	7.7	50,000	5,575	⅜	1¾	M.C.H.T.	1⅜
HSB835	S	6.000	20	8.1	60,000	5,900	⅜	2	M.C.H.T.	1½
HSB110	S	6.000	20	6.3	40,000	6,290	⅜	1½	M.C.H.T.	2⅛
HSB830	O	6.000	20	7.5	60,000	5,900	⅜	2	M.C.H.T.	1½
HSB833	S	6.000	20	9.0	50,000	8,850	⅜	2	M.C.H.T.	2⅝
HSB844	S or O	6.000	20	10.4	65,000	9,200	½	2	M.C.H.T.	2½
HSB826	O	6.000	20	14.0	95,000	9,570	⅜	2½	M.C.H.T.	2⅜
HSB860B	S	6.000	20	15.0	100,000	10,500	½	2½	M.C.H.T.	2
HSB856B	S	6.000	20	16.2	100,000	14,000	½	2½	M.C.H.T.	3
HSB956	S	6.000	20	17.3	100,000	14,000	½	3▼▼▼	M.C.H.T.	3
HSB857A	S	6.000	20	21.0	130,000	14,000	½	3¼▼▼	M.C.H.T.	3
HSB2858A	S	6.000	20	24.1	150,000	15,300	½	3½▽▽	M.C.H.T.	2½
HSB850	S or O	6.000	20	23.5	200,000	16,000	⅝	3	M.C.H.T.	2¼
HSB859B	S	6.000	20	34.0	200,000	21,875	⅝	4▽▽▽	M.C.H.T.	3¾
HSB1654	O	6.000	20	32.0	230,000	18,375	⅝	4	M.C.H.T.	2¼
HSB851	S or O	6.000	20	30.0	200,000	24,500	⅝	3½	M.C.H.T.	2¾
HSB150+	S	6.050	20	16.6	100,000	15,100	½	2½	M.C.H.T.	3⅜

HSB Chains

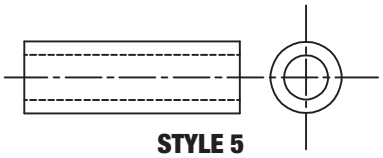
BUSHINGS



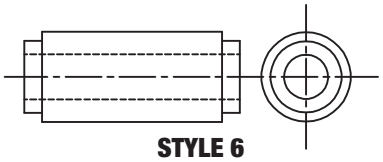
STYLE 2



STYLE 4

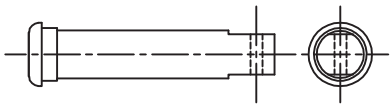


STYLE 5

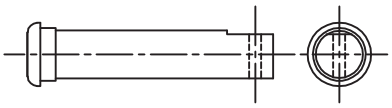


STYLE 6

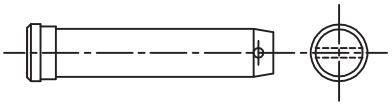
PINS



STYLE A



STYLE B



STYLE F

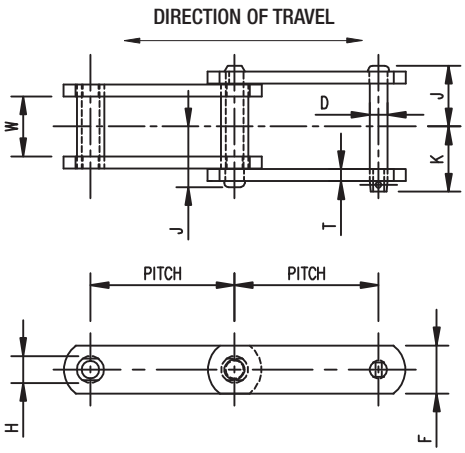
Abbreviations of Material and Treatment

M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H.. . . . . Low Carbon, Case Hardened
ALY.C.H.. . . . . Alloy Steel, Case Hardened

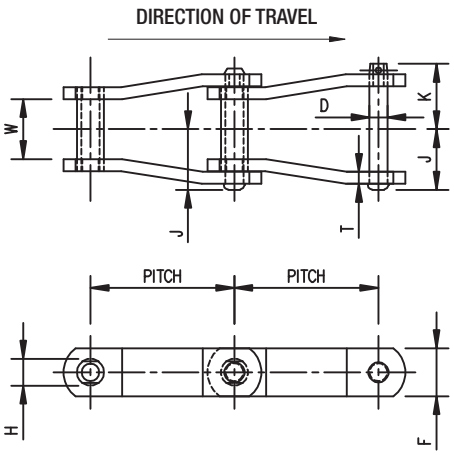
Chain No.	Overall Width		Pins			Bushings			Common Attachment Numbers
	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material	Outside Dia.	Style	Material	
	K	J	D			H			
HSB1316	1 25/32	1 19/32	5/8	A	ALY.H.T.	1 1/4	4	L.C.C.H.	A53
HSB2730	1 31/32	1 23/32	3/4	A	ALY.H.T.	1 3/8	4	L.C.C.H.	
HSB835	2 1/32	1 25/32	3/4	A	ALY.I.H.	1 1/8	2	L.C.C.H.	
HSB110	2 3/16	2 1/16	5/8	A	ALY.H.T.	1 1/4	4	L.C.C.H.	A2, A2M, A22, A42, K2, K2M, K22
HSB830	2 1/32	1 25/32	3/4	A	ALY.I.H.	1 1/8	2	L.C.C.H.	A2, A42, K2
HSB833	2 19/32	2 11/32	3/4	A	ALY.I.H.	1 7/16	6	L.C.C.H.	K2M
HSB844	2 23/32	2 17/32	3/4	A	ALY.I.H.	1 1/8	2	L.C.C.H.	A2, K2
HSB826	2 19/32	2 7/32	7/8	B	ALY.I.H.	1 1/2	2	L.C.C.H.	K2/K3
HSB860B	2 17/32	2 11/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	
HSB856B	3	2 27/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H	A2M, K2M, K3M, K24M, K35M
HSB956	3	2 27/32	1	F	ALY.I.H.	1 3/4	5	ALY.C.H.	A2M, K2M, K3M, K24M, K35M
HSB857A	3 5/32	2 27/32	1	F	ALY.I.H.	1 3/4	5	ALY.C.H.	K2M, K44
HSB2858A	2 29/32	2 19/32	1 1/4	F	ALY.I.H.	2 3/8	6	ALY.C.H.	K4M
HSB850	3	2 23/32	1 5/16	A	ALY.I.H.	2	6	ALY.C.H.	
HSB859B	3 25/32	3 15/32	1 1/4	F	ALY.I.H.	2 3/8	6	ALY.C.H.	K44
HSB1654	3 1/32	2 25/32	1 1/2	B	ALY.I.H.	2 1/2	6	ALY.C.H.	
HSB851	3 11/32	2 31/32	1 3/4	B	ALY.I.H.	2 3/8	6	ALY.C.H.	
HSB150+	3 7/32	3 1/32	1	A	ALY.I.H.	1 3/4	6	ALY.C.H.	A2M, K2M, K3M

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

HSB Chains



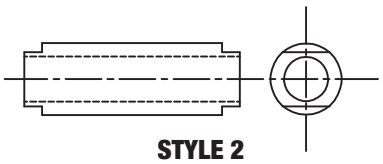
STRAIGHT STYLE



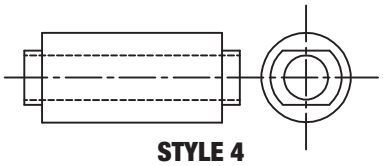
OFFSET STYLE

Chain No.	Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	Sidebars			Inside Sidebars
							Thk.	Height		
							T	F	Material	W
HSB864B	S	7.000	17	32.0	200,000	21,875	⅝	4▽▽▽	M.C.H.T.	3¾
HSB984	S	7.000	17	31.0	200,000	24,000	⅝	4▽	M.C.H.T.	3¾
HSB2866	S	7.000	17	35.4	200,000	27,370	⅝	4▽▽▽	M.C.H.T.	4½
HSB886	O	7.000	17	42.0	350,000	24,200	¾	4	M.C.H.T.	2¾
HSB187	S	8.000	15	2.5	25,000	2,730	¼	1⅛	M.C.H.T.	1 1/16
HSB1856	S	8.000	15	13.9	100,000	14,000	½	2½	M.C.H.T.	3
HSB1219	S	9.000	13⅓	8.0	50,000	8,850	⅜	2	M.C.H.T.	2⅝
HSB9124	S	9.000	13⅓	12.8	100,000	10,500	½	2½	M.C.H.T.	2
HSB1956	S	9.000	13⅓	13.1	100,000	14,000	½	2½	M.C.H.T.	3
HSB9150	S	9.000	13⅓	14.1	100,000	15,100	½	2½	M.C.H.T.	3⅜
HSB1903	S	9.000	13⅓	16.7	110,000	15,100	½	3	M.C.H.T.	3⅜
HSB959	S	9.000	13⅓	28.2	200,000	21,875	⅝	3½	M.C.H.T.	3¾
HSB964	S	9.000	13⅓	26.9	200,000	21,875	⅝	4▽	M.C.H.T.	3¾
HSB6322	O	12.000	10	7.1	50,000	7,200	⅜	2	M.C.H.T.	2
HSB6102½	O	12.000	10	7.0	50,000	7,700	⅜	2	M.C.H.T.	2 3/16
HSB6124	O	12.000	10	11.7	100,000	10,500	½	2½	M.C.H.T.	2½
HSB852	O	12.000	10	12.6	100,000	15,100	½	2	M.C.H.T.	3⅜
HSB1259	O	12.000	10	25.2	200,000	21,875	⅝	3½	M.C.H.T.	3¾

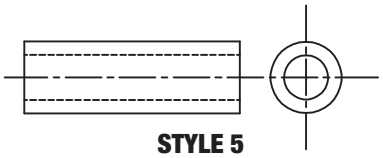
BUSHINGS



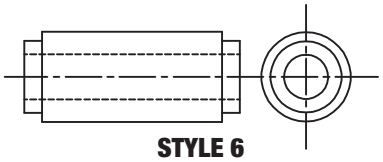
STYLE 2



STYLE 4

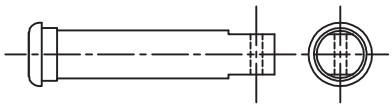


STYLE 5

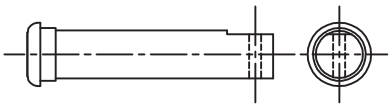


STYLE 6

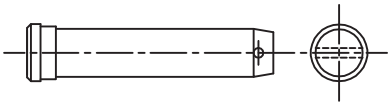
PINS



STYLE A



STYLE B



STYLE F

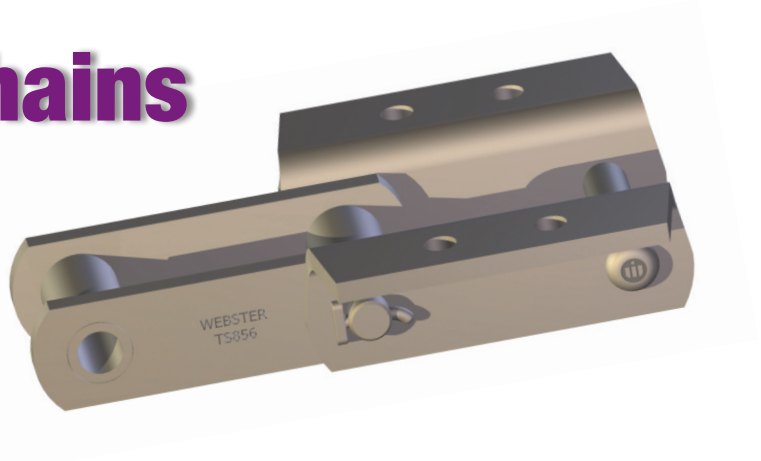
Abbreviations of Material and Treatment

M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H.. . . . . Low Carbon, Case Hardened
ALY.C.H.. . . . . Alloy Steel, Case Hardened

Chain No.	Overall Width		Pins			Bushings			Common Attachment Numbers
	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material	Outside Dia.	Style	Material	
	K	J	D			H			
HSB864B	3 25/32	3 15/32	1 1/4	F	ALY.I.H.	2 3/8	6	ALY.C.H.	K443
HSB984	3 25/32	3 15/32	1 3/8	F	ALY.I.H.	2 1/2	6	ALY.C.H.	K443
HSB2866	4 5/32	3 17/32	1.36	F	ALY.I.H.	2 3/8	6	ALY.C.H.	K3
HSB886	3 23/32	3 7/32	1 5/8	F	ALY.I.H.	2 5/8	6	ALY.C.H.	
HSB187	1 11/32	1 7/32	1/2	A	ALY.H.T.	7/8	2	L.C.C.H.	
HSB1856	3	2 27/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	
HSB1219	2 19/32	2 11/32	3/4	A	ALY.I.H.	1 7/16	6	L.C.C.H.	K21
HSB9124	2 19/32	2 11/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	G6
HSB1956	3	2 27/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	K21
HSB9150	3 7/32	3 1/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	G6
HSB1903	3 7/32	3 1/32	1	F	ALY.I.H.	1 3/4	5	ALY.C.H.	K21
HSB959	3 25/32	3 15/32	1 1/4	F	ALY.I.H.	2 3/8	6	ALY.C.H.	G6
HSB964	3 25/32	3 15/32	1 1/4	F	ALY.I.H.	2 3/8	6	ALY.C.H.	K44
HSB6322	2 9/32	2 1/32	3/4	A	ALY.I.H.	1 1/2	4	L.C.C.H.	G16A
HSB6102½	2 3/8	2 1/8	3/4	A	ALY.I.H.	1 3/8	2	ALY.C.H.	G16A
HSB6124	2 9/16	2 11/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	G16A
HSB852	3 7/32	3 1/32	1	F	ALY.I.H.	1 3/4	6	ALY.C.H.	
HSB1259	3 25/32	3 15/32	1 1/4	F	ALY.I.H.	2 3/8	6	ALY.C.H.	

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Turbo Series Chains



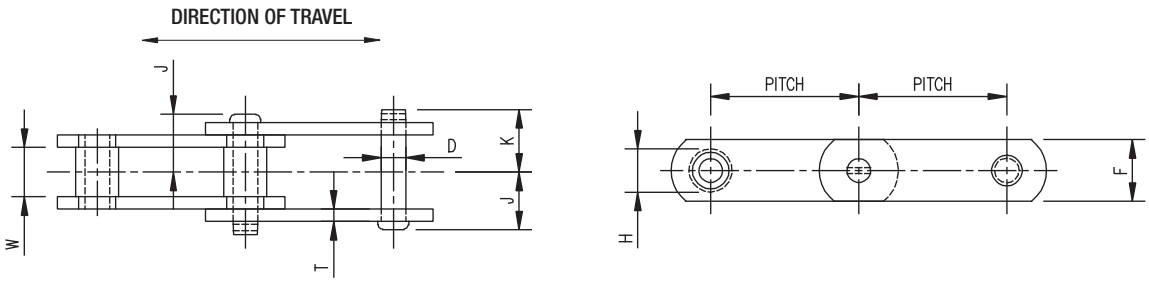
TURBO SERIES CHAINS BACKED BY
FOUR YEAR PERFORMANCE GUARANTEE

Webster Industries, Inc. guarantees the Turbo Series cement chains when properly installed, maintained, and applied, without alteration, in a cement mill bucket elevator, will not fail because of any defect in material or workmanship for four (4) years. In the event of any failure, the chain or defective part, at Webster's option, will be replaced, in accordance with the following schedule:

1st Year	-	Chain or Part Replaced at No Charge
2nd Year	-	Chain or Part Replaced at 40% of Original Price
3rd Year	-	Chain or Part Replaced at 70% of Original Price
4th Year	-	Chain or Part Replaced at 90% of Original Price

Remedy under this guarantee is between the user and Webster and no other person. Webster's liability is limited to the replacement of the defective product and the user waives all other remedies, including but not limited to all rights to consequential, special or accidental damages, including but not limited to damages resulting from personal injury, death or damage to or loss of use of property. This guarantee commences upon date of shipment.

SELLER MAKES NO OTHER WARRANTY OF ANY KIND WHATEVER, EXPRESS OR IMPLIED. ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE HEREBY DISCLAIMED BY THE SELLER AND EXCLUDED FROM THIS AGREEMENT.



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.☆	Sidebars Thk. T	Sidebars Height F	Inside Sidebars W	Overall Width ℄ To Cotter End K	Overall Width ℄ To Head or Rivet End J	Pins Dia. D	Bushings Outside Dia. H	Common Attachment Numbers
TS856	6.000	20	16.2	150,000	14,000	½	2½	3	3	2 27/32	1	1¾	A2M, K2M, K3M, K24M, K35M
TS956	6.000	20	17.3	150,000	14,000	½	3▼▼▼	3	3	2 27/32	1	1¾	A2M, K2M, K3M, K24M, K35M
TS857	6.000	20	21.0	150,000	14,000	½	3¼▼▼	3	3 5/32	2 27/32	1	1¾	A2M, K2M, K44
TS859	6.000	20	34.0	250,000	21,875	⅝	4▽▽▽	3¾	3 25/32	3 15/32	1¼	2⅜	K44
TS864	7.000	17	32.0	250,000	21,875	⅝	4▽▽▽	3¾	3 25/32	3 15/32	1¼	2⅜	K443

Common HSB Chain Attachments

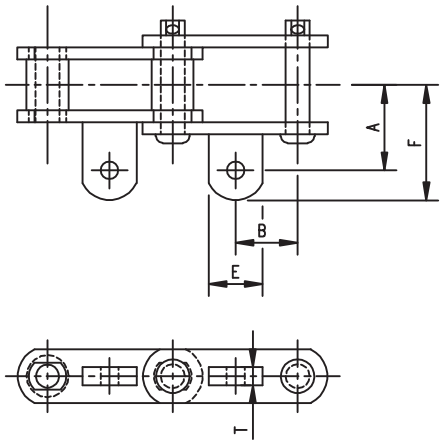
A22

Chain No.	A	B	E	F	T	Weight Per Foot-Lbs. Δ	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB188	1 25/32	1 5/16	1 1/8	2 13/32	3/8	—	4.8	3/8
HSB102B	2 7/16	2	1 1/4	3 1/16	1/2	7.5	—	5/8
HSB110	3	3	1 1/2	3 27/32	3/8	6.7	—	5/8

HSB188 can be furnished on pinhead or cotter side.

A42

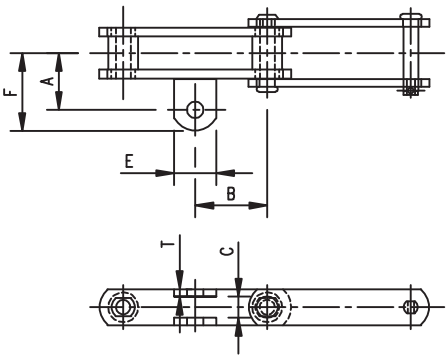
HSB131✚	2 1/2	1 17/32	1 1/2	3 1/8	3/8	—	9.6	1/2
HSB825	2 3/4	2 1/8	1 1/2	3 9/16	5/8	10.0	—	5/8
HSB110	2 1/2	3	1 3/4	3 3/16	9/16	6.9	—	5/8
HSB830	2 9/16	3	2	3 9/16	5/8	9.0	—	3/4



A22 and A42

A53

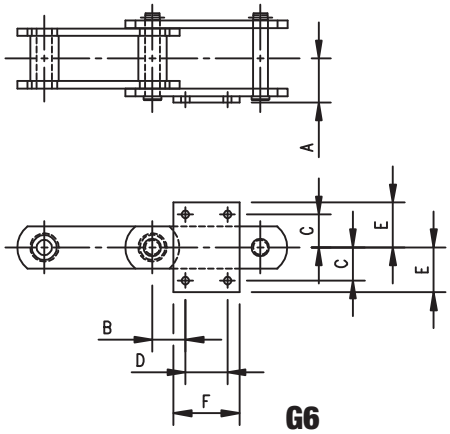
Chain No.	A	B	C	E	F	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB1316	2	3	7/8	1 3/4	2 23/32	5/16	6.9	1/2



A53

G6

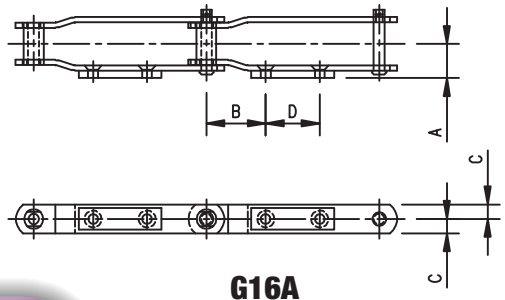
Chain No.	A	B	C	D	E	F	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB959	3 21/32	2 3/4	2 3/4	3 1/2	3 3/4	5 1/2	32.1	5/8
HSB9124	2 17/32	2 3/4	2 1/4	3 1/2	3 1/4	5 1/2	16.2	5/8
HSB9150	3 7/32	2 3/4	2 1/4	3 1/2	3 1/4	5 1/2	17.5	5/8



G6

G16A

Chain No.	A	B	C	D	Weight Per Foot-Lbs. Δ	Bolt Size
HSB6102½	2 3/8	4 1/8	1	3 3/4	8.2	5/8 ●
HSB6322	2 9/32	4 1/8	1	3 3/4	8.3	5/8 ●
HSB6124	2 17/32	4 1/8	1 1/4	3 3/4	12.8	5/8 ●



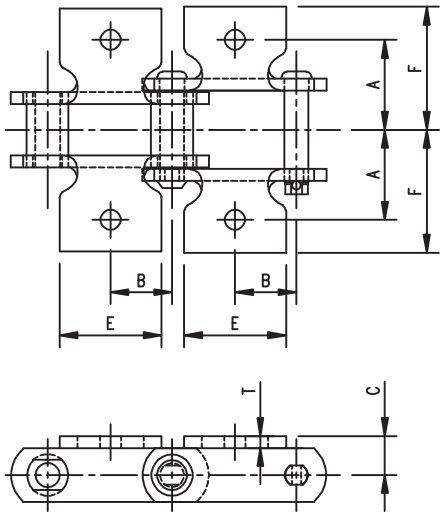
G16A

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common HSB Chain Attachments

K1

Chain No.	A	B	C	E	F Max.	T	Weight Per Foot-Lbs. Δ	Bolt Size
HSB188	1⅞	1⁵⁄₁₆	¹³⁄₁₆	2⅛	2⁹⁄₁₆	¼	5.8	⅜
HSB131	2¹⁄₁₆	1¹⁷⁄₃₂	1¹⁄₁₆	2½	2¹⁵⁄₁₆	⅜	10.2	⅜
HSB102B	2⅜	2	1¹⁄₁₆	2¾	3⅜	⅜	9.0	⅜
HSB111	3⅛	2⅜	1½	2¼	3¾	⅜	15.2	⅜



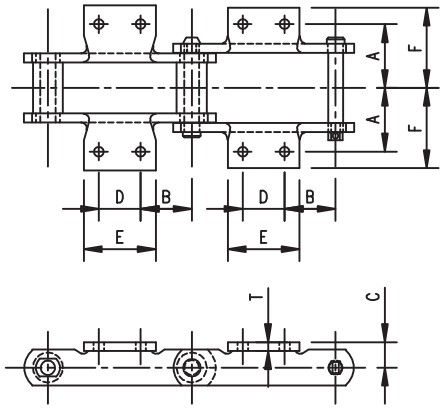
K1

K2 STRAIGHT

Chain No.	A	B	C	D	E	F Max.	T	Weight Per Foot-Lbs. Δ	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB188	2³⁄₃₂	1¹⁄₁₆	¹³⁄₁₆	1¼	2⅛	2⁹⁄₁₆	¼	5.8	—	⁵⁄₁₆
HSB131	2¹⁄₁₆	²⁵⁄₃₂	1¹⁄₁₆	1½	2½	2¹⁵⁄₁₆	⅜	10.2	—	½
HSB102B	2²¹⁄₃₂	1⅛	1¹⁄₁₆	1¾	2¾	3⅜	⅜	9.0	—	⅜
HSB102½	2²¹⁄₃₂	1⁹⁄₆₄	1¹⁄₁₆	1¾	2⅞	3³⁄₃₂	⅜	13.4	—	½
HSB111SPC	3⅛	1⁷⁄₃₂	1½	2⁵⁄₁₆	3⅝	3¾	⅜	—	10.3	½
HSB110	2²¹⁄₃₂	2⅛	1⅛	1¾	3	3⅜	⅜	8.6	—	⅜
HSB844	3³⁄₃₂	1⅝	1¼	2¾	4¼	4¾	½	14.9	—	½

K22

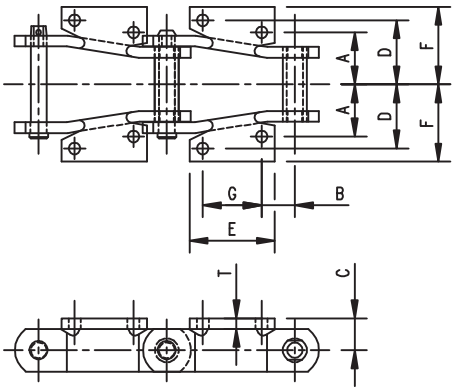
Chain No.	A	B	C	D	E	F Max.	T	Weight Per Foot-Lbs. Δ	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB110	2²¹⁄₃₂	2⅛	1¹⁄₁₆	1¾	3	3⁷⁄₁₆	⅜	8.6	—	½



K2 STRAIGHT and K22

K2 OFFSET

Chain No.	A	B	C	D	E	F Max.	G	T	Weight Per Foot-Lbs. Δ	Bolt Size
HSB825	3	1¹⁄₁₆	1¼	3	3¾	3⅝	2⅝	⅜	16.0	½
HSB830	3	1¹¹⁄₁₆	1¼	3	3⅞	3⅝	2⅝	⅜	12.3	½
HSB844	2⁷⁄₁₆	1⁹⁄₁₆	1½	3	4	3⅝	2¾	½	14.9	½

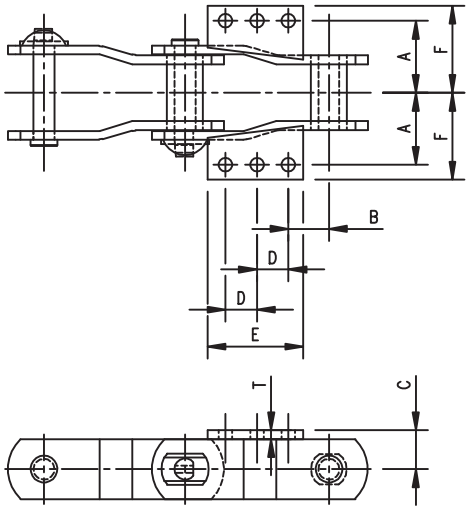


K2 OFFSET

Common HSB Chain Attachments

K2/K3

Chain No.	A	B	C	D	E	F Max.	T	Weight Per Foot-Lbs. Δ	Bolt Size
HSB826	3	1 11/16	1 5/8	1 5/16	4	3 5/8	3/8	17.0	1/2



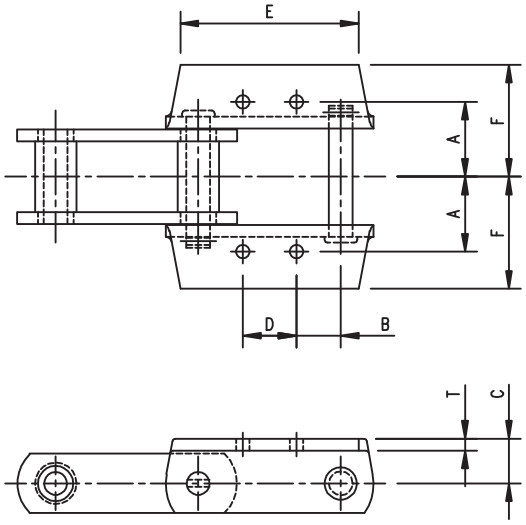
K2/K3

K2M

Chain No.	A	B	C	D	E	F Max.	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB102B	2 21/32	1 1/8	1 1/16	1 3/4	4 1/2	3 11/32	3/8	9.1	3/8
HSB102 1/2	2 21/32	1 9/64	1 1/16	1 3/4	4 3/4	3 3/8	3/8	9.3	1/2
HSB110	2 21/32	2 1/8	1 1/16	2 1/8	6 27/32	3 9/32	3/8	8.6	3/8
HSB111	3 1/8	1 7/32	1 1/2	2 5/16	5 1/2	3 29/32	3/8	13.0	1/2
HSB150+	3 3/4	1 21/32	1 7/8	2 3/4	7 1/2	4 3/4	1/2	22.4	1/2
HSB833	3 1/8	1 27/32	1 7/8	2 5/16	7 3/4	4 1/16	3/8	14.5	1/2
HSB856B	3 5/32	1 7/8	1 7/8	2 1/4	7 1/2	4 3/4	1/2	22.0	1/2
TS856	3 5/32	1 7/8	1 7/8	2 1/4	7 1/2	4 3/4	1/2	22.0	1/2
HSB857A	3 13/16	1 5/8	2 1/2	2 3/4	7 3/32	4 23/32	1/2	21.5	5/8
TS857	3 13/16	1 5/8	2 1/2	2 3/4	7 3/32	4 23/32	1/2	21.5	5/8
HSB956	3 5/32	1 7/8	1 7/8	2 1/4	7 1/2	4 3/4	1/2	23.1	1/2
TS956	3 5/32	1 7/8	1 7/8	2 1/4	7 1/2	4 3/4	1/2	23.1	1/2

K24M+

HSB856B	3 5/8	1 3/4	1 7/8	2 1/2	7 1/2	4 3/4	1/2	22.0	5/8
TS856	3 5/8	1 3/4	1 7/8	2 1/2	7 1/2	4 3/4	1/2	22.0	5/8
HSB956	3 5/8	1 3/4	1 7/8	2 1/2	7 1/2	4 3/4	1/2	23.1	5/8
TS956	3 5/8	1 3/4	1 7/8	2 1/2	7 1/2	4 3/4	1/2	23.1	5/8



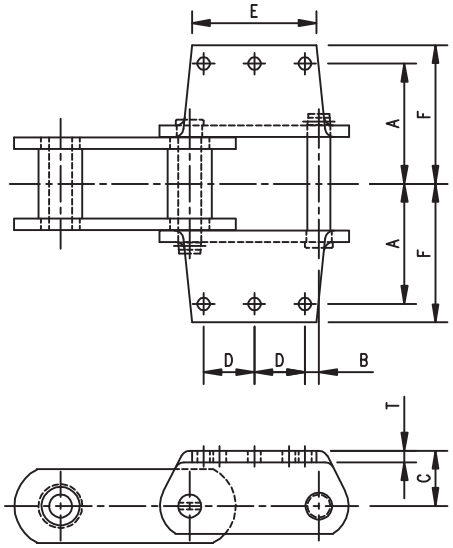
K2M and K24M

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common HSB Chain Attachments

K3+

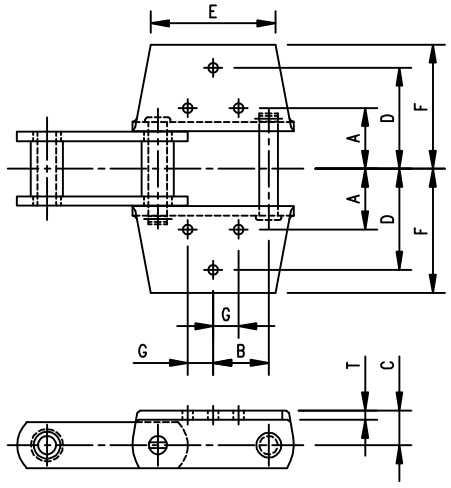
Chain No.	A	B	C	D	E	F Max.	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB2866	6⅞	¾	3	2¾	6½	8½	⅝	47.5	⅝



K3

K3M+

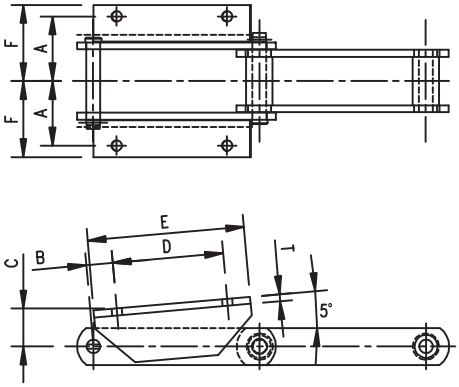
Chain No.	A	B	C	D	E	F Max.	G	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB150+	3¾	3⅛₂	1⅞	5¾	4¼	6¹⁵⁄₁₆	1⅜	½	26.9	⅝



K3M

K21

Chain No.	A	B	C	D	E	F Max.	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB1219	3½	1⁷⁄₁₆	2¹⁄₁₆	6	8½	4⅛	⅜	13.0	½
HSB1903	3⅞	2¹¹⁄₁₆	2⁵⁄₃₂	3½	5½	5¼	½	20.3	½
HSB1956	3³¹⁄₃₂	1⁷⁄₁₆	2¹⁄₁₆	6	8½	4¹⁷⁄₃₂	½	18.1	½



K21

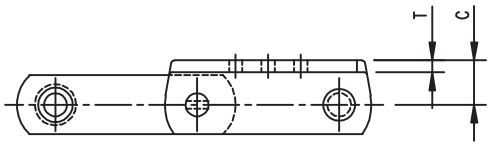
Common HSB Chain Attachments

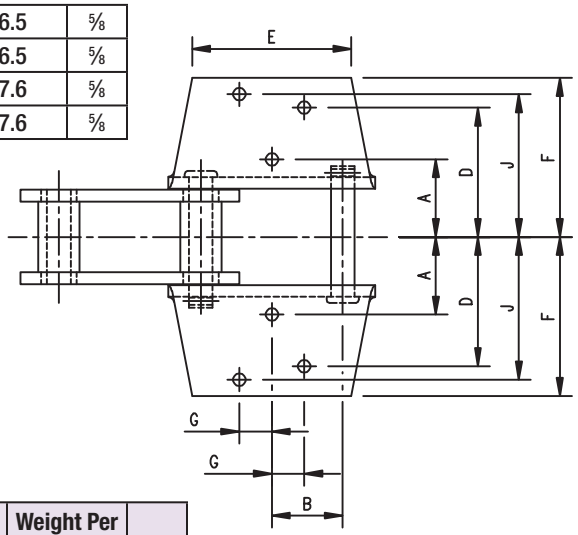
K3M+

Chain No.	A	B	C	D	E	F Max.	G	J	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB856B	3 9/32	3	1 7/8	5 15/32	6 3/4	6 3/4	1 3/8	6 1/32	1/2	26.5	1/2
TS856	3 9/32	3	1 7/8	5 15/32	6 3/4	6 3/4	1 3/8	6 1/32	1/2	26.5	1/2
HSB956	3 9/32	3	1 7/8	5 15/32	6 3/4	6 3/4	1 3/8	6 1/32	1/2	27.6	1/2
TS956	3 9/32	3	1 7/8	5 15/32	6 3/4	6 3/4	1 3/8	6 1/32	1/2	27.6	1/2

K35M+

HSB856B	3 5/8	3	1 7/8	5 7/8	6 3/4	6 3/4	1 1/4	5 7/8	1/2	26.5	5/8
TS856	3 5/8	3	1 7/8	5 7/8	6 3/4	6 3/4	1 1/4	5 7/8	1/2	26.5	5/8
HSB956	3 5/8	3	1 7/8	5 7/8	6 3/4	6 3/4	1 1/4	5 7/8	1/2	27.6	5/8
TS956	3 5/8	3	1 7/8	5 7/8	6 3/4	6 3/4	1 1/4	5 7/8	1/2	27.6	5/8





K3M and K35M

K4M+ (8 Holes, no center hole in outside rows)

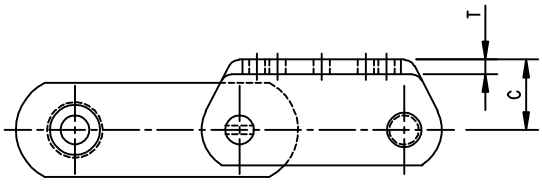
Chain No.	A	B	C	D	E	F Max.	G	J	K	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
HSB2858A	3 1/8	2 1/2	2 3/8	5 7/8	7 1/4	6 3/4	2 1/2	2 1/2	1 3/4	1/2	24.3	5/8

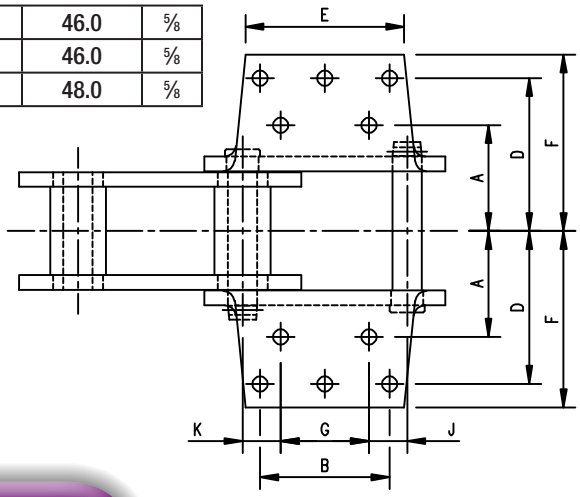
K44+ (8 Holes, no center hole in outside rows)

HSB857A	3 1/2	3 1/2	2 1/2	6	6 1/2	7	3 1/2	1 1/4	1 1/4	1/2	32.0	1/2
TS857	3 1/2	3 1/2	2 1/2	6	6 1/2	7	3 1/2	1 1/4	1 1/4	1/2	32.0	1/2
HSB859B	4 1/2	4 1/2	3	6 1/2	7 1/4	7 1/4	2 3/4	1 5/8	3/4	5/8	48.0	5/8
TS859	4 1/2	4 1/2	3	6 1/2	7 1/4	7 1/4	2 3/4	1 5/8	3/4	5/8	48.0	5/8
HSB964	4 1/2	4 1/2	3	6 1/2	10 1/4	7 1/4	2 3/4	3 1/8	2 1/4	5/8	38.0	5/8

K443+ (10 Holes)

HSB864B▼	4 1/2	5 1/2	3	6 1/2	8 1/4	7 1/4	3 3/4	1 5/8	3/4	5/8	46.0	5/8
TS864	4 1/2	5 1/2	3	6 1/2	8 1/4	7 1/4	3 3/4	1 5/8	3/4	5/8	46.0	5/8
HSB984	4 1/2	5 1/2	3	6 1/2	8 1/4	7 1/4	3 3/4	1 5/8	3/4	5/8	48.0	5/8



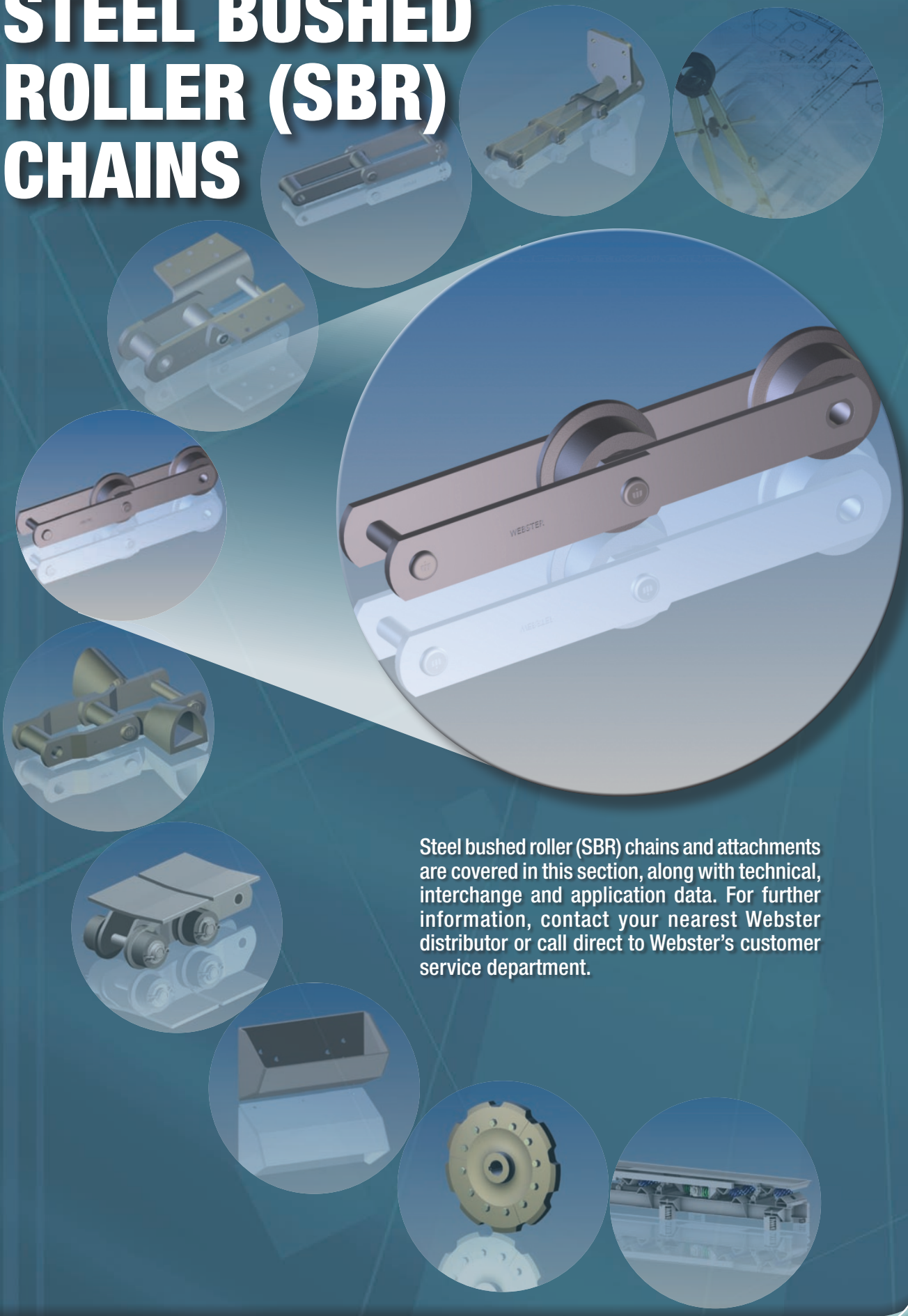


K4M, K44 and K443

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Notes

STEEL BUSHED ROLLER (SBR) CHAINS



Steel bushed roller (SBR) chains and attachments are covered in this section, along with technical, interchange and application data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

SBR Chains



Steel bushed roller (SBR) chains are used for a broad range of conveyor and elevator applications. They are the appropriate selection for long life and heavy-duty service where difficult operating conditions prevail.

MATERIAL

Sidebars are medium carbon steel. Pins are alloy steel and are thru hardened for maximum chain life. Pins can be induction hardened for even more wear resistance. Sidebars and pins can be furnished with additional heat treatment on request. Bushings are case hardened steel to provide maximum wear resistance and chain life. Rollers are available in various designs and materials for different application requirements.

ASSEMBLY

Riveted construction is recommended for wood yards and sawmills. Cottered construction is recommended for elevators and conveyors. Riveted or cottered construction must be specified.

INTERCHANGEABILITY

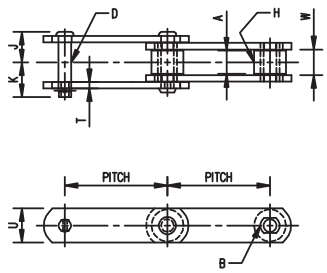
SBR chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

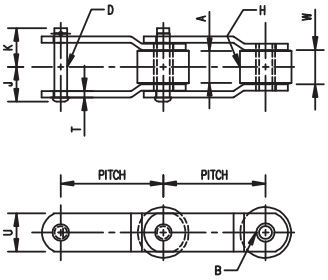
SBR chains are used in bucket elevators, flight conveyors, scraper conveyors and other conveying applications where difficult operating conditions prevail. The roller provides a lower operating friction which helps increase chain life and reduces conveyor design requirements.

OPERATION

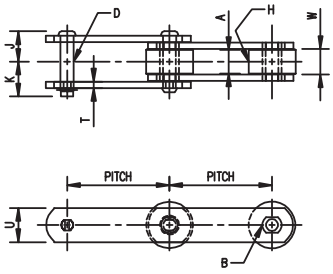
Best suited for slow or moderate speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.



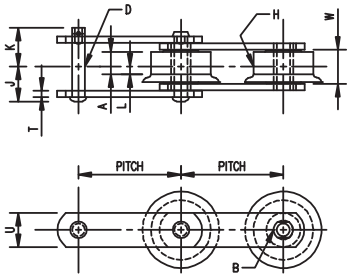
STYLE 1



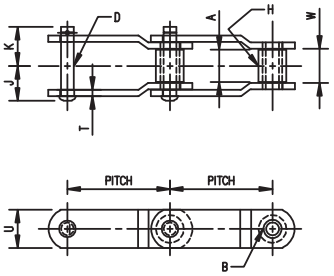
STYLE 2



STYLE 3



STYLE 4



STYLE 5

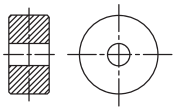
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . . Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

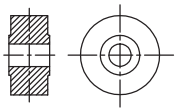
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
S1500	1	1.500	80	3.7	12,000	2,000	1⅛	1⁵⁄₃₂	1⅛	⁷⁄₁₆	B	ALY.H.T.
S1578	5	2.609	46	2.8	12,000	2,000	1⅛	1⁵⁄₃₂	1⅛	⁷⁄₁₆	B	ALY.H.T.

SBR Chains

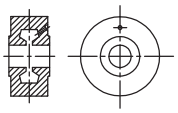
ROLLERS



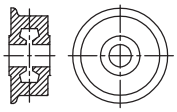
STYLE A



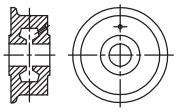
STYLE B



STYLE D

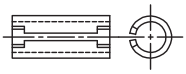


STYLE E

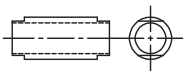


STYLE G

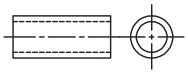
BUSHINGS



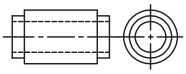
STYLE 1



STYLE 2

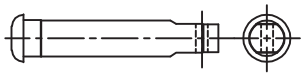


STYLE 3

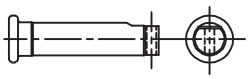


STYLE 4

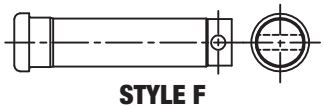
PINS



STYLE A



STYLE B



STYLE F

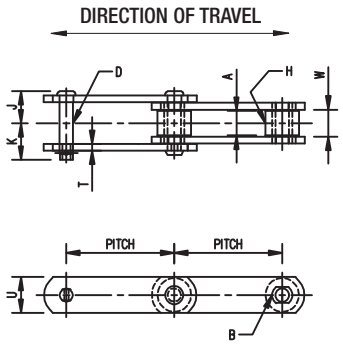
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

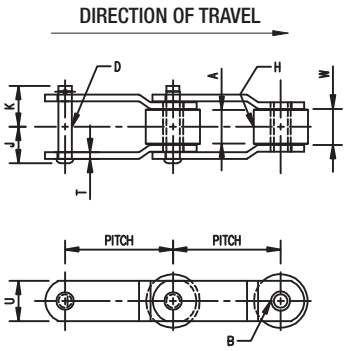
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
S1500	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	13/16	1 1/32	—	A	L.C.C.H.	A42
S1578	3/16	1	M.C.	5/8	3	L.C.C.H.	7/8	1 1/32	—	A	L.C.C.H.	

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

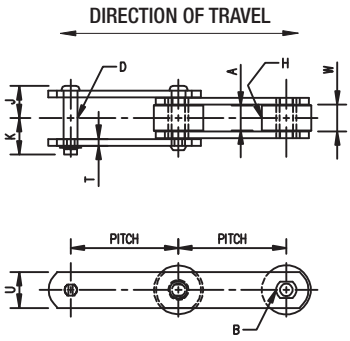
SBR Chains



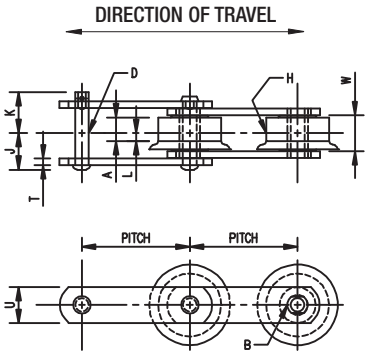
STYLE 1



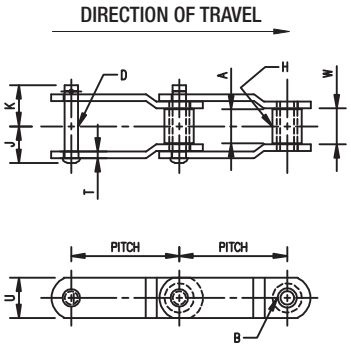
STYLE 2



STYLE 3



STYLE 4



STYLE 5

Chain Style Descriptions

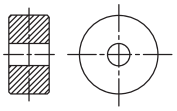
Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

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			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
SS881	1	2.609	46	3.0	14,000	2,300	1⅛	1⁹⁄₃₂	1⅛	⁷⁄₁₆	B	ALY.H.T.
SS881+	1	2.609	46	3.8	27,890	2,490	1⅛	1⁹⁄₃₂	1⅛	⁷⁄₁₆	B	ALY.H.T.
S588+	5	2.609	46	3.8	27,890	2,490	1⅛	1⁹⁄₃₂	1¼	⁷⁄₁₆	B	ALY.H.T.
S788+	1	2.609	46	3.8	27,890	2,490	1⅛	1⁹⁄₃₂	1¼	⁷⁄₁₆	B	ALY.H.T.
81X	1	2.609	46	2.5	24,000	2,500	1¹⁄₁₆	1⁵⁄₃₂	1	⁷⁄₁₆	F	ALY.C.H.
81XH	1	2.609	46	3.8	33,000	2,750	1¹⁄₁₆	1⅜	1³⁄₁₆	⁷⁄₁₆	F	ALY.C.H.
81XHH	1	2.609	46	4.5	42,000	3,100	1¹⁄₁₆	1¹⁵⁄₃₂	1⁹⁄₃₂	⁷⁄₁₆	F	ALY.C.H.
S1183	3	3.000	40	4.0	14,000	2,100	1	1⁷⁄₃₂	1¹⁄₁₆	⁷⁄₁₆	B	ALY.H.T.
S1184	3	3.000	40	4.0	14,000	2,300	1⅛	1⁵⁄₃₂	1⅛	⁷⁄₁₆	B	ALY.H.T.
S4001	3	3.000	40	4.9	19,000	2,730	1¹⁄₁₆	1¹¹⁄₃₂	1⁷⁄₃₂	½	A	ALY.H.T.
S1800+	5	3.075	39	6.2	30,000	2,730	1¹⁄₁₆	1¹¹⁄₃₂	1⁷⁄₃₂	½	A	ALY.H.T.
S554	5	3.075	39	7.0	28,000	4,650	1½	1²⁵⁄₃₂	1⅝	⅝	A	ALY.H.T.
S554+	5	3.075	39	7.0	41,000	4,650	1½	1²⁵⁄₃₂	1⅝	⅝	A	ALY.H.T.
SS554	1	3.075	39	6.8	28,000	4,650	1½	1²⁵⁄₃₂	1⅝	⅝	A	ALY.H.T.
SS554+	1	3.075	39	6.8	41,000	4,650	1½	1²⁵⁄₃₂	1⅝	⅝	A	ALY.H.T.

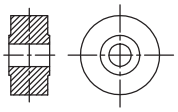
81XH outside sidebars are ⁷⁄₃₂" thick.

SBR Chains

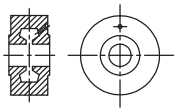
ROLLERS



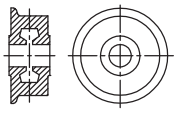
STYLE A



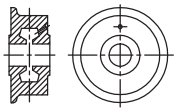
STYLE B



STYLE D

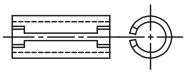


STYLE E

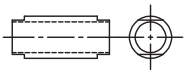


STYLE G

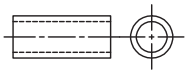
BUSHINGS



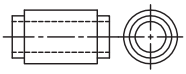
STYLE 1



STYLE 2

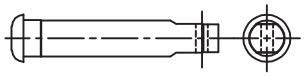


STYLE 3

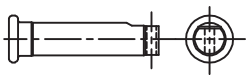


STYLE 4

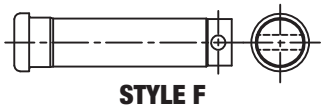
PINS



STYLE A



STYLE B



STYLE F

Abbreviations of Material and Treatment

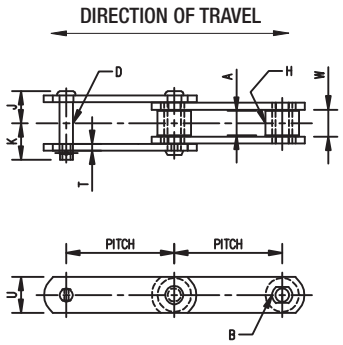
M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
SS881	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	7/8	1 1/32	—	A	L.C.C.H.	A1, A2, K1, K2
SS881+	3/16	1 1/8	M.C.H.T.	5/8	3	L.C.C.H.	7/8	1 1/32	—	A	L.C.C.H.	A1, A2, K1, K2
S588+	1/4	1 1/8	M.C.H.T.	5/8	3	L.C.C.H.	7/8	1 1/32	—	A	L.C.C.H.	
S788+	1/4	1 1/8	M.C.H.T.	5/8	3	L.C.C.H.	7/8	1 1/32	—	A	L.C.C.H.	A1, K1
81X	5/32	1 1/8	M.C.H.T	19/32	3	L.C.C.H.	29/32	31/32	—	A	L.C.C.H.	
81XH	5/16	1 1/4	M.C.H.T	19/32	3	L.C.C.H.	29/32	31/32	—	A	L.C.C.H.	
81XHH	5/16	1 1/4	M.C.H.T	19/32	3	L.C.C.H.	29/32	31/32	—	A	L.C.C.H.	
S1183	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	1 1/2	7/8	—	A	L.C.C.H.	A1, A2, A11, A42, K1, K2, M3
S1184	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	1 1/2	1	—	A	L.C.C.H.	A1, A2, A11, A42, K1, K2, M3
S4001	1/4	1 1/4	M.C.	3/4	3	L.C.C.H.	1 1/2	15/16	—	A	L.C.C.H.	
S1800+	1/4	1 1/4	M.C.H.T.	3/4	3	L.C.C.H.	1 1/8	15/16	—	A	L.C.C.H.	
S554	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	L.C.C.H.	
S554+	5/16	1 1/2	M.C.H.T.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	L.C.C.H.	
SS554	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	L.C.C.H.	A1, K1
SS554+	5/16	1 1/2	M.C.H.T.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	L.C.C.H.	A1, K1

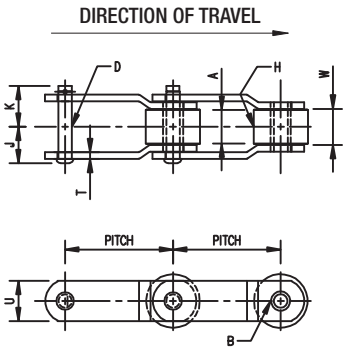
81XH outside sidebars are 7/32" thick.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

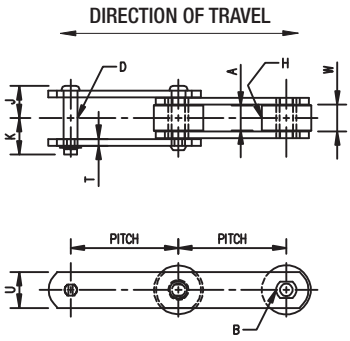
SBR Chains



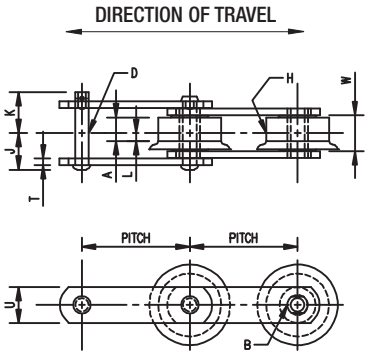
STYLE 1



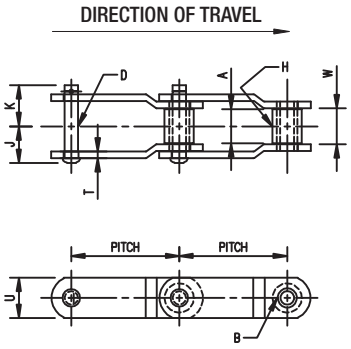
STYLE 2



STYLE 3



STYLE 4



STYLE 5

Chain Style Descriptions

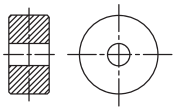
Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

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			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
SR131	1	3.075	39	7.4	42,000	4,375	1¼	1 13/16	1⅝	⅝	A	ALY.H.T.
S2219	5	3.675	33	4.7	44,000	3,450	1¼	1 15/32	1 11/32	9/16	B	ALY.H.T.
S1112	3	3.690	33	6.3	21,000	3,500	1 5/16	1½	1⅜	9/16	B	ALY.H.T.
S1120	3	4.000	30	3.4	14,000	2,100	1	1 7/32	1 1/16	7/16	B	ALY.H.T.
S1121	3	4.000	30	3.5	14,000	2,300	1⅛	1 5/32	1⅛	7/16	B	ALY.H.T.
S1122	3	4.000	30	4.1	14,000	2,300	1⅛	1 5/32	1⅛	7/16	B	ALY.H.T.
S1195	3	4.000	30	4.8	14,000	2,300	1⅛	1 5/32	1⅛	7/16	B	ALY.H.T.
S4019	3	4.000	30	4.1	19,000	2,450	⅞	1 9/32	1⅛	½	A	ALY.H.T.
S1478	3	4.000	30	7.0	27,000	2,730	1 1/16	1 11/32	1 7/32	½	A	ALY.H.T.
S4002	3	4.000	30	4.0	19,000	2,730	1 1/16	1 11/32	1 7/32	½	A	ALY.H.T.
S1119	3	4.000	30	6.7	21,000	3,500	1 5/16	1½	1⅜	9/16	B	ALY.H.T.
S2436+	5	4.000	30	4.8	44,000	3,450	1¼	1 15/32	1 11/32	9/16	B	ALY.H.T.
S2400+	5	4.000	30	4.8	44,000	3,570	1 5/16	1⅜	1½	9/16	B	ALY.H.T.
S2188	3	4.000	30	7.1	28,000	4,240	1 5/16	1 23/32	1 17/32	⅝	A	ALY.H.T.
SS555	1	4.000	30	6.0	28,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.

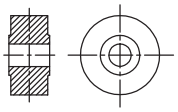
SBR Chains

E
PAGE E-7

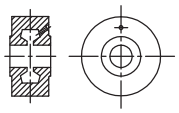
ROLLERS



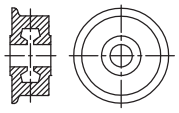
STYLE A



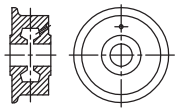
STYLE B



STYLE D

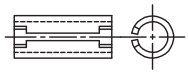


STYLE E

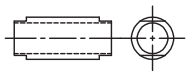


STYLE G

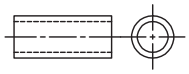
BUSHINGS



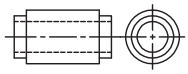
STYLE 1



STYLE 2

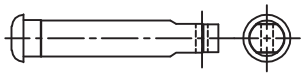


STYLE 3

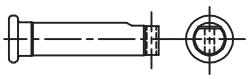


STYLE 4

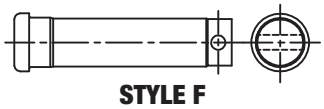
PINS



STYLE A



STYLE B



STYLE F

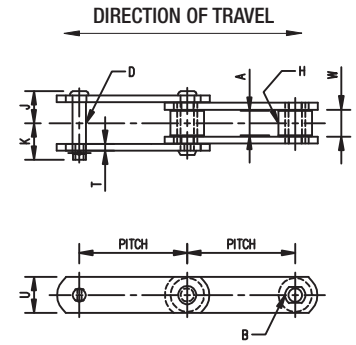
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

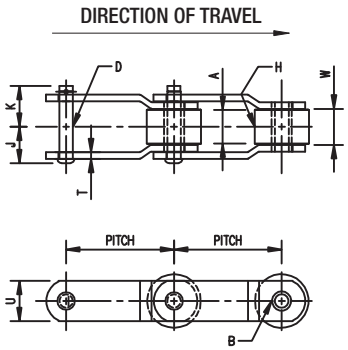
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
SR131	3/8	1 1/2	M.C.H.T.	29/32	1	L.C.C.H.	1 1/4	1 1/8	—	A	L.C.C.H.	
S2219	1/4	1 1/2	M.C.H.T.	13/16	3	L.C.C.H.	1 1/8	1 1/8	—	A	ALY.H.T.	
S1112	1/4	1 1/2	M.C.	13/16	3	L.C.C.H.	1 3/4	1 3/16	—	A	L.C.C.H.	A42, A2, K2
S1120	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	1 1/2	7/8	—	A	L.C.C.H.	A1, A2, A11, A42, K1, K2, M3
S1121	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	1 1/2	1	—	A	L.C.C.H.	A1, A2, A11, A42, K1, K2, M3
S1122	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	1 3/4	1	—	A	L.C.C.H.	A1, A2, K1, K2
S1195	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	2	1	—	A	L.C.C.H.	A1, A2, A11, K1, K2, M3
S4019	1/4	1 1/4	M.C.	3/4	3	L.C.C.H.	1 1/2	3/4	—	A	L.C.C.H.	A1, A2, K1, K2
S1478	1/4	1 1/2	M.C.H.T.	7/8	2	L.C.C.H.	2 1/4	15/16	—	A	L.C.C.H.	A2, K2
S4002	1/4	1 1/4	M.C.	3/4	3	L.C.C.H.	1 1/2	15/16	—	A	L.C.C.H.	A1, A2, A11, A22, A42, G29, K1, K2
S1119	1/4	1 1/2	M.C.	13/16	3	L.C.C.H.	2	1 3/16	—	A	L.C.C.H.	A1, K1
S2436+	1/4	1 1/2	M.C.H.T.	13/16	3	L.C.C.H.	1 1/8	1 1/8	—	A	ALY.H.T.	
S2400+	1/4	1 1/2	M.C.H.T.	13/16	3	L.C.C.H.	1 1/8	1 3/16	—	A	L.C.C.H.	
S2188	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 3/4	1 3/16	—	A	L.C.C.H.	A1, A2, K1, K2
SS555	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	L.C.C.H.	A2, K2

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

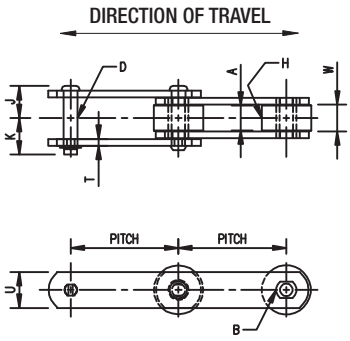
SBR Chains



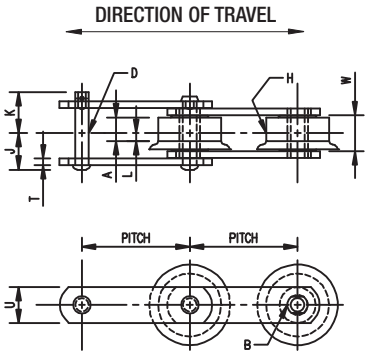
STYLE 1



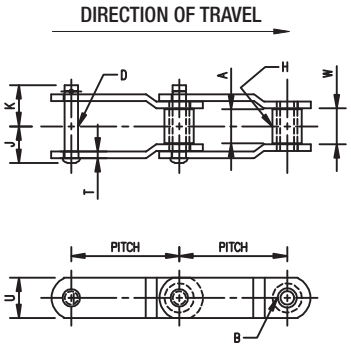
STYLE 2



STYLE 3



STYLE 4



STYLE 5

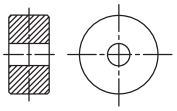
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

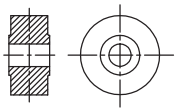
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
S2450+	5	4.000	30	6.0	52,000	4,650	1½	1 25/32	1 5/8	5/8	A	ALY.I.H.
S531	3	4.000	30	9.5	32,000	4,375	1¼	1 13/16	1 5/8	5/8	A	ALY.H.T.
S3945	1	4.000	30	6.6	40,000	5,740	2	2 3/32	1 7/8	5/8	B	ALY.I.H.
S4830	1	4.000	30	7.7	40,000	6,290	2 1/8	2 3/16	2 1/16	5/8	A	ALY.I.H.
S3433	1	4.000	30	8.7	40,000	6,290	2 1/8	2 3/16	2 1/16	5/8	A	ALY.H.T.
S3433SPC	3	4.000	30	9.2	40,000	6,290	2 1/8	2 3/16	2 1/16	5/8	A	ALY.H.T.
S3952	1	4.000	30	8.2	40,000	7,220	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
S1140	3	4.000	30	12.1	38,000	4,800	1 3/8	1 21/32	1 9/16	11/16	B	ALY.H.T.
S1113	3	4.040	30	7.9	28,000	4,240	1 5/16	1 23/32	1 17/32	5/8	A	ALY.H.T.
S2268	1	4.083	29	11.9	62,600	7,220	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
S2268SPC	1	4.083	29	17.0	62,600	7,220	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
S2268HD	1	4.083	29	17.0	100,000	8,400	2	2 9/32	2 1/32	7/8	A	ALY.I.H.
S3945SPC	1	4.090	29⅓	7.0	40,000	5,740	2	2 3/32	1 7/8	5/8	B	ALY.H.T.
S3968	1	4.610	26	8.4	40,000	5,740	2	2 3/32	1 27/32	5/8	B	ALY.I.H.
S9111A	1	4.760	25	11.2	50,000	8,850	2 5/8	2 19/32	2 11/32	3/4	A	ALY.I.H.

SBR Chains

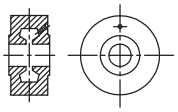
ROLLERS



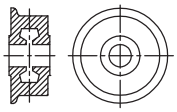
STYLE A



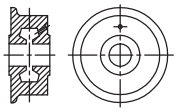
STYLE B



STYLE D

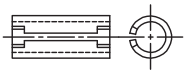


STYLE E

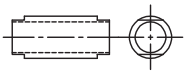


STYLE G

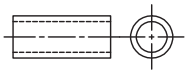
BUSHINGS



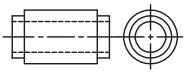
STYLE 1



STYLE 2

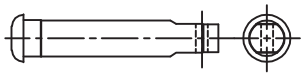


STYLE 3

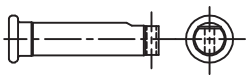


STYLE 4

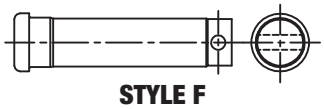
PINS



STYLE A



STYLE B



STYLE F

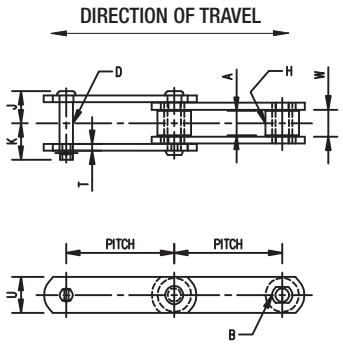
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

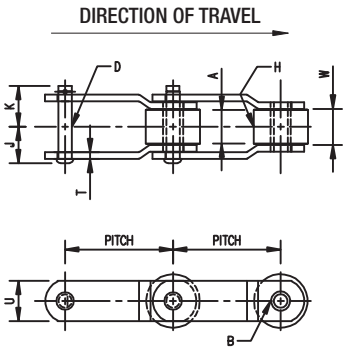
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
S2450+	5/16	1 1/2	M.C.H.T.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	ALY.C.H.	
S531	3/8	1 1/2	M.C.	29/32	1	L.C.C.H.	2 1/4	1 1/8	—	A	L.C.C.H.	A1, A2, A42, K1, K2
S3945	5/16	1 1/2	M.C.H.T.	7/8	3	ALY.C.H.	1 1/4	1 7/8	—	A	ALY.C.H.	K23, M2
S4830	3/8	1 1/2	M.C.H.T.	7/8	2	ALY.C.H.	1 1/4	2	—	A	L.C.C.H.	K23
S3433	3/8	1 1/2	M.C.H.T.	1	2	ALY.C.H.	1 1/2	2	—	A	L.C.C.H.	K25
S3433SPC	3/8	1 1/2	M.C.H.T.	1	2	ALY.C.H.	1 5/8	2	—	A	L.C.C.H.	K25
S3952	3/8	1 3/4	M.C.H.T.	1 1/8	3	ALY.C.H.	1 7/16	1 7/8	—	A	ALY.C.H.	K22
S1140	5/16	2	M.C.	1	3	L.C.C.H.	2 1/2	1 3/16	—	A	L.C.C.H.	A1, K1, M3
S1113	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	2	1 3/16	—	A	L.C.C.H.	A2, A11, A22, K2
S2268	3/8	2 1/2	M.C.H.T.	1 1/8	3	ALY.C.H.	1 5/8	1 7/8	—	A	M.C.H.T.	K22, M2
S2268SPC	3/8	2 1/4	M.C.H.T.	1 1/8	3	ALY.C.H.	2	1 7/8	—	A	L.C.C.H.	K22
S2268HD	3/8	2 1/2	M.C.H.T.	1 1/4	3	ALY.C.H.	2	1 7/8	—	A	ALY.C.H.	K22
S3945SPC	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 3/8	1 7/8	—	A	ALY.C.H.	M2
S3968	5/16	2	M.C.H.T.	7/8	3	ALY.C.H.	1 3/8	1 7/8	—	A	M.C.H.T.	K23
S9111A	3/8	2	M.C.H.T.	1 7/16	4	L.C.C.H.	1 7/8	2 1/2	—	A	L.C.C.H.	K25

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

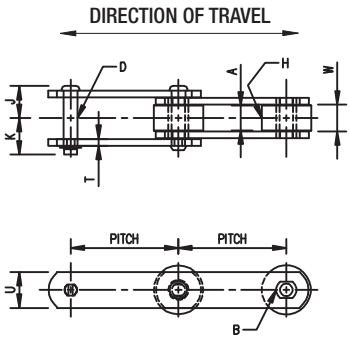
SBR Chains



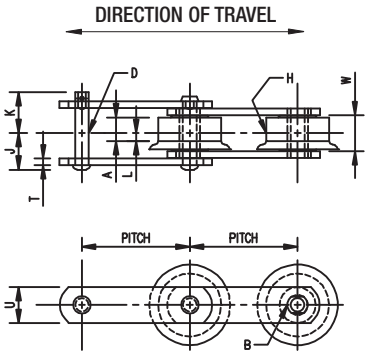
STYLE 1



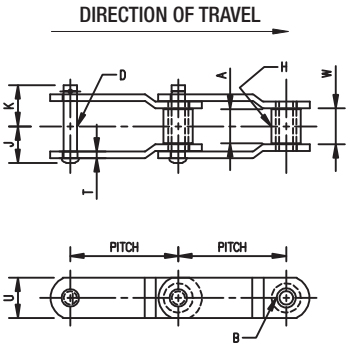
STYLE 2



STYLE 3



STYLE 4



STYLE 5

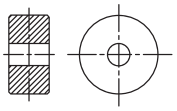
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

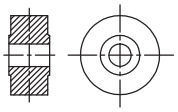
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
S1596	5	5.000	24	5.7	28,000	4,240	1 5/16	1 23/32	1 17/32	5/8	A	ALY.H.T.
S2035	1	5.188	23	14.4	124,000	9,350	2 5/16	2 3/8	2 7/32	7/8	B	ALY.I.H.
S1199	3	6.000	20	3.5	14,000	2,100	1	1 7/32	1 1/16	7/16	B	ALY.H.T.
S1197	3	6.000	20	3.6	14,000	2,300	1 1/8	1 5/32	1 1/8	7/16	B	ALY.H.T.
S1198	3	6.000	20	2.8	14,000	2,300	1 1/8	1 5/32	1 1/8	7/16	B	ALY.H.T.
S1196	3	6.000	20	5.3	21,700	2,490	1 1/8	1 9/32	1 1/4	7/16	B	ALY.H.T.
S4003	3	6.000	20	3.6	19,000	2,730	1 1/16	1 11/32	1 7/32	1/2	A	ALY.H.T.
S1604	2	6.000	20	7.2	27,000	2,730	1 1/16	1 11/32	1 7/32	1/2	A	ALY.H.T.
S1116	3	6.000	20	5.6	21,000	3,500	1 5/16	1 1/2	1 3/8	9/16	B	ALY.H.T.
S2190	3	6.000	20	6.6	21,000	3,500	1 5/16	1 1/2	1 3/8	9/16	B	ALY.H.T.
S2190F	4	6.000	20	7.0	21,000	3,500	1 5/16	1 1/2	1 3/8	9/16	B	ALY.H.T.
S1114	3	6.000	20	6.3	28,000	4,240	1 5/16	1 23/32	1 17/32	5/8	A	ALY.H.T.
S1670	3	6.000	20	6.9	28,000	4,240	1 5/16	1 23/32	1 17/32	5/8	A	ALY.H.T.
S2180	3	6.000	20	8.3	33,600	4,375	1 1/4	1 13/16	1 5/8	5/8	A	ALY.H.T.
S951	3	6.000	20	11.9	40,000	4,375	1 1/4	1 13/16	1 5/8	5/8	A	ALY.H.T.

SBR Chains

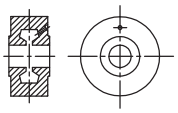
ROLLERS



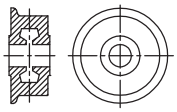
STYLE A



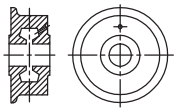
STYLE B



STYLE D

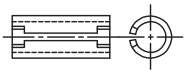


STYLE E

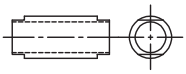


STYLE G

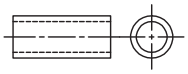
BUSHINGS



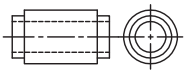
STYLE 1



STYLE 2

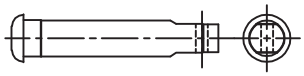


STYLE 3

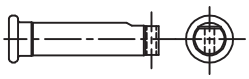


STYLE 4

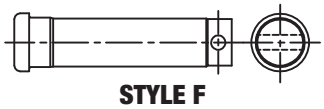
PINS



STYLE A



STYLE B



STYLE F

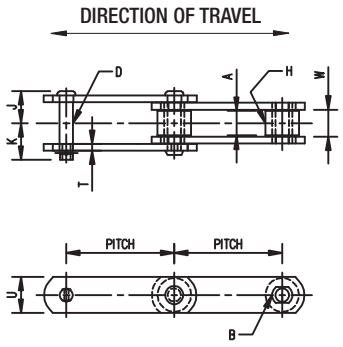
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

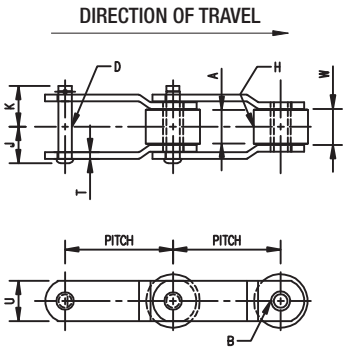
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
S1596	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 1/2	1 3/16	—	A	L.C.C.H.	A42
S2035	3/8	2 1/2	M.C.H.T.	1 1/4	3	ALY.C.H.	2	2 3/16	—	A	M.C.H.T.	K22
S1199	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	2	7/8	—	A	L.C.C.H.	A11
S1197	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	2	1	—	A	L.C.C.H.	A1, A2, A42, K1, K2
S1198	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	1 1/2	1	—	A	L.C.C.H.	
S1196	1/4	1 1/2	M.C.	5/8	3	L.C.C.H.	2	1	—	A	L.C.C.H.	A1, A2, K1, K2
S4003	1/4	1 1/4	M.C.	3/4	3	L.C.C.H.	1 1/2	15/16	—	A	L.C.C.H.	
S1604	1/4	1 1/2	M.C.	3/4	3	L.C.C.H.	3	15/16	—	A	L.C.C.H.	A42
S1116	1/4	1 1/2	M.C.	13/16	3	L.C.C.H.	2	1 3/16	—	A	L.C.C.H.	A1, A2, A42, K1, K2
S2190	1/4	1 1/2	M.C.	13/16	3	L.C.C.H.	2 1/2	1 3/16	—	A	L.C.C.H.	A2, A11, A42, K2
S2190F	1/4	1 1/2	M.C.	13/16	3	L.C.C.H.	2 1/2	7/8	1/4	E	WEBLOY	A2, A11, K2
S1114	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	2	1 3/16	—	A	L.C.C.H.	A2, A11, A42, K2
S1670	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	2 1/4	1 3/16	—	A	L.C.C.H.	
S2180	3/8	1 3/4	M.C.	29/32	1	L.C.C.H.	2 1/4	1 1/8	—	A	L.C.C.H.	A2, A42, K2
S951	3/8	2	M.C.	29/32	1	L.C.C.H.	3	1 1/8	—	A	L.C.C.H.	A1, A2, A11, K1, K2

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

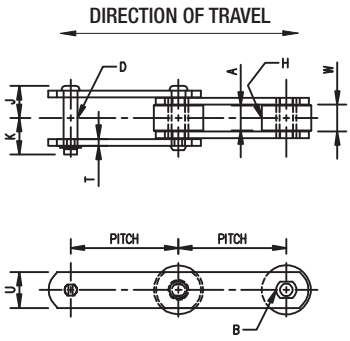
SBR Chains



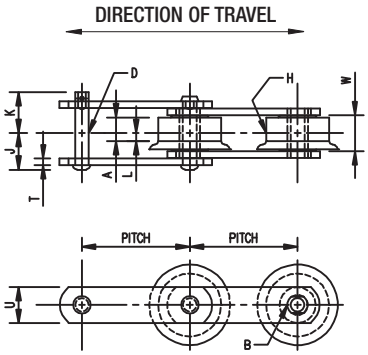
STYLE 1



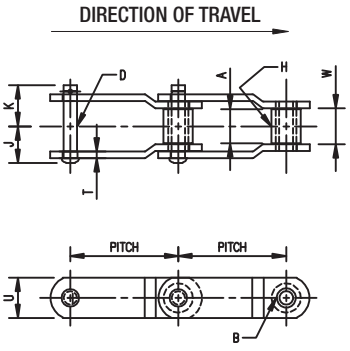
STYLE 2



STYLE 3



STYLE 4



STYLE 5

Chain Style Descriptions

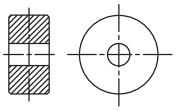
Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . . Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

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			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
S1602	2	6.000	20	8.4	32,000	4,375	1¼	1 13/16	1⅝	⅝	A	ALY.H.T.
SS556	3	6.000	20	6.7	28,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
SS556F	4	6.000	20	10.4	28,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
S1036	1	6.000	20	6.7	28,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
RS658P	3	6.000	20	10.0	30,000	4,650	1⅝	1 27/32	1 9/16	⅝	A	ALY.H.T.
RS658F	4	6.000	20	10.0	30,000	4,650	1⅝	1 27/32	1 9/16	⅝	A	ALY.H.T.
S945	3	6.000	20	10.0	28,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
RS611P	3	6.000	20	9.8	42,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
RS611F	4	6.000	20	10.8	42,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
S1141	3	6.000	20	9.5	38,000	4,800	1⅜	1 21/32	1 9/16	11/16	B	ALY.H.T.
CC5	3	6.000	20	10.5	50,000	4,800	1⅜	1 21/32	1 9/16	11/16	B	ALY.H.T.
S2847	1	6.000	20	6.7	50,000	6,620	2⅛	2 5/32	1 29/32	11/16	B	ALY.I.H.
SS6	3	6.000	20	11.0	50,000	5,575	1⅜	1 31/32	1 23/32	¾	A	ALY.H.T.
SS6SPC	3	6.000	20	12.6	50,000	5,575	1⅜	1 31/32	1 23/32	¾	A	ALY.H.T.
RS622P	3	6.000	20	15.0	50,000	7,200	2	2 9/32	2 1/32	¾	A	ALY.H.T.

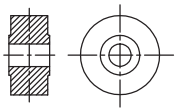
CC5 centerline of sidebar is ¼" above centerline of roller. Sidebar extends ¼" above top of roller.

SBR Chains

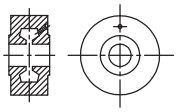
ROLLERS



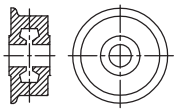
STYLE A



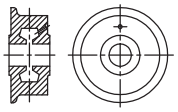
STYLE B



STYLE D

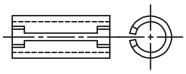


STYLE E

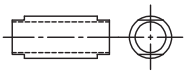


STYLE G

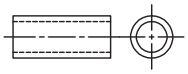
BUSHINGS



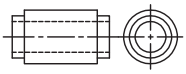
STYLE 1



STYLE 2

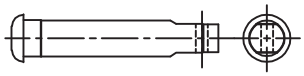


STYLE 3

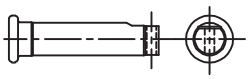


STYLE 4

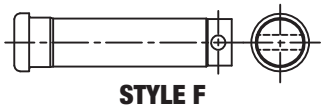
PINS



STYLE A



STYLE B



STYLE F

Abbreviations of Material and Treatment

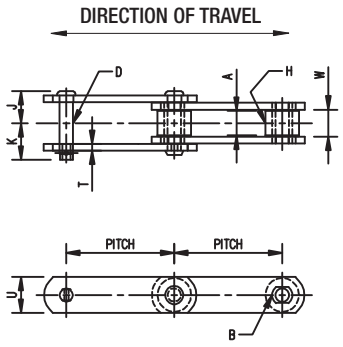
M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	Chain To Wheel Ga. L	Style	Material	
S1602	3/8	1 1/2	M.C.	29/32	1	L.C.C.H.	2 1/2	1 1/8	—	A	L.C.C.H.	
SS556	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	2	1 3/8	—	A	L.C.C.H.	
SS556F	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	3	1 1/8	7/16	E	WEBLOY	
S1036	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	1 1/4	1 3/8	—	A	L.C.C.H.	
RS658P	1/4	2	M.C.	1	2	ALY.C.H.	3	1 1/2	—	D	WEBLOY	A2, A11, G16, G29, K2
RS658F	1/4	2	M.C.	1	2	ALY.C.H.	3	1 1/8	3/8	E	WEBLOY	A2, A11, G16, G29, K2
S945	5/16	1 1/2	M.C.	7/8	3	ALY.C.H.	3	1 3/8	—	A	L.C.C.H.	
RS611P	5/16	2	M.C.	1	2	ALY.C.H.	3	1 1/4	—	B	WEBLOY	A2, A11, G16, K2
RS611F	5/16	2	M.C.	1	2	ALY.C.H.	3	1 1/8	7/16	E	WEBLOY	A2, A11, G16, K2
S1141	5/16	2	M.C.	1	3	L.C.C.H.	2 1/2	1 3/16	—	A	L.C.C.H.	
CC5	5/16	2 1/2	M.C.	1	3	L.C.C.H.	2 1/2	1 3/16	—	A	L.C.C.H.	M3
S2847	5/16	1 3/4	M.C.H.T.	1	3	L.C.C.H.	1 3/8	2	—	A	L.C.C.H.	K25
SS6	3/8	2	M.C.	1 1/8	3	ALY.C.H.	2 1/2	1 1/4	—	A	L.C.C.H.	A1, A2, A11, A42, K1, K2
SS6SPC	3/8	2	M.C.	1 1/8	3	ALY.C.H.	3	1 1/4	—	A	L.C.C.H.	A1, A2, A11, A42, K1, K2
RS622P	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/2	1 3/4	—	D	WEBLOY	

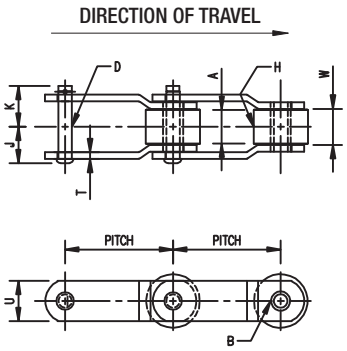
CC5 centerline of sidebar is 1/4" above centerline of roller. Sidebar extends 1/4" above top of roller.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

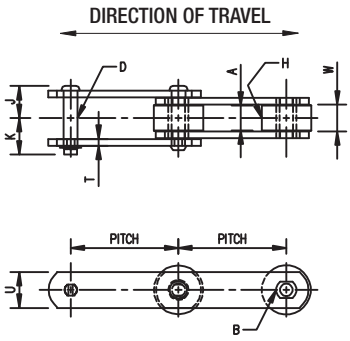
SBR Chains



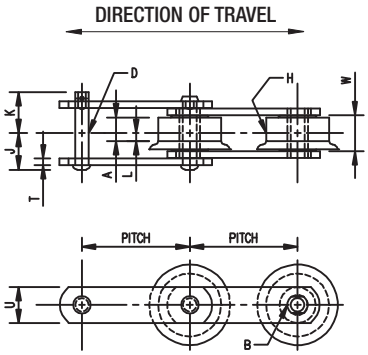
STYLE 1



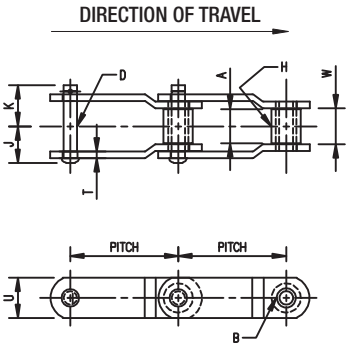
STYLE 2



STYLE 3



STYLE 4



STYLE 5

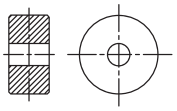
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

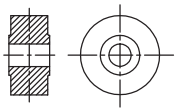
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
RS622F	4	6.000	20	16.0	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
S3600+	5	6.000	20	10.5	77,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
SS96	3	6.000	20	12.2	50,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.H.T.
SS944+	1	6.000	20	9.6	73,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.I.H.
SS1776	3	6.000	20	15.2	50,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.H.T.
SS9061	3	6.000	20	13.0	85,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.H.T.
S1131	3	6.000	20	13.5	50,000	6,230	1 5/8	2 3/32	1 27/32	3/4	A	ALY.H.T.
S2130	2	6.000	20	11.4	50,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.H.T.
S1920	3	6.000	20	11.4	73,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.I.H.
SS996	3	6.000	20	12.2	73,000	5,900	1 1/2	2 1/32	1 25/32	3/4	A	ALY.I.H.
S3940	1	6.000	20	9.7	62,600	7,220	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
SS3888	1	6.000	20	17.5	73,200	7,875	2 1/4	2 11/32	2 5/32	3/4	A	ALY.I.H.
S9833A	3	6.000	20	13.9	50,000	8,850	2 5/8	2 19/32	2 11/32	3/4	A	ALY.I.H.
S6910	3	6.000	20	18.3	82,250	9,200	2 1/4	2 15/32	2 5/32	7/8	B	ALY.H.T.
ZA2184+	2	6.000	20	12.4	85,000	6,500	1 3/8	2 3/32	1 3/4	7/8	B	ALY.I.H.

SBR Chains

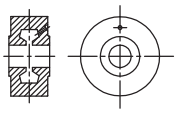
ROLLERS



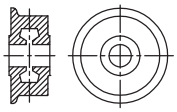
STYLE A



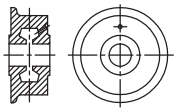
STYLE B



STYLE D

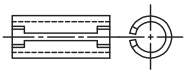


STYLE E

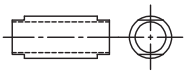


STYLE G

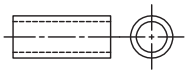
BUSHINGS



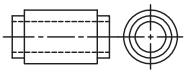
STYLE 1



STYLE 2

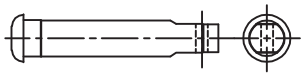


STYLE 3

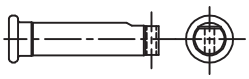


STYLE 4

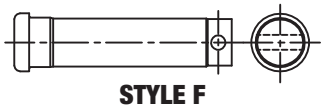
PINS



STYLE A



STYLE B



STYLE F

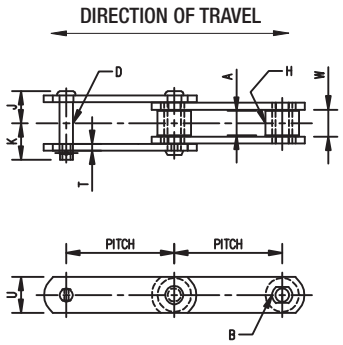
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

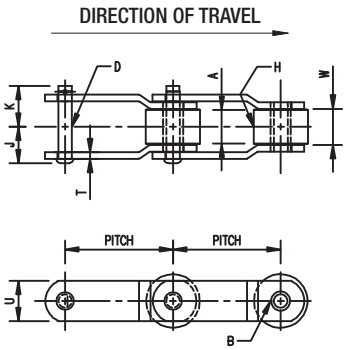
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
RS622F	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/2	1 5/16	7/16	G	WEBLOY	
S3600+	3/8	2 1/4	M.C.H.T	1 1/8	3	ALY.C.H.	1 5/8	7/8	—	A	L.C.C.H.	
SS96	3/8	2	M.C.	1 1/8	3	ALY.C.H.	2 3/4	1 3/8	—	A	L.C.C.H.	A1, A2, A42, K1, K2
SS944+	3/8	2	M.C.H.T	1 1/8	3	ALY.C.H.	1 7/8	1 3/8	—	A	L.C.C.H.	A1, K1
SS1776	3/8	2	M.C.	1 1/8	3	ALY.C.H.	3 1/2	1 5/16	—	B	L.C.C.H.	
SS9061	3/8	2 1/4	M.C.	1 1/8	3	ALY.C.H.	2 3/4	1 1/8	—	A	L.C.C.H.	A42
S1131	3/8	2	M.C.	1 1/8	3	ALY.C.H.	3	1 7/16	—	A	L.C.C.H.	A2, A42, K2
S2130	3/8	2	M.C.	1 1/8	3	ALY.C.H.	2 1/2	1 3/8	—	A	L.C.C.H.	A42
S1920	3/8	2	M.C.H.T	1 1/8	3	ALY.C.H.	2 1/2	1 3/8	—	A	L.C.C.H.	
SS996	3/8	2	M.C.H.T	1 1/8	3	ALY.C.H.	2 3/4	1 3/8	—	A	L.C.C.H.	A1, A2, A42, K1, K2
S3940	3/8	2 1/4	M.C.H.T.	1 1/8	3	ALY.C.H.	1 5/8	1 7/8	—	A	M.C.H.T.	K25
SS3888	3/8	3	M.C.H.T.	1 1/4	3	L.C.C.H.	2 1/2	2 1/8	—	A	L.C.C.H.	
S9833A	3/8	2	M.C.H.T.	1 7/16	4	L.C.C.H.	2 1/2	2 1/2	—	A	L.C.C.H.	K25
S6910	3/8	2 1/2	M.C.H.T.	1 1/4	2	ALY.C.H.	3	2 1/16	—	B	L.C.C.H.	M3
ZA2184+	3/8	2	M.C.H.T.	1 1/4	2	ALY.C.H.	3	1 1/8	—	A	L.C.C.H.	A42

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

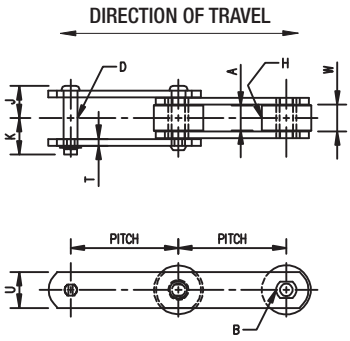
SBR Chains



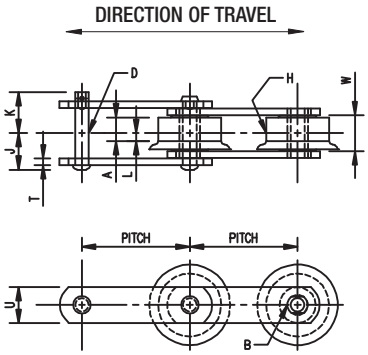
STYLE 1



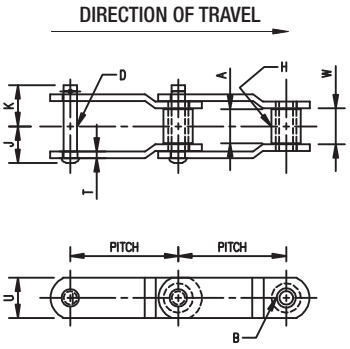
STYLE 2



STYLE 3



STYLE 4



STYLE 5

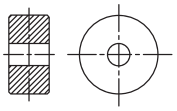
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

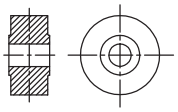
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
ZA2178A	3	6.000	20	13.4	85,000	7,080	1 9/16	2 1/16	1 13/16	7/8	B	ALY.I.H.
ZA2198	3	6.000	20	15.6	100,000	7,850	1 9/16	2 5/16	2 3/32	7/8	B	ALY.I.H.
S9063	3	6.000	20	13.6	140,000	7,380	1 1/2	2 1/32	1 25/32	15/16	B	ALY.I.H.
ZA9184	2	6.000	20	17.2	125,000	8,400	1 9/16	2 1/4	2 1/16	15/16	B	ALY.I.H.
S645	3	6.000	20	23.5	122,000	12,700	2 5/8	2 27/32	2 21/32	1	B	ALY.I.H.
S9856B	3	6.000	20	22.2	100,000	14,000	3	3	2 27/32	1	F	ALY.I.H.
SS888	1	8.000	15	1.9	14,000	2,100	1	1 7/16	1 1/16	7/16	B	ALY.I.H.
3939	1	8.000	15	1.6	24,000	2,500	1 1/16	1 1/8	1	7/16	F	ALY.C.H.
RS822P	3	8.000	15	12.8	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS822F	4	8.000	15	13.4	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS832P	3	8.000	15	14.4	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS832F	4	8.000	15	15.4	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS833P	3	8.000	15	16.8	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
RS833F	4	8.000	15	17.8	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
ZA2800	3	8.000	15	26.0	125,000	9,840	1 13/16	2 7/16	2 3/16	1	B	ALY.I.H.

SBR Chains

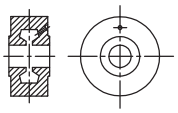
ROLLERS



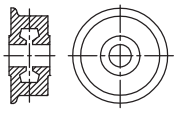
STYLE A



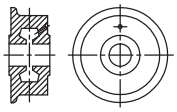
STYLE B



STYLE D

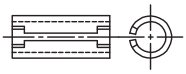


STYLE E

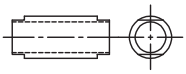


STYLE G

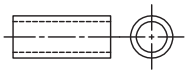
BUSHINGS



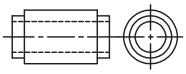
STYLE 1



STYLE 2

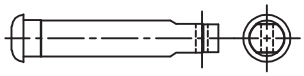


STYLE 3

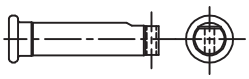


STYLE 4

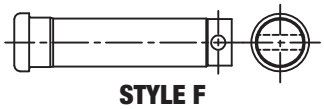
PINS



STYLE A



STYLE B



STYLE F

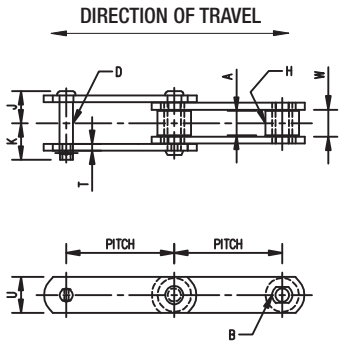
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

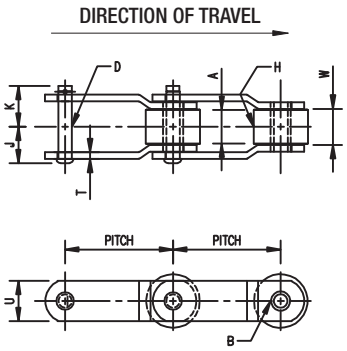
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
ZA2178A	3/8	2 1/4	M.C.H.T.	1 1/4	3	ALY.C.H.	2 3/4	1 3/16	—	B	L.C.C.H.	A2, K2
ZA2198	1/2	2 1/4	M.C.H.T.	1 1/4	3	L.C.C.H.	2 3/4	1 1/4	—	B	L.C.C.H.	A2, K2
S9063	3/8	2 1/2	ALY.H.T.	1 1/4	3	ALY.C.H.	3	1 3/16	—	B	L.C.C.H.	A2, K2
ZA9184	1/2	2 1/2	M.C.H.T.	1 1/4	3	ALY.C.H.	3	1 1/4	—	B	L.C.C.H.	A42
S645	1/2	2 1/2	M.C.H.T.	1 1/2	2	L.C.C.H.	3	2 7/16	—	A	L.C.C.H.	
S9856B	1/2	2 1/2	M.C.H.T.	1 3/4	4	ALY.C.H.	2 3/4	2 13/16	—	A	L.C.C.H.	K25, M2, M2-9
SS888	3/16	1 1/8	M.C.	5/8	3	L.C.C.H.	7/8	7/8	—	A	L.C.C.H.	JIG
3939	5/32	1 1/8	M.C.H.T.	19/32	3	L.C.C.H.	29/32	1	—	A	L.C.C.H.	JIG
RS822P	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/2	1 3/4	—	D	WEBLOY	
RS822F	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/2	1 5/16	7/16	G	WEBLOY	
RS832P	3/8	2	M.C.	1 1/8	2	ALY.C.H.	4	1 3/4	—	D	WEBLOY	
RS832F	3/8	2	M.C.	1 1/8	2	ALY.C.H.	4	1 5/16	7/16	G	WEBLOY	
RS833P	3/8	2 1/2	M.C.	1 1/4	2	ALY.C.H.	4	2	—	D	WEBLOY	
RS833F	3/8	2 1/2	M.C.	1 1/4	2	ALY.C.H.	4	1 9/16	17/32	G	WEBLOY	
ZA2800	1/2	2 3/4	M.C.H.T.	1 1/2	3	L.C.C.H.	3 1/2	1 7/16	—	A	L.C.C.H.	A2, A22, A42, K2, K22

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

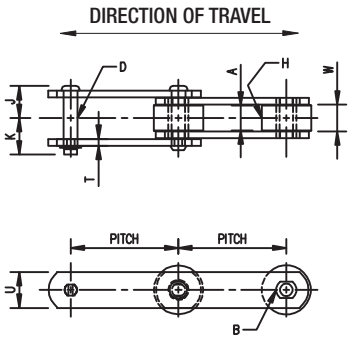
SBR Chains



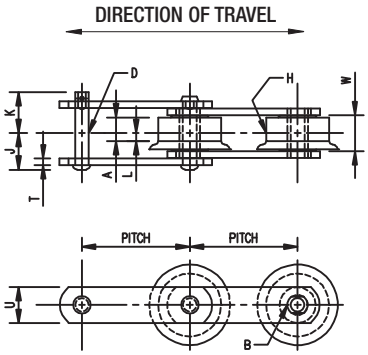
STYLE 1



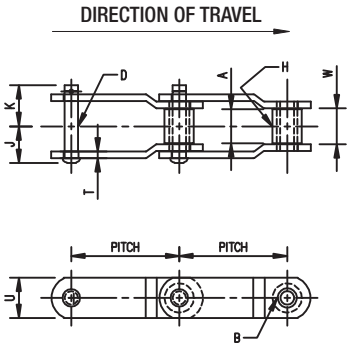
STYLE 2



STYLE 3



STYLE 4



STYLE 5

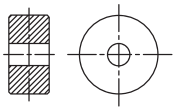
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

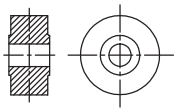
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
S1117	3	9.000	13⅓	4.4	21,000	3,500	1 5/16	1½	1⅜	9/16	B	ALY.H.T.
RS958P	3	9.000	13⅓	7.8	30,000	4,650	1⅝	1 27/32	1 9/16	⅝	A	ALY.H.T.
RS958F	4	9.000	13⅓	7.8	30,000	4,650	1⅝	1 27/32	1 9/16	⅝	A	ALY.H.T.
RS911P	3	9.000	13⅓	7.9	38,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
RS911F	4	9.000	13⅓	8.6	38,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
809	4	9.000	13⅓	13.0	33,000	6,500	2	1 15/16	1 25/32	¾	A	ALY.I.H.
RS928	5	9.000	13⅓	8.5	50,000	7,200	2	2 9/32	2 1/32	¾	A	ALY.H.T.
RS922P	3	9.000	13⅓	11.7	50,000	7,200	2	2 9/32	2 1/32	¾	A	ALY.H.T.
RS922F	4	9.000	13⅓	12.3	50,000	7,200	2	2 9/32	2 1/32	¾	A	ALY.H.T.
RS932P	3	9.000	13⅓	13.3	50,000	7,200	2	2 9/32	2 1/32	¾	A	ALY.H.T.
RS932F	4	9.000	13⅓	14.3	50,000	7,200	2	2 9/32	2 1/32	¾	A	ALY.H.T.
S2342	5	9.000	13⅓	9.2	65,000	9,000	1 15/16	2½	2¼	⅞	A	ALY.I.H.
RS933P	3	9.000	13⅓	15.6	56,000	9,200	2¼	2 15/32	2 3/16	⅞	A	ALY.H.T.
RS933F	4	9.000	13⅓	16.5	56,000	9,200	2¼	2 15/32	2 3/16	⅞	A	ALY.H.T.
RS938	5	9.000	13⅓	10.4	56,000	9,200	2¼	2 15/32	2 3/16	⅞	A	ALY.H.T.
RS933½P	3	9.000	13⅓	14.1	56,000	9,200	2¼	2 15/32	2 3/16	⅞	A	ALY.H.T.

SBR Chains

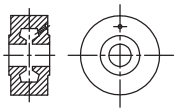
ROLLERS



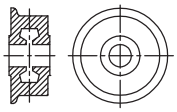
STYLE A



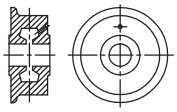
STYLE B



STYLE D

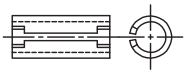


STYLE E

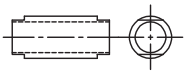


STYLE G

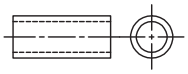
BUSHINGS



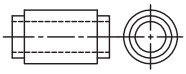
STYLE 1



STYLE 2

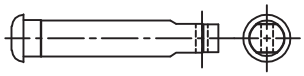


STYLE 3

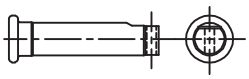


STYLE 4

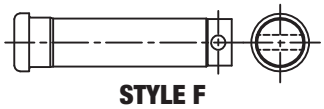
PINS



STYLE A



STYLE B



STYLE F

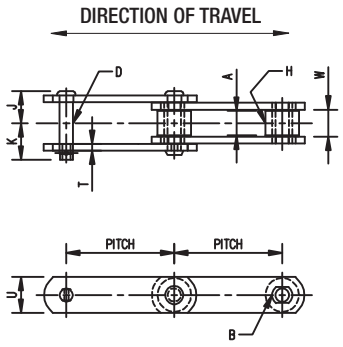
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

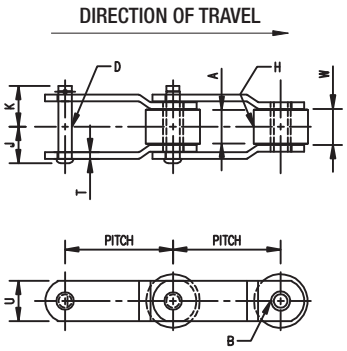
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	Chain To Wheel Ga. L	Style	Material	
S1117	¼	1½	M.C.H.T.	13/16	3	L.C.C.H.	2	1 3/16	—	A	L.C.C.H.	
RS958P	¼	2	M.C.	1	2	ALY.C.H.	3	1½	—	D	WEBLOY	A2, G16, K2
RS958F	¼	2	M.C.	1	2	L.C.C.H.	3	1⅛	⅜	E	WEBLOY	A2, G16, K2
RS911P	5/16	2	M.C.	1	2	L.C.C.H.	3	1¼	—	B	WEBLOY	A2, G16, K2
RS911F	5/16	2½	M.C.	1	2	L.C.C.H.	3	1⅛	7/16	E	WEBLOY	A2, G16, K2
809	¼	2	M.C.	1⅛	2	ALY.C.H.	3½	1 5/16	7/16	G	WEBLOY	
RS928	⅜	2	M.C.	1⅛	2	ALY.C.H.	1⅞	1⅞	—	A	L.C.C.H.	M14
RS922P	⅜	2	M.C.	1⅛	2	L.C.C.H.	3½	1¾	—	D	WEBLOY	A2, G16, K2
RS922F	⅜	2	M.C.	1⅛	2	L.C.C.H.	3½	1 5/16	7/16	G	WEBLOY	A2, G16, K2
RS932P	⅜	2	M.C.	1⅛	2	L.C.C.H.	4	1¾	—	D	WEBLOY	A2, G16, K2
RS932F	⅜	2	M.C.	1⅛	2	L.C.C.H.	4	1 5/16	7/16	G	WEBLOY	A2, G16, K2
S2342	½	2½	M.C.	1¼	2	ALY.C.H.	1¾	1 13/16	—	A	L.C.C.H.	M14
RS933P	⅜	2½	M.C.	1¼	2	L.C.C.H.	4	2	—	D	WEBLOY	A2, G5, G16, K2
RS933F	⅜	2½	M.C.	1¼	2	L.C.C.H.	4	1 9/16	17/32	G	WEBLOY	A2, G5, G16, K2
RS938	⅜	2½	M.C.	1¼	2	ALY.C.H.	1⅞	2⅛	—	A	L.C.C.H.	M14
RS933½P	⅜	2	M.C.	1¼	2	L.C.C.H.	3	2 1/16	—	B	L.C.C.H.	G5, G16

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

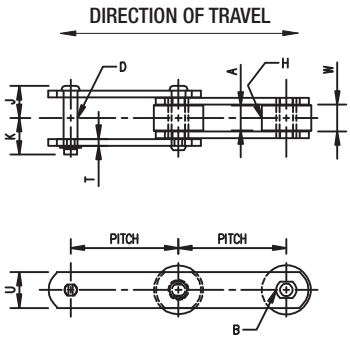
SBR Chains



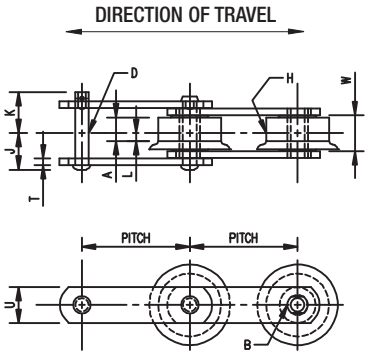
STYLE 1



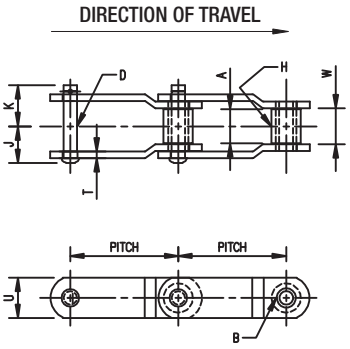
STYLE 2



STYLE 3



STYLE 4



STYLE 5

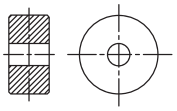
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . . Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

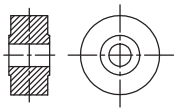
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
S4009	3	9.000	13⅓	14.7	81,200	9,200	2¼	2 15/32	2 3/16	⅞	A	ALY.I.H.
RS944P	3	9.000	13⅓	24.5	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS944F	4	9.000	13⅓	25.9	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS944½P	3	9.000	13⅓	18.5	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS946	5	9.000	13⅓	15.0	85,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.I.H.
S4004	3	9.000	13⅓	18.5	85,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.I.H.
RS955P	3	9.000	13⅓	38.8	130,000	17,500	2¾	3 9/32	2 21/32	1¼	A	ALY.H.T.
RS955F	4	9.000	13⅓	40.1	130,000	17,500	2¾	3 9/32	2 21/32	1¼	A	ALY.H.T.
S4065A	3	9.000	13⅓	38.0	150,000	18,900	3 1/16	3 7/16	3⅛	1¼	A	ALY.I.H.
S1209A	3	9.000	13⅓	40.0	183,000	25,000	3½	3 21/32	3 11/32	1½	B	ALY.I.H.
S1118	3	12.000	10	5.1	21,000	3,500	1 5/16	1½	1⅜	9/16	B	ALY.H.T.
RS1258P	3	12.000	10	6.8	30,000	4,650	1⅝	1 27/32	1 9/16	⅝	A	ALY.H.T.
RS1258F	4	12.000	10	6.8	30,000	4,650	1⅝	1 27/32	1 9/16	⅝	A	ALY.H.T.
RS1211P	3	12.000	10	7.0	38,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.
RS1211F	4	12.000	10	7.9	38,000	4,650	1½	1 25/32	1⅝	⅝	A	ALY.H.T.

SBR Chains

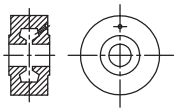
ROLLERS



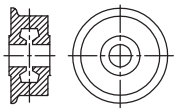
STYLE A



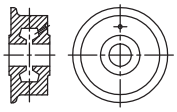
STYLE B



STYLE D

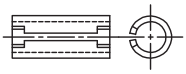


STYLE E

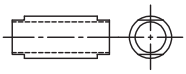


STYLE G

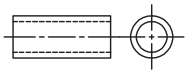
BUSHINGS



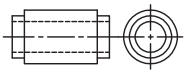
STYLE 1



STYLE 2

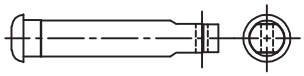


STYLE 3

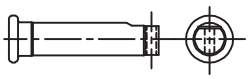


STYLE 4

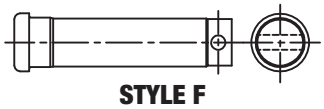
PINS



STYLE A



STYLE B



STYLE F

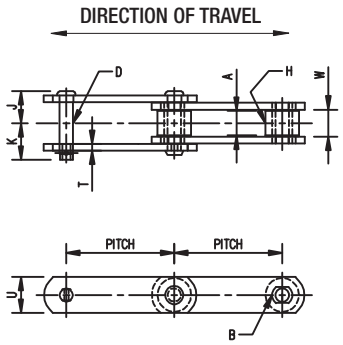
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

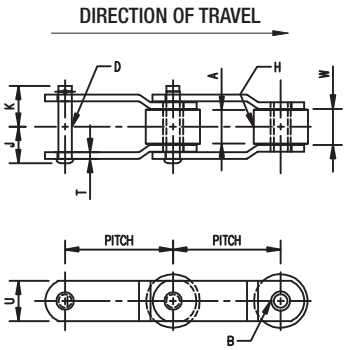
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	Chain To Wheel Ga. L	Style	Material	
S4009	3/8	2 1/2	M.C.H.T.	1 1/4	2	ALY.C.H.	3	2 1/16	—	A	L.C.C.H.	G5
RS944P	1/2	2 1/2	M.C.	1 3/8	2	L.C.C.H.	5	2	—	D	WEBLOY	
RS944F	1/2	2 1/2	M.C.	1 3/8	2	L.C.C.H.	5	1 3/4	19/32	G	WEBLOY	
RS944 1/2P	1/2	2 1/2	M.C.	1 3/8	2	L.C.C.H.	3	2 7/16	—	B	L.C.C.H.	
RS946	1/2	2 1/2	M.C.	1 1/2	2	L.C.C.H.	2 1/4	2 7/16	—	A	L.C.C.H.	M14
S4004	1/2	2 1/2	M.C.	1 1/2	2	L.C.C.H.	3	2 7/16	—	B	L.C.C.H.	G5
RS955P	5/8	3	M.C.	1 3/4	2	ALY.C.H.	6	2 1/2	—	D	WEBLOY	
RS955F	5/8	3	M.C.	1 3/4	2	ALY.C.H.	6	1 9/16	15/32	G	WEBLOY	
S4065A	5/8	3 1/2	M.C.	2	4	ALY.C.H.	4 1/4	2 15/16	—	A	L.C.C.H.	G5
S1209A	5/8	3 1/2	M.C.H.T.	2 3/8	4	ALY.C.H.	4 1/4	3 3/8	—	A	L.C.C.H.	G5
S1118	1/4	1 1/2	M.C.	13/16	3	L.C.C.H.	2	1 3/16	—	A	L.C.C.H.	
RS1258P	1/4	2	M.C.	1	2	ALY.C.H.	3	1 1/2	—	D	WEBLOY	
RS1258F	1/4	2	M.C.	1	2	ALY.C.H.	3	1 1/8	3/8	E	WEBLOY	
RS1211P	5/16	2	M.C.	1	2	ALY.C.H.	3	1 1/4	—	B	WEBLOY	G16
RS1211F	5/16	2	M.C.	1	2	ALY.C.H.	3	1 1/8	7/16	E	WEBLOY	G16

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

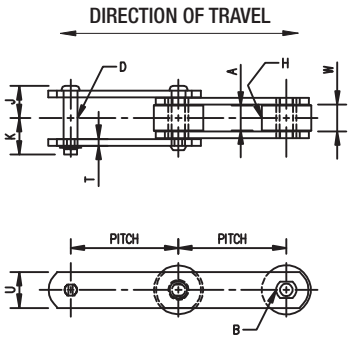
SBR Chains



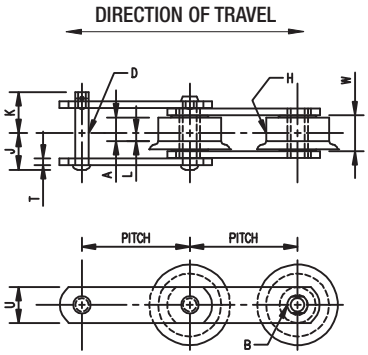
STYLE 1



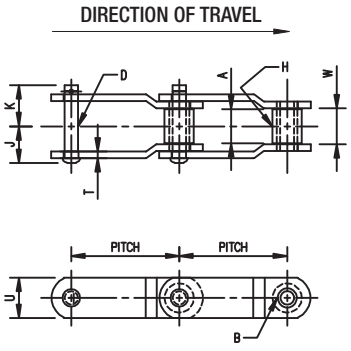
STYLE 2



STYLE 3



STYLE 4



STYLE 5

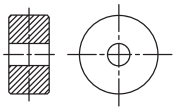
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

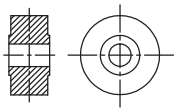
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
RS1221P	3	12.000	10	9.5	50,000	6,230	1 5/8	2 3/32	1 27/32	3/4	A	ALY.H.T.
RS1221½P	3	12.000	10	11.0	50,000	6,230	1 5/8	2 3/32	1 27/32	3/4	A	ALY.H.T.
RS1222P	3	12.000	10	10.0	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1222F	4	12.000	10	10.5	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1228	5	12.000	10	7.6	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1232P	3	12.000	10	11.2	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1232F	4	12.000	10	12.0	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
S1270	4	12.000	10	14.2	46,000	7,665	2 1/4	2 11/32	2 1/32	7/8	A	ALY.H.T.
RS1233P	3	12.000	10	13.3	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
RS1233F	4	12.000	10	14.0	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
RS1238	5	12.000	10	9.4	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
RS1233½P	3	12.000	10	12.2	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
RS1244P	3	12.000	10	20.5	90,000	12,700	2 5/8	2 27/32	2 21/32	1	F	ALY.H.T.
RS1244F	4	12.000	10	21.5	90,000	12,700	2 5/8	2 27/32	2 21/32	1	F	ALY.H.T.
RS1244½P	3	12.000	10	16.0	90,000	12,700	2 5/8	2 27/32	2 21/32	1	F	ALY.H.T.

SBR Chains

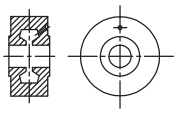
ROLLERS



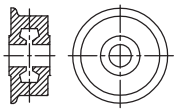
STYLE A



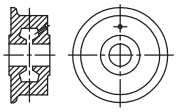
STYLE B



STYLE D

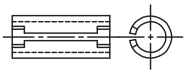


STYLE E

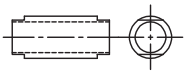


STYLE G

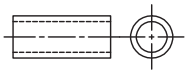
BUSHINGS



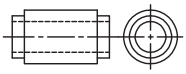
STYLE 1



STYLE 2

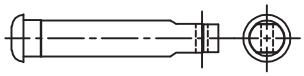


STYLE 3

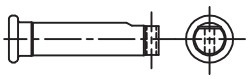


STYLE 4

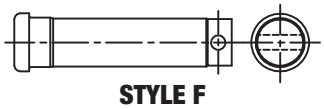
PINS



STYLE A



STYLE B



STYLE F

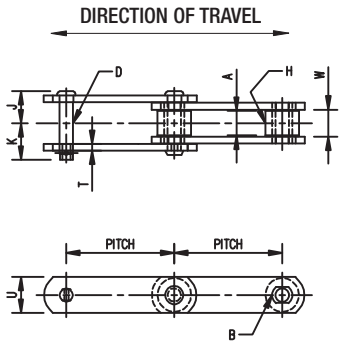
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

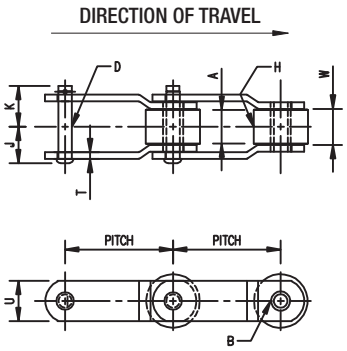
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	℄ Chain To Wheel Ga. L	Style	Material	
RS1221P	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/4	1 1/2	—	D	WEBLOY	G16
RS1221½P	3/8	2 1/2	M.C.	1 1/8	2	ALY.C.H.	3 1/4	1 1/2	—	D	WEBLOY	G16
RS1222P	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/2	1 3/4	—	D	WEBLOY	A2, G16, G16A, K2, K3
RS1222F	3/8	2	M.C.	1 1/8	2	ALY.C.H.	3 1/2	1 5/16	7/16	G	WEBLOY	A2, G16, G16A, K2, K3
RS1228	3/8	2	M.C.	1 1/8	2	ALY.C.H.	1 7/8	1 7/8	—	A	L.C.C.H.	M14
RS1232P	3/8	2	M.C.	1 1/8	2	ALY.C.H.	4	1 3/4	—	D	WEBLOY	A2, G16, G16A, K2, K3
RS1232F	3/8	2	M.C.	1 1/8	2	ALY.C.H.	4	1 5/16	7/16	G	WEBLOY	A2, G16, G16A, K2, K3
S1270	5/16	2 1/2	M.C.	1 1/4	2	ALY.C.H.	4	1 9/16	17/32	G	WEBLOY	
RS1233P	3/8	2 1/2	M.C.	1 1/4	2	ALY.C.H.	4	2	—	D	WEBLOY	A2, G16, G16A, K2, K3
RS1233F	3/8	2 1/2	M.C.	1 1/4	2	ALY.C.H.	4	1 9/16	17/32	G	WEBLOY	A2, G16, G16A, K2, K3
RS1238	3/8	2 1/2	M.C.	1 1/4	2	ALY.C.H.	1 7/8	2 1/8	—	A	L.C.C.H.	M14
RS1233½P	3/8	2 1/2	M.C.	1 1/4	2	ALY.C.H.	3	2 1/16	—	B	L.C.C.H.	G16, G16A
RS1244P	1/2	2 1/2	M.C.	1 3/8	2	L.C.C.H.	5	2	—	D	WEBLOY	A2, G16, G16A, K2, K3
RS1244F	1/2	2 1/2	M.C.	1 3/8	2	L.C.C.H.	5	1 3/4	19/32	G	WEBLOY	A2, G16, G16A, K2, K3
RS1244½P	1/2	2 1/2	M.C.	1 3/8	2	L.C.C.H.	3	2 1/2	—	B	L.C.C.H.	G16, G16A

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

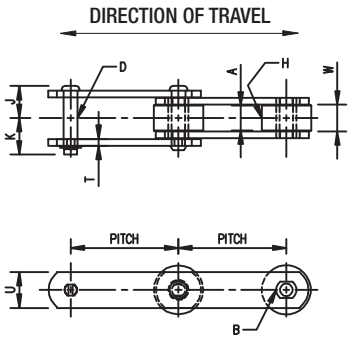
SBR Chains



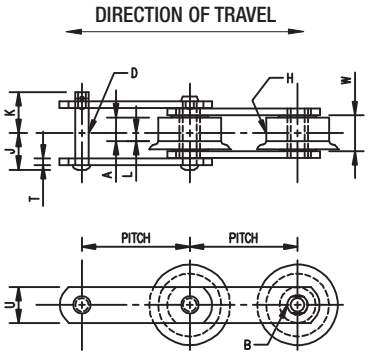
STYLE 1



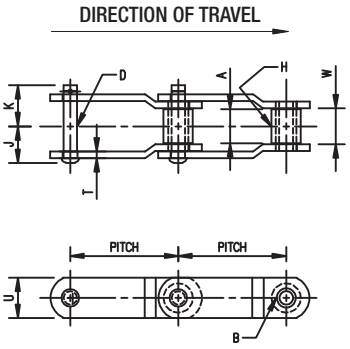
STYLE 2



STYLE 3



STYLE 4



STYLE 5

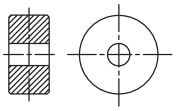
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

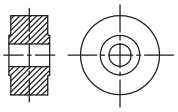
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
RS1246	5	12.000	10	13.3	125,000	12,700	2 5/8	2 27/32	2 21/32	1	F	ALY.I.H.
S1245	3	12.000	10	16.0	125,000	12,700	2 5/8	2 27/32	2 21/32	1	F	ALY.I.H.
1706	5	12.000	10	13.7	120,000	14,000	3	3	2 27/32	1	F	ALY.I.H.
RS1255P	3	12.000	10	32.3	130,000	17,500	2 3/4	3 9/32	2 31/32	1 1/4	A	ALY.H.T.
RS1255F	4	12.000	10	33.3	130,000	17,500	2 3/4	3 9/32	2 31/32	1 1/4	A	ALY.H.T.
S2614	5	12.000	10	24.0	162,000	17,500	2 3/4	3 9/32	2 31/32	1 1/4	A	ALY.I.H.
S2648	5	12.000	10	33.0	200,000	29,600	4	3 29/32	3 19/32	1 5/8	F	ALY.I.H.
RS1422P	3	14.000	8 1/2	9.3	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
RS1422F	4	14.000	8 1/2	9.7	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.I.H.
RS1822P	3	18.000	6 2/3	8.3	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1822F	4	18.000	6 2/3	8.7	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1832P	3	18.000	6 2/3	9.1	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1832F	4	18.000	6 2/3	9.7	50,000	7,200	2	2 9/32	2 1/32	3/4	A	ALY.H.T.
RS1833P	3	18.000	6 2/3	11.0	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.
RS1833F	4	18.000	6 2/3	11.5	56,000	9,200	2 1/4	2 15/32	2 3/16	7/8	A	ALY.H.T.

SBR Chains

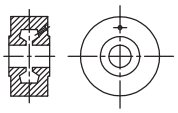
ROLLERS



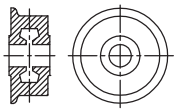
STYLE A



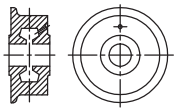
STYLE B



STYLE D

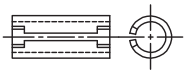


STYLE E

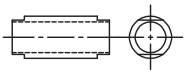


STYLE G

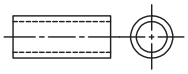
BUSHINGS



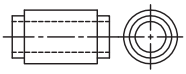
STYLE 1



STYLE 2

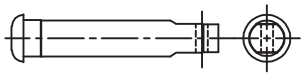


STYLE 3

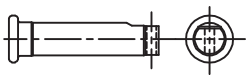


STYLE 4

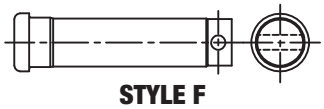
PINS



STYLE A



STYLE B



STYLE F

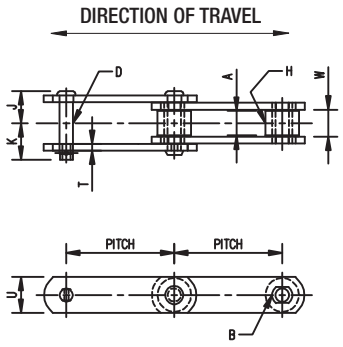
Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

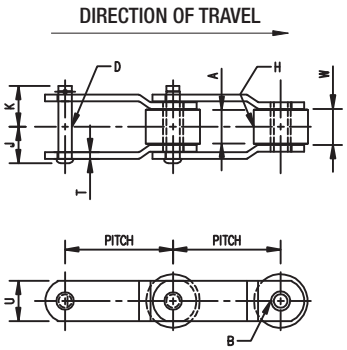
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	Chain To Wheel Ga. L	Style	Material	
RS1246	½	2½	M.C.H.T.	1½	2	L.C.C.H.	2¼	2⁷⁄₁₆	—	A	L.C.C.H.	M14
S1245	½	2½	M.C.H.T.	1½	2	L.C.C.H.	3	2⁷⁄₁₆	—	B	L.C.C.H.	G5, G16A
1706	½	2½	M.C.H.T.	1¾	4	ALY.C.H.	2¼	2⅞	—	A	M.C.H.T.	M14
RS1255P	⅝	3	M.C.	1¾	2	ALY.C.H.	6	2½	—	D	WEBLOY	
RS1255F	⅝	3	M.C.	1¾	2	ALY.C.H.	6	1⁹⁄₁₆	¹⁵⁄₃₂	G	WEBLOY	
S2614	⅝	3½	M.C.H.T.	1¾	2	ALY.C.H.	2½	2⅝	—	A	L.C.C.H.	M14
S2648	⅝	4	M.C.H.T.	2½	3	ALY.C.H.	3½	3⅞	—	A	ALY.H.T.	M14
RS1422P	⅜	2	M.C.	1⅛	2	ALY.C.H.	3½	1¾	—	D	WEBLOY	
RS1422F	⅜	2	M.C.	1⅛	2	ALY.C.H.	3½	1⁵⁄₁₆	7⁄16	G	WEBLOY	
RS1822P	⅜	2	M.C.	1⅛	2	ALY.C.H.	3½	1¾	—	D	WEBLOY	G16, G16A, K3
RS1822F	⅜	2	M.C.	1⅛	2	ALY.C.H.	3½	1⁵⁄₁₆	7⁄16	G	WEBLOY	G16, G16A, K3
RS1832P	⅜	2	M.C.	1⅛	2	ALY.C.H.	4	1¾	—	D	WEBLOY	G16, G16A, K3
RS1832F	⅜	2	M.C.	1⅛	2	ALY.C.H.	4	1⁵⁄₁₆	7⁄16	G	WEBLOY	G16, G16A, K3
RS1833P	⅜	2½	M.C.	1¼	2	ALY.C.H.	4	2	—	D	WEBLOY	G16, G16A, K3
RS1833F	⅜	2½	M.C.	1¼	2	ALY.C.H.	4	1⁹⁄₁₆	¹⁷⁄₃₂	G	WEBLOY	G16, G16A, K3

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

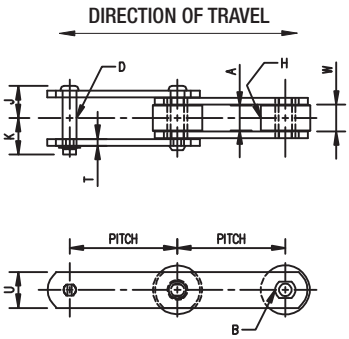
SBR Chains



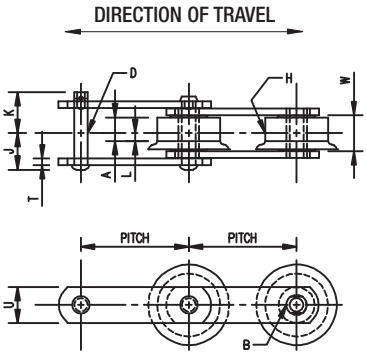
STYLE 1



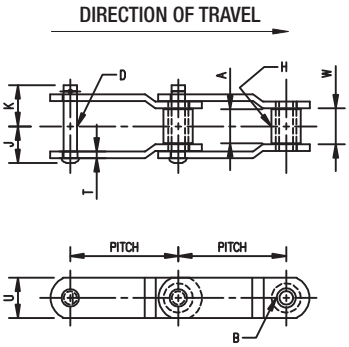
STYLE 2



STYLE 3



STYLE 4



STYLE 5

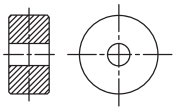
Chain Style Descriptions

Style 1 . . . . Straight Sidebar, Small Roller
Style 2 . . . . . Offset Sidebar, Large Roller
Style 3 . . . . Straight Sidebar, Large Roller
Style 4 . . .Straight Sidebar, Flanged Roller
Style 5 . . . . . Offset Sidebar, Small Roller

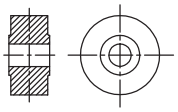
Chain No.	Chain Style	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins		
							Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Material
							W	K	J	D		
RS1844P	3	18.000	6⅔	16.5	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS1844F	4	18.000	6⅔	17.2	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS1855P	3	18.000	6⅔	25.8	130,000	17,500	2¾	3 9/32	2 31/32	1¼	A	ALY.H.T.
RS1855F	4	18.000	6⅔	26.5	130,000	17,500	2¾	3 9/32	2 31/32	1¼	A	ALY.H.T.
RS1866F	4	18.000	6⅔	31.5	150,000	22,300	3	3 13/32	3 5/32	1½	A	ALY.H.T.
RS2444P	3	24.000	5	14.5	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS2444F	4	24.000	5	15.0	90,000	12,700	2⅝	2 27/32	2 21/32	1	F	ALY.H.T.
RS2455P	3	24.000	5	22.6	130,000	17,500	2¾	3 9/32	2 31/32	1¼	A	ALY.H.T.
RS2455F	4	24.000	5	23.1	130,000	17,500	2¾	3 9/32	2 21/32	1¼	A	ALY.H.T.
RS2466F	4	24.000	5	27.5	150,000	22,300	3	3 13/32	3 5/32	1½	A	ALY.H.T.

SBR Chains

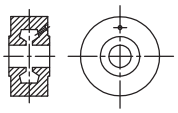
ROLLERS



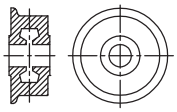
STYLE A



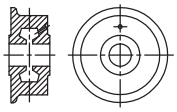
STYLE B



STYLE D

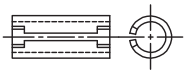


STYLE E

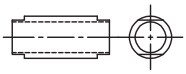


STYLE G

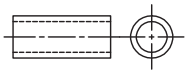
BUSHINGS



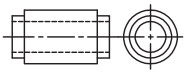
STYLE 1



STYLE 2

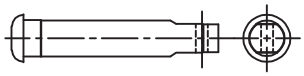


STYLE 3

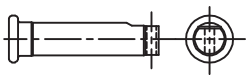


STYLE 4

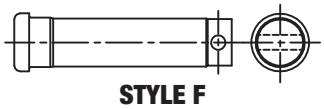
PINS



STYLE A



STYLE B



STYLE F

Abbreviations of Material and Treatment

M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated
M.C.I.H. . . . . Medium Carbon, Induction Hardened
ALY.I.H. . . . . Alloy Steel, Induction Hardened
L.C.C.H. . . . . Low Carbon, Case Hardened
ALY.C.H. . . . . Alloy Steel, Case Hardened
WEBLOY. . . . . White Iron

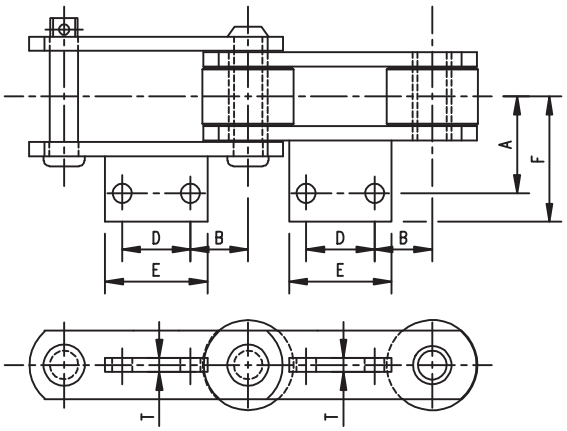
Chain No.	Sidebars			Bushings			Rollers					Common Attachment Numbers
	Thk. T	Height U	Material	Outside Dia. B	Style	Material	Tread Dia. H	Tread Width A	Chain To Wheel Ga. L	Style	Material	
RS1844P	½	2½	M.C.	1⅜	2	L.C.C.H.	5	2	—	D	WEBLOY	G16, G16A, K3
RS1844F	½	2½	M.C.	1⅜	2	L.C.C.H.	5	1¾	19/32	G	WEBLOY	G16, G16A, K3
RS1855P	⅝	3	M.C.	1¾	2	L.C.C.H.	6	2½	—	D	WEBLOY	G16, K3
RS1855F	⅝	3	M.C.	1¾	2	L.C.C.H.	6	1 9/16	15/32	G	WEBLOY	G16, K3
RS1866F	⅝	3½	M.C.	2	2	L.C.C.H.	6	1⅞	19/32	G	WEBLOY	G16, K3
RS2444P	½	2½	M.C.	1⅜	2	L.C.C.H.	5	2	—	D	WEBLOY	G16, K3
RS2444F	½	2½	M.C.	1⅜	2	L.C.C.H.	5	1¾	19/32	G	WEBLOY	G16, K3
RS2455P	⅝	3	M.C.	1¾	2	L.C.C.H.	6	2½	—	D	WEBLOY	G16, K3
RS2455F	⅝	3	M.C.	1¾	2	L.C.C.H.	6	1 9/16	15/32	G	WEBLOY	G16, K3
RS2466F	⅝	3½	M.C.	2	2	L.C.C.H.	6	1⅞	19/32	G	WEBLOY	G16, K3

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common SBR Chain Attachments

A11→→

Chain No.	A	B	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
S1183	1⅝	1	1	1¾	1 15/16	3/16	4.4	5/16
S1184	1⅝	1	1	1¾	2	3/16	4.4	5/16
S1120	2⅛	1⅜	1¼	2	2 19/32	3/16	4.1	5/16
S1121	2⅛	1⅜	1¼	2	2 21/32	3/16	4.1	5/16
S1195	2⅛	1⅜	1¼	2	2 21/32	3/16	5.4	⅜
S4002	1⅝	1¼	1½	2¼	2 3/16	¼	4.6	⅜
S1113	2⅛	1 17/64	1½	2¼	2¾	5/16	8.8	⅜
S2190	2 9/16	1⅞	2¼	3¼	2 15/16	⅜	7.9	¼
S2190F	2 9/16	1⅞	2¼	3¼	2 15/16	⅜	7.9	¼
S1199	2½	1¾	2½	4	3	¼	4.7	⅜
RS658P	2 5/16	2⅛	1¾	3	3⅛	¼	10.8	⅜
RS658F	2 5/16	2⅛	1¾	3	3⅛	¼	10.8	⅜
S1114	2¾	1 9/16	2⅞	4	3 11/32	5/16	8.8	½
RS611P	2 5/16	2⅛	1¾	3	3 1/16	5/16	11.7	⅜
RS611F	2 5/16	2⅛	1¾	3	3 1/16	5/16	11.7	⅜
S951	2 3/16	1⅞	2¼	3¼	2 25/32	¼	12.6	⅜
SS6	2¾	1 9/16	2⅞	4	3½	⅜	12.8	½
SS6SPC	2¾	1 9/16	2⅞	4	3½	⅜	14.4	½



A11

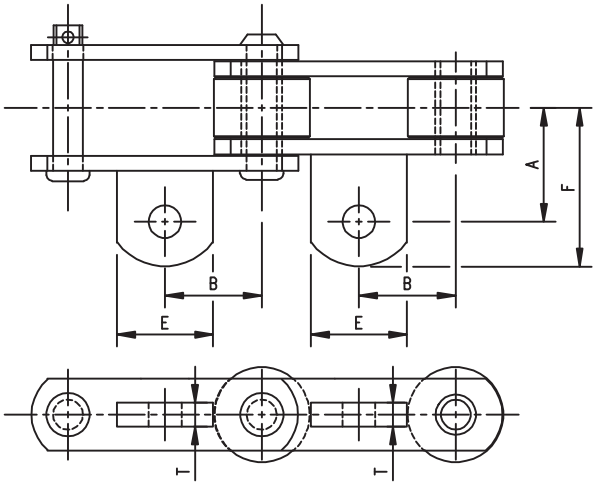
Common SBR Chain Attachments

A22→→

Chain No.	A	B	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
S4002	1 25/32	2	1 1/8	2 13/32	3/8	5.2	3/8
S1113	2 3/8	2 1/64	2	3 5/16	1/2	9.7	5/8
ZA2800	2 27/32	4	2	3 7/8	5/8	27.2	5/8

A42→→

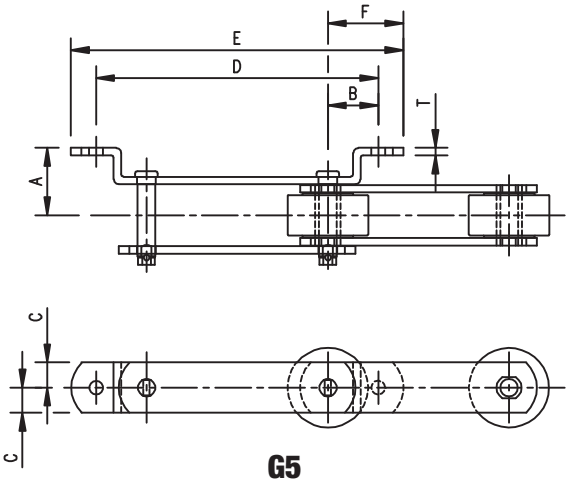
S1500	1 9/16	3/4	7/8	2	3/8	4.4	3/8
S1183	1 9/16	1 1/2	1 1/4	2 3/32	1/4	4.4	3/8
S1184	1 9/16	1 1/2	1 1/4	2 5/32	1/4	4.4	3/8
S1112	2 7/16	1 27/32	1 3/4	3 1/8	1/2	7.4	5/8
S1120	1 5/8	2	1 1/4	1 15/16	3/8	3.9	3/8
S1121	1 5/8	2	1 1/4	2	3/8	3.9	3/8
S4002	2	2	1 1/2	2 7/8	1/2	5.2	5/8
S531	2 3/8	2	1 1/2	3 1/8	3/8	10.1	1/2
S1596	1 7/8	2 1/2	1 3/8	2 5/8	3/8	6.1	1/2
S1197	2	3	2	2 13/16	3/8	4.4	5/8
S1116	2 11/32	3	2	3 5/32	1/2	6.8	5/8
S2190	2 5/32	3	2	2 25/32	1/2	7.6	3/8
S1604	2	3	2	2 3/4	1/2	8.0	5/8
S1114	2 11/32	3	2	3 5/32	1/2	7.4	5/8
S2180	2 11/16	3	1 1/2	3 3/8	1/2	9.2	5/8
SS6	2 9/16	3	2	3 3/8	5/8	12.5	5/8
SS6SPC	2 9/16	3	2	3 3/8	5/8	14.1	5/8
SS96	2 27/32	3	1 1/2	3 19/32	3/8	13.0	5/8
SS9061	3 5/8	3	2	3 9/16	5/8	14.6	5/8
S1131	2 19/32	3	2	3 19/32	5/8	14.8	5/8
S2130	2 9/16	2 7/8	2	3 5/8	5/8	12.8	5/8
SS996	2 27/32	3	1 1/2	3 19/32	3/8	13.0	5/8
ZA2184+	2 5/8	3	2	3 11/16	5/8	13.8	5/8
ZA9184	3	3 3/4	2	4 1/32	5/8	18.6	5/8
ZA2800	3 5/8	4	2	3 21/32	5/8	27.2	5/8



A22 and A42

G5→→

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
RS933P	3 11/32	2 1/2	1 1/4	14	16 1/2	3 3/4	3/8	17.7	5/8
RS933F	3 11/32	2 1/2	1 1/4	14	16 1/2	3 3/4	3/8	17.7	5/8
RS933 1/2P	3 11/32	2 1/2	1 1/4	14	16 1/2	3 3/4	3/8	15.3	5/8
S4009	3 11/32	2 1/2	1 1/4	14	16 1/2	3 3/4	3/8	15.3	5/8
S4004	3 11/32	2 1/2	1 1/4	14	16 1/2	3 3/4	1/2	19.7	5/8
S1209A	4 5/32	2 3/4	1 3/4	14 1/2	17	4	5/8	42.0	5/8
S4065A	3 15/16	2 1/2	1 3/4	14	16 1/2	3 3/4	5/8	40.0	5/8
S1245	3 11/32	2 1/2	1 1/4	17	19 1/2	3 3/4	1/2	17.8	5/8



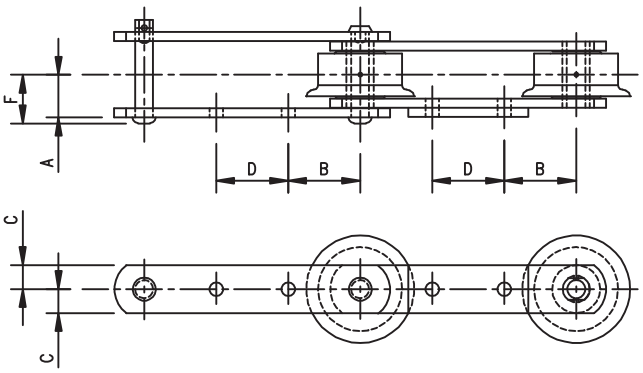
G5

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common SBR Chain Attachments

G16→→

Chain No.	A	B	C	D	F	Weight Per Foot-Lbs. Δ	Bolt Size
RS658P	1 11/32	2 1/4	1	1 1/2	1 17/32	10.5	3/8
RS658F	1 11/32	2 1/4	1	1 1/2	1 17/32	10.5	3/8
RS611P	1 13/32	2 1/4	1	1 1/2	1 19/32	11.4	3/8
RS611F	1 13/32	2 1/4	1	1 1/2	1 19/32	11.4	3/8
RS958P	1 11/32	3 1/8	1	2 3/4	1 17/32	8.3	1/2
RS958F	1 11/32	3 1/8	1	2 3/4	1 17/32	8.3	1/2
RS911P	1 13/32	3 1/8	1	2 3/4	1 19/32	9.2	1/2
RS911F	1 13/32	3 1/8	1	2 3/4	1 19/32	9.2	1/2
RS922P	1 25/32	3	1	3	2 1/32	13.0	1/2
RS922F	1 25/32	3	1	3	2 1/32	13.0	1/2
RS932P	1 25/32	3	1	3	2 1/32	15.0	1/2
RS932F	1 25/32	3	1	3	2 1/32	15.0	1/2
RS933P	1 29/32	3 1/4	1 1/4	2 1/2	2 5/32	17.4	1/2
RS933F	1 29/32	3 1/4	1 1/4	2 1/2	2 5/32	17.4	1/2
RS933 1/2P	1 29/32	3 1/4	1 1/4	2 1/2	2 5/32	15.0	1/2
RS1211P	1 13/32	4 1/8	1	3 3/4	1 19/32	8.1	1/2
RS1211F	1 13/32	4 1/8	1	3 3/4	1 19/32	8.1	1/2
RS1221P	1 19/32	4 1/8	1	3 3/4	1 27/32	10.1	1/2
RS1221 1/2P	1 19/32	4 1/8	1 1/4	3 3/4	1 27/32	11.8	1/2
RS1222P	1 25/32	4 1/8	1	3 3/4	2 1/32	11.3	1/2
RS1222F	1 25/32	4 1/8	1	3 3/4	2 1/32	11.3	1/2
RS1232P	1 25/32	4 1/8	1	3 3/4	2 1/32	12.8	1/2
RS1232F	1 25/32	4 1/8	1	3 3/4	2 1/32	12.8	1/2
RS1233P	1 29/32	4 1/8	1 1/4	3 3/4	2 5/32	14.8	1/2
RS1233F	1 29/32	4 1/8	1 1/4	3 3/4	2 5/32	14.8	1/2
RS1233 1/2P	1 29/32	4 1/8	1 1/4	3 3/4	2 5/32	13.0	1/2
RS1244P	2 11/32	4 1/8	1 1/4	3 3/4	2 19/32	22.6	5/8
RS1244F	2 11/32	4 1/8	1 1/4	3 3/4	2 19/32	22.6	5/8
RS1244 1/2P	2 11/32	4 1/8	1 1/4	3 3/4	2 19/32	18.1	5/8
RS1822P	1 25/32	6	1	6	2 1/32	9.3	1/2
RS1822F	1 25/32	6	1	6	2 1/32	9.3	1/2
RS1832P	1 25/32	6	1	6	2 1/32	10.3	1/2
RS1832F	1 25/32	6	1	6	2 1/32	10.3	1/2
RS1833P	1 29/32	6	1 1/4	6	2 5/32	12.3	5/8
RS1833F	1 29/32	6	1 1/4	6	2 5/32	12.3	5/8
RS1844P	2 11/32	6	1 1/4	6	2 19/32	18.3	5/8
RS1844F	2 11/32	6	1 1/4	6	2 19/32	18.3	5/8
RS1855P	2 21/32	6	1 1/2	6	2 31/32	28.1	5/8
RS1855F	2 21/32	6	1 1/2	6	2 31/32	28.1	5/8
RS1866F	2 25/32	6	1 3/4	6	3 5/32	33.5	5/8
RS2444P	2 11/32	8	1 1/4	8	2 19/32	16.0	5/8
RS2444F	2 11/32	8	1 1/4	8	2 19/32	16.0	5/8
RS2455P	2 21/32	8	1 1/2	8	2 31/32	24.0	5/8
RS2455F	2 21/32	8	1 1/2	8	2 31/32	24.0	5/8
RS2466F	2 25/32	8	1 3/4	8	3 5/32	29.2	5/8

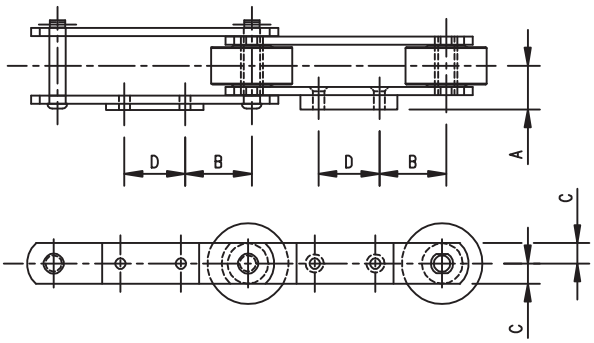


G16

Common SBR Chain Attachments

G16A→→

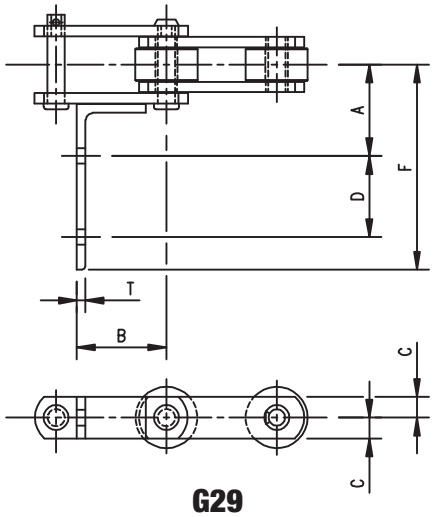
Chain No.	A	B	C	D	Weight Per Foot-Lbs. Δ	Bolt Size
RS1222P	2 9/32	4 1/8	1	3 3/4	12.7	1/2
RS1222F	2 9/32	4 1/8	1	3 3/4	12.7	1/2
RS1232P	2 9/32	4 1/8	1	3 3/4	14.2	1/2
RS1232F	2 9/32	4 1/8	1	3 3/4	14.2	1/2
RS1233P	2 13/32	4 1/8	1 1/4	3 3/4	17.7	5/8
RS1233F	2 13/32	4 1/8	1 1/4	3 3/4	17.7	5/8
RS1233½P	2 13/32	4 1/8	1 1/4	3 3/4	15.9	5/8
RS1244P	2 23/32	4 1/8	1 1/4	3 3/4	24.2	5/8
RS1244F	2 23/32	4 1/8	1 1/4	3 3/4	24.2	5/8
RS1244½P	2 23/32	4 1/8	1 1/4	3 3/4	19.7	5/8
S1245	2 27/32	4 1/8	1 1/4	3 3/4	20.2	5/8
RS1822P	2 9/32	6	1	6	14.9	1/2
RS1822F	2 9/32	6	1	6	14.9	1/2
RS1832P	2 9/32	6	1	6	15.9	1/2
RS1832F	2 9/32	6	1	6	15.9	1/2
RS1833P	2 13/32	6	1 1/4	6	15.0	5/8
RS1833F	2 13/32	6	1 1/4	6	15.0	5/8
RS1844P	2 23/32	6	1 1/4	6	20.0	5/8
RS1844F	2 23/32	6	1 1/4	6	20.0	5/8



G16A

G29→→

Chain No.	A	B	C	D	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
S4002	1 27/32	3 1/8	5/8	1 1/8	3 13/16	1/4	4.7	3/8
RS658P	2 15/16	3	1	1 1/2	5 11/32	1/4	11.7	3/8
RS658F	2 15/16	3	1	1 1/2	5 11/32	1/4	11.7	3/8



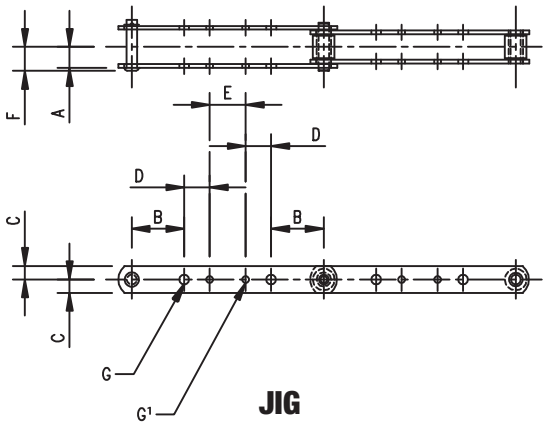
G29

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common SBR Chain Attachments

JIG

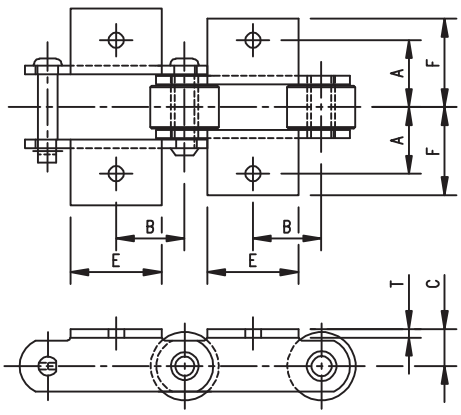
Chain No.	A	B	C	D	E	F	Weight Per Foot-Lbs. Δ	Bolt Size G	Bolt Size G¹
SS888	29/32	2 3/16	9/16	1 1/16	1 1/2	1 1/16	1.9	13/32	9/32
3939	7/8	2 3/16	9/16	1 1/16	1 1/2	1	1.6	13/32	9/32



JIG

K1 →→→

Chain No.	A	B	C	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
SS881	1 15/16	1 5/16	7/8	2 1/8	2 1/2	3/16	4.5	5/16
SS881+	1 15/16	1 5/16	7/8	2 1/8	2 1/2	3/16	4.5	5/16
S788+	1 13/16	1 5/16	7/8	2 1/8	2 17/32	1/4	5.3	3/8
S1183	1 15/32	1 1/2	13/16	2	2 5/32	3/16	5.0	5/16
S1184	1 15/16	1 1/2	13/16	2	2 7/32	3/16	5.0	5/16
SS554	2 5/32	1 17/32	1 1/4	2 1/2	2 7/8	5/16	10.0	1/2
SS554+	2 5/32	1 17/32	1 1/4	2 1/2	2 7/8	5/16	10.0	1/2
S1120	1 3/8	2	13/16	2 1/2	2 5/32	3/16	4.6	3/8
S1121	1 3/8	2	13/16	2 1/2	2 7/32	3/16	4.6	3/8
S4019	1 3/8	2	7/8	2 1/2	1 27/32	1/4	5.3	3/8
S1122	1 23/32	2	1	2 1/2	2 3/8	3/16	5.8	3/8
S1195	2	2	1 1/8	2 1/2	2 11/16	3/16	6.0	3/8
S4002	1 1/2	2	7/8	2 1/2	2	1/4	6.7	3/8
S1119	2	2	1	2 3/4	2 13/16	1/4	7.8	3/8
S2188	1 13/16	2	1	2 3/4	2 3/4	5/16	9.5	1/2
S531	2	2	1 1/4	2 3/4	2 13/16	3/8	12.5	1/2
S1140	2	2	1 1/2	1 3/4	2 25/32	5/16	13.1	1/2
S1197	2	3	1 1/4	3	2 25/32	3/16	5.1	3/8
S1196	2	3	1 1/4	3	2 15/32	1/4	7.4	3/8
S1116	2	3	1 1/8	3	2 11/16	1/4	7.2	1/2
S951	2 3/16	3	1 5/8	4	3 3/16	3/8	15.7	1/2
SS6	2 1/8	3	1 5/8	2 1/2	3 1/16	3/8	13.3	1/2
SS6SPC	2 1/8	3	1 5/8	2 1/2	3 1/16	3/8	14.9	1/2
SS96	2 1/4	3	1 5/8	2 1/2	3 1/8	3/8	14.0	1/2
SS944+	2 3/8	2 1/2	1 5/8	2 1/2	3 3/16	3/8	11.4	5/8
SS996	2 3/16	3	1 5/8	2 1/2	3 1/8	3/8	14.0	1/2

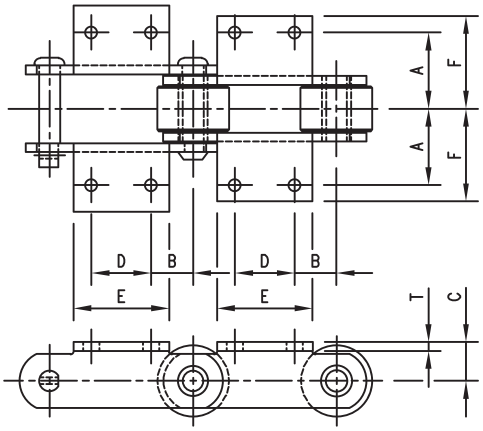


K1

Common SBR Chain Attachments

K2 STYLE 1→→→

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
SS881	2 3/32	1 1/16	7/8	1 1/4	2 1/8	2 1/2	3/16	4.5	5/16
SS881+	2 3/32	1 1/16	7/8	1 1/4	2 1/8	2 1/2	3/16	4.5	5/16
S1183	1 15/32	31/32	13/16	1 1/16	2	2 5/32	3/16	5.0	1/4
S1184	1 15/32	31/32	13/16	1 1/16	2	2 7/32	3/16	5.0	1/4
S1112	2 1/16	1 3/32	1 1/8	1 1/2	2 1/2	2 9/16	1/4	8.2	3/8
S1120	1 3/8	1 13/32	13/16	1 3/16	2 1/2	2 5/32	3/16	4.6	5/16
S1121	1 3/8	1 13/32	13/16	1 3/16	2 1/2	2 7/32	3/16	4.6	5/16
S4019	1 3/8	1 1/4	7/8	1 1/2	2 1/2	1 27/32	1/4	5.3	3/8
S1122	2	1	1	2	3 3/8	2 9/16	3/16	6.3	3/8
S1195	2	1	1 1/8	2	3 3/8	2 11/16	3/16	7.0	3/8
S1478	2	1	1	2	2 3/4	2 11/16	1/4	10.0	3/8
S4002	1 1/2	1 1/4	7/8	1 1/2	2 1/2	2	1/4	6.7	3/8
S2188	1 13/16	1 1/8	1	1 3/4	2 3/4	2 3/4	5/16	9.5	1/2
SS555	2 1/4	1 1/8	1 1/4	1 3/4	2 3/4	2 27/32	5/16	8.7	3/8
S531	2	1 1/8	1 1/4	1 3/4	2 3/4	2 13/16	3/8	12.5	3/8
S1113	2 1/16	1 17/64	1 1/4	1 1/2	2 3/4	2 5/8	5/16	12.6	3/8
S1197	2	2	1 1/4	2	3	2 25/32	3/16	5.1	3/8
S1196	2	2	1 1/4	2	3	2 15/32	1/4	6.9	3/8
S1116	2	2	1 1/8	2	3	2 11/16	1/4	7.2	3/8
S2190	2	2	1 1/8	2	3	2 11/16	1/4	8.2	3/8
S2190F	2	2	1 1/8	2	3	2 11/16	1/4	8.6	3/8
S1114	2	2	1 1/8	2	3	2 5/8	5/16	8.0	3/8
RS611P	2 5/8	1 1/2	2 1/2	3	4 1/4	3 15/16	5/16	15.9	3/8
RS611F	2 5/8	1 1/2	2 1/2	3	4 1/4	3 15/16	5/16	15.9	3/8
S2180	2 3/4	2	1 5/8	2	3	3 5/16	3/8	11.6	1/2
S951	2 3/16	2	1 5/8	2	4	3 3/16	3/8	15.7	1/2
SS6	2 1/8	1 11/16	1 5/8	2 5/8	4 7/8	3 3/32	3/8	15.0	1/2
SS6SPC	2 1/8	1 11/16	1 5/8	2 5/8	4 7/8	3 3/32	3/8	16.6	1/2
SS96	2 3/16	1 1/2	1 5/8	3	4 7/8	3 5/32	3/8	16.3	1/2
S1131	3	1 11/16	1 5/8	2 5/8	4 1/2	3 3/4	3/8	18.6	1/2
SS996	2 3/16	1 1/2	1 5/8	3	4 7/8	3 5/32	3/8	16.3	1/2
ZA2178A	2 3/16	1 1/2	1 5/8	3	4 3/8	3 3/32	3/8	17.1	1/2
ZA2198	2 3/16	1 1/2	1 5/8	3	4 1/4	2 13/16	1/2	18.2	1/2
S9063	2 3/16	1 1/2	1 3/4	3	4 1/2	3 9/32	3/8	17.4	1/2
ZA2800	2 19/32	1 3/4	2 3/16	4 1/2	6	3 11/16	1/2	33.3	5/8



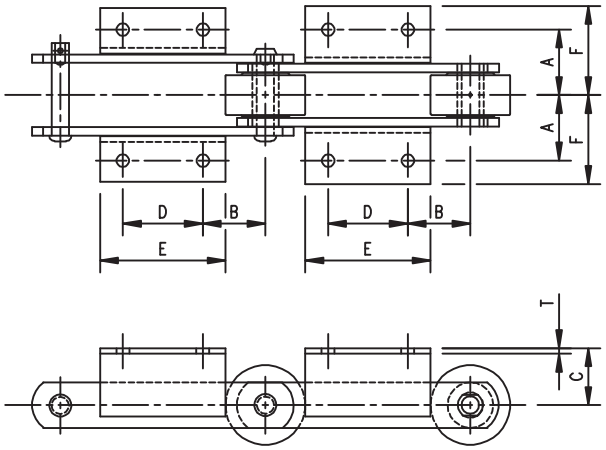
K2 STYLE 1

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common SBR Chain Attachments

K2 STYLE 2→→→

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
RS658P	2⅝	1½	2½	3	4¼	3⁹⁄₁₆	¼	15.5	⅜
RS658F	2⅝	1½	2½	3	4¼	3⁹⁄₁₆	¼	15.5	⅜
RS958P	2⅝	2¾	1¾	3½	5½	3¹¹⁄₃₂	¼	11.1	½
RS958F	2⅝	2¾	1¾	3½	5½	3¹¹⁄₃₂	¼	11.1	½
RS911P	2⁹⁄₁₆	2¾	1¾	3½	5½	3⁹⁄₁₆	¼	13.3	½
RS911F	2⁹⁄₁₆	2¾	1¾	3½	5½	3⁹⁄₁₆	¼	13.3	½
RS922P	2⅞	2¾	2½	3½	5½	3⅞	¼	17.5	½
RS922F	2⅞	2¾	2½	3½	5½	3⅞	¼	17.5	½
RS932P	2⅞	2¾	2⅞	3½	5½	3⅞	¼	19.5	½
RS932F	2⅞	2¾	2⅞	3½	5½	3⅞	¼	19.5	½
RS933P	3	2¾	2⅞	3½	5½	4	⅜	23.3	½
RS933F	3	2¾	2⅞	3½	5½	4	⅜	23.3	½
RS1222P	2⅞	3	2½	6	8	3⅞	¼	16.2	½
RS1222F	2⅞	3	2½	6	8	3⅞	¼	16.2	½
RS1232P	2⅞	3	2⅞	6	8	3⅞	¼	17.7	½
RS1232F	2⅞	3	2⅞	6	8	3⅞	¼	17.7	½
RS1233P	3	3	2⅞	6	8	4	⅜	21.5	½
RS1233F	3	3	2⅞	6	8	4	⅜	21.5	½
RS1244P	3¾	3	3⅝	6	8	5¹¹⁄₃₂	½	36.3	½
RS1244F	3¾	3	3⅝	6	8	5¹¹⁄₃₂	½	36.3	½

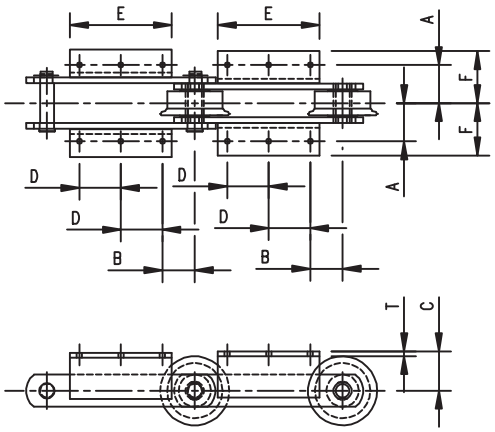


K2 STYLE 2

Common SBR Chain Attachments

K3→→→

Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
RS1222P	2⅞	3	2½	3	8	3⅞	¼	16.2	½
RS1222F	2⅞	3	2½	3	8	3⅞	¼	16.2	½
RS1232P	2⅞	3	2⅞	3	8	3⅞	¼	17.7	½
RS1232F	2⅞	3	2⅞	3	8	3⅞	¼	17.7	½
RS1233P	3	3	2⅞	3	8	4	⅜	21.5	½
RS1233F	3	3	2⅞	3	8	4	⅜	21.5	½
RS1244P	3¾	3	3⅝	3	8	5 11/32	⅜	32.6	½
RS1244F	3¾	3	3⅝	3	8	5 11/32	⅜	32.6	½
RS1822P	2⅞	3½	2½	5½	14	3⅞	¼	15.4	½
RS1822F	2⅞	3½	2½	5½	14	3⅞	¼	15.4	½
RS1832P	2⅞	3½	2⅞	5½	14	3⅞	¼	16.4	½
RS1832F	2⅞	3½	2⅞	5½	14	3⅞	¼	16.4	½
RS1833P	3	3½	2⅞	5½	14	4	⅜	20.2	½
RS1833F	3	3½	2⅞	5½	14	4	⅜	20.2	½
RS1844P	3¾	3½	3⅝	5½	14	5 11/32	⅜	30.2	½
RS1844F	3¾	3½	3⅝	5½	14	5 11/32	⅜	30.2	½
RS1855P	4	3½	4⅛	5½	13	5 25/32	½	42.5	½
RS1855F	4	3½	4⅛	5½	13	5 25/32	½	42.5	½
RS1866F	4⅛	4	4⅛	5	13	5 25/32	½	47.5	½
RS2444P	3¾	3½	3⅝	8½	19	5 11/32	⅜	28.2	½
RS2444F	3¾	3½	3⅝	8½	19	5 11/32	⅜	28.2	½
RS2455P	4	3	4⅛	9	19½	5 25/32	½	41.0	½
RS2455F	4	3	4⅛	9	19½	5 25/32	½	41.0	½
RS2466F	4⅛	3½	4⅛	8½	19	5 25/32	½	46.0	½

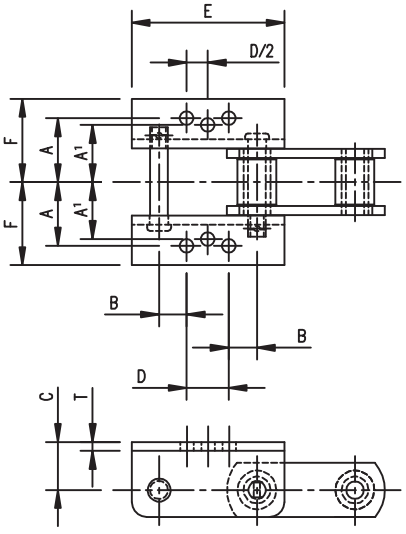


K3

K22 and K23

Chain No.	A	A¹	B	C	D	E	F	T	Weight Per Foot-Lbs. ΔΔ	Bolt Size
S3945	2 21/32	2⅜	1⅛	1⅜	1¾	6	3⅜	5/16	9.6	⅜
S4830	2 21/32	2⅜	1⅛	1⅜	1¾	5¾	3 9/16	⅜	11.0	⅜
S3952	2 21/32	—	1⅛	1⅝	1¾	6¼	3⅝	⅜	14.7	⅜
S2268	2 21/32	—	1 5/32	2	1¾	6⅜	3 15/32	⅜	20.3	½
S2268SPC	2 21/32	—	1 5/32	2	1¾	6⅜	3 31/32	⅜	18.7	½
S2268HD	2 21/32	—	1 5/32	2	1¾	6⅛	3 27/32	⅜	18.7	⅝
S3968	2 21/32	2⅜	1 7/16	1⅜	1¾	6 5/32	3⅜	5/16	9.9	⅜
S2035	3⅛	—	1 7/16	2	2 5/16	7⅞	4	⅜	19.3	½
ZA2800	2 19/32	—	2⅜	2 3/16	3¼	5	3 11/16	½	33.3	⅝

S3952 also available with square holes.



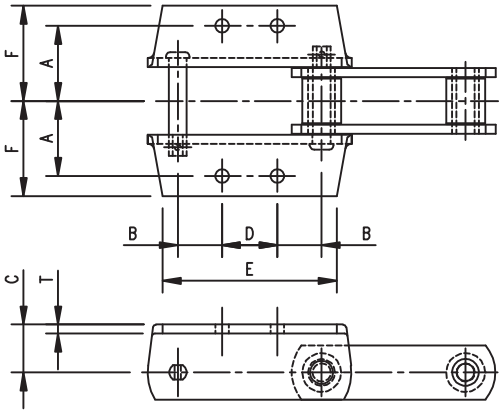
K22 and K23

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common SBR Chain Attachments

K25

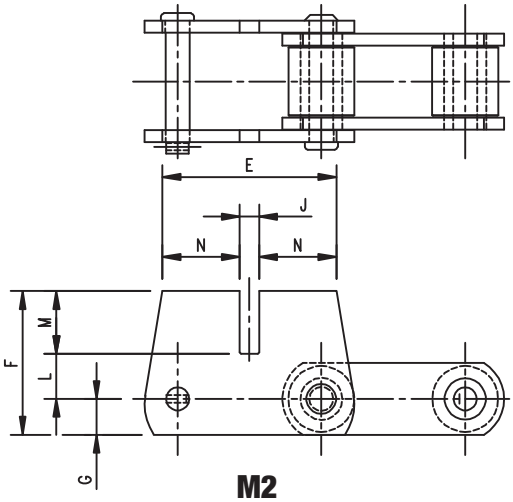
Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
S3433	2 21/32	1 1/8	1 1/8	1 3/4	4 3/4	3 13/32	3/8	11.5	1/2
S3433SPC	2 21/32	1 1/8	1 3/8	1 3/4	4 5/16	3 15/32	3/8	12.0	3/8
S9111A	3 1/8	1 7/32	1 1/2	2 5/16	5 1/2	3 29/32	3/8	15.1	1/2
S2847	2 11/16	2 1/8	1 1/2	1 3/4	7	3 21/32	5/16	9.0	1/2
S3940	3 1/8	1 27/32	2	2 5/16	7 1/4	3 31/32	3/8	14.5	1/2
S9833A	2 7/8	1 1/4	1 7/8	3 1/2	6 3/4	3 15/32	3/8	16.6	1/2
S9856B	3 5/8	1 3/4	1 7/8	2 1/2	7 1/2	4 23/32	1/2	28.0	3/4



K25

M2

Chain No.	E	F	G	J	L	M	N	Weight Per Foot-Lbs. ΔΔ
S3945	3 9/32	4 1/2	3/4	11/16	1 1/4	2 1/2	1 19/64	9.6
S2268	4 15/16	6	1 1/8	11/16	2	2 7/8	2 1/8	17.0
S3945SPC	3 3/8	4 1/2	3/4	11/16	1 1/4	2 1/2	1 11/32	12.8
S9856B	7 1/4	6	1 1/2	13/16	1 7/8	2 5/8	3 7/32	31.4

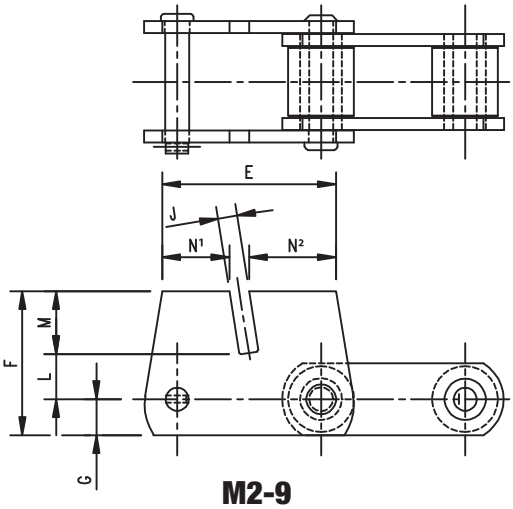


M2

M2-9

Chain No.	E	F	G	J	L	M	N¹	N²	Weight Per Foot-Lbs. ΔΔ
S9856B	7 1/4	6	1 1/2	13/16	1 1/4	3 1/4	2 23/32	3 23/32	31.4

Slot sloped 9° in direction of travel.

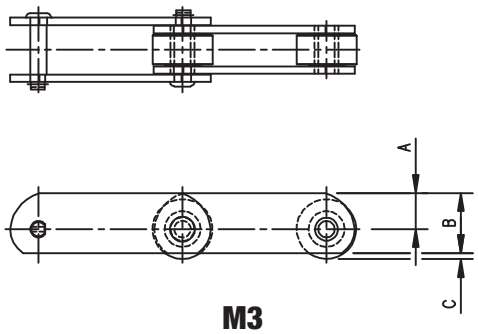


M2-9

Common SBR Chain Attachments

M3

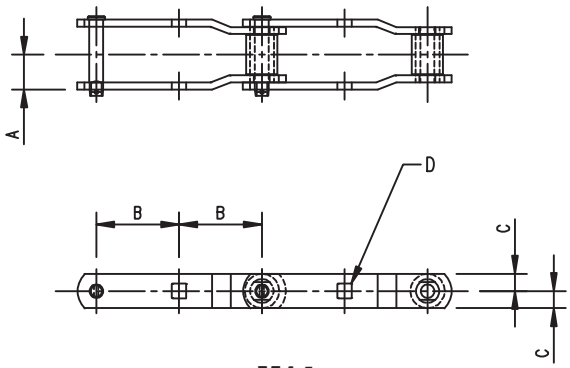
Chain No.	A	B	C	Weight Per Foot-Lbs. Δ
S1183	15/16	1½	3/16	4.5
S1184	15/16	1½	3/16	4.5
S1120	15/16	1½	3/16	3.9
S1121	15/16	1½	3/16	3.9
S1195	1¼	2	¼	6.0
S1140	1½	2½	¼	13.1
CC5	1½	2½	¼	10.5
S6910	1¾	3	¼	20.0



M3

M14

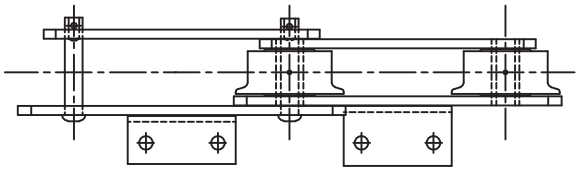
Chain No.	A	B	C	Shaft Size D	Weight Per Foot-Lbs. Δ
RS928	1 25/32	4½	1	1□	8.5
S2342	2	4½	1	1□	9.2
RS938	1 29/32	4½	1¼	1□	10.4
RS946	2 11/32	4½	1¼	1□	15.0
RS1228	1 25/32	6	1	1□	7.6
RS1238	1 29/32	6	1¼	1□	9.4
RS1246	2 11/32	6	1¼	1□	13.3
1706	2 17/32	6	1¼	1□	13.7
S2614	2 21/32	6	1¾	1¼□	24.0
S2648	3 11/32	6	2	1¼□	33.0

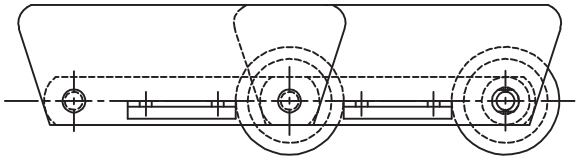


M14

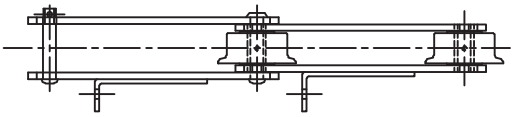
Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

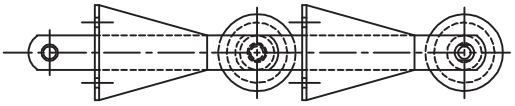
Common SBR Chain Attachments



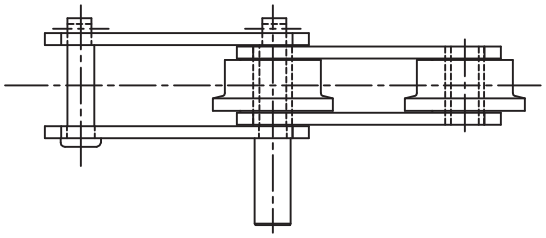


AR→→

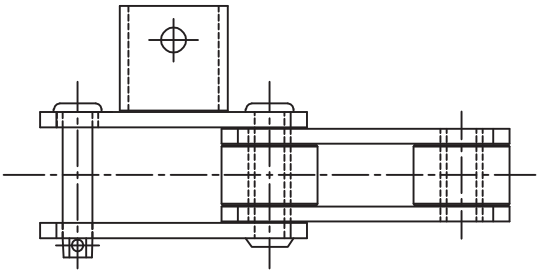




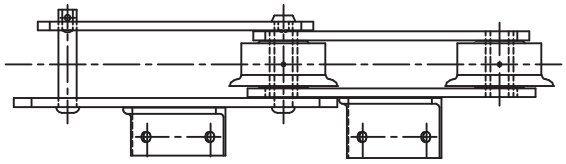
G19→→

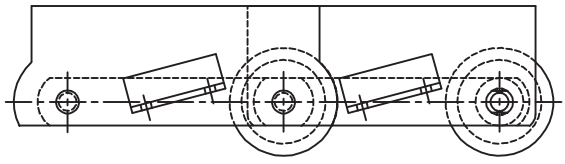


D5→→

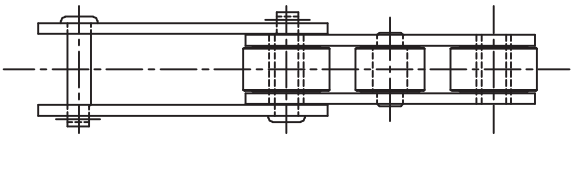


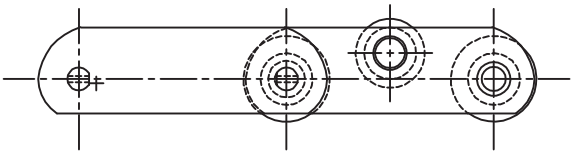
LOOPER→→





G2→→





RAISED ROLLER

These attachments can be furnished for all chains shown in this section.

Notes

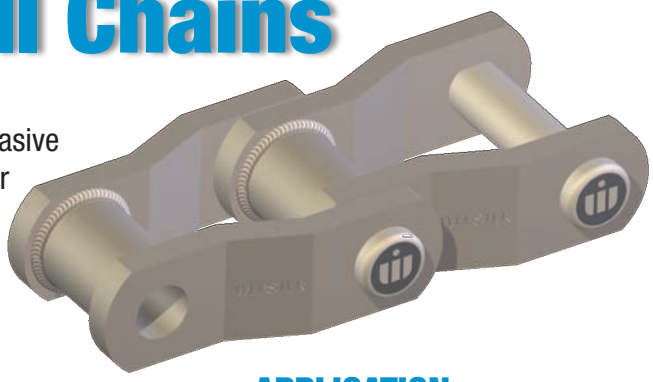
Notes

WELDED STEEL CHAINS



Welded steel chains and attachments are covered in this section, along with technical, interchange and application data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

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

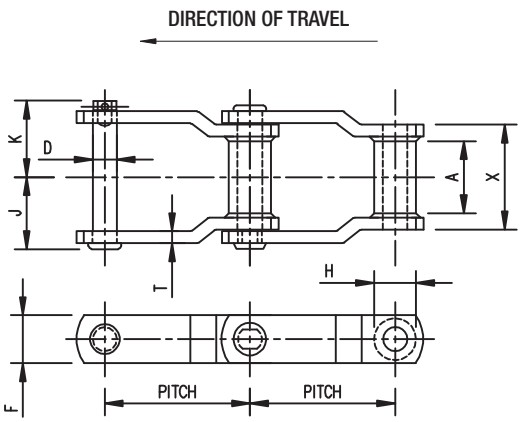
Welded steel mill chains are used in wood yards, paper mills, OSB plants, grain systems and ethanol processing. They provide long life with very low maintenance.

OPERATION

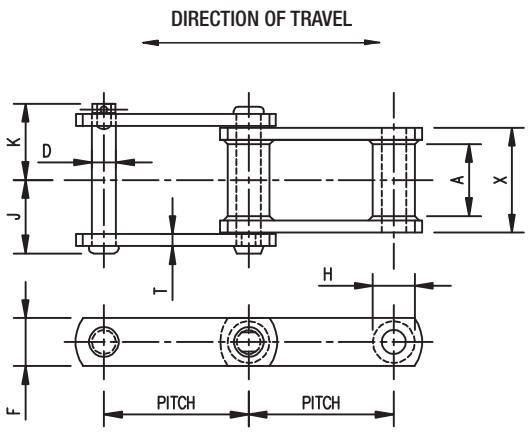
Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

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

Welded Steel Mill Chains



OFFSET STYLE



STRAIGHT STYLE

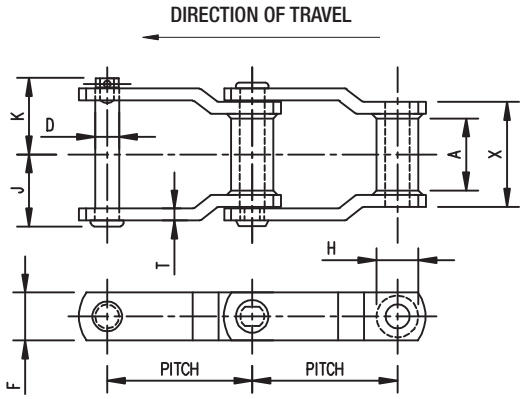
Abbreviations of Material and Treatment

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	Style	Material	Thk. T	Height F	Material	Outside Dia. H	Material	A	
WR78	½	A	ALY.H.T.	¼	1⅛	M.C.	⅞	M.C.	1⅛	A12, A22, CHAIR, F2, F4, G19, H1, H2, K1, K2, RF2, ROOFTOP, RR
WH78	½	A	ALY.H.T.	¼	1⅛	M.C.H.T.	⅞	M.C.H.T.	1⅛	
WHC78	½	A	ALY.H.T.	¼	1⅛	M.C.H.T.	⅞	M.C.H.T.	1⅛	
WH78HD	9⁄16	A	ALY.H.T.	⅜	1¼	M.C.H.T.	1	M.C.H.T.	⅞	K2
WR78-4	½	A	ALY.H.T.	¼	1¼	M.C.	⅞	M.C.	1⅛	
WH78-4	½	A	ALY.H.T.	¼	1¼	M.C.H.T.	⅞	M.C.H.T.	1⅛	
WR82	9⁄16	F	ALY.H.T.	¼	1¼	M.C.	1 1⁄16	M.C.	1¼	A22, A42, AD474, CHAIR, F4, H1, H2, K1, K2, RR
WH82	9⁄16	F	ALY.H.T.	¼	1¼	M.C.H.T.	1 1⁄16	M.C.H.T.	1¼	
WHC82	9⁄16	F	ALY.H.T.	¼	1¼	M.C.H.T.	1 1⁄16	M.C.H.T.	1¼	
WH82HD	⅝	A	ALY.H.T.	⅜	1½	M.C.H.T.	1 1⁄16	M.C.H.T.	1	CHAIR, K1, K2
WH82XHD	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1	CHAIR, K2
WR124	¾	A	ALY.H.T.	⅜	1½	M.C.	1¼	M.C.	1½	A220SB, A27, CHAIR, C CRADLE, F4, K1, K2, RF2, RR, S1
WH124	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WHX124	¾	A	ALY.I.H.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WHC124	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WH124HDSPC	1	F	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	1½	A220SB, CHAIR, A & C CRADLE, K2, RF2
WH124XHD	1	A	ALY.H.T.	⅝	2	M.C.H.T.	1¾	M.C.H.T.	1½	A220SB, CHAIR, C CRADLE
WH144	1	A	ALY.H.T.	⅜	1¾	M.C.H.T.	1⅝	M.C.H.T.	1½	A220SB
WR111+	¾	A	ALY.H.T.	⅜	1¾	M.C.	1¼	M.C.	2	A & C CRADLE, K1, K2
WH111+	¾	A	ALY.H.T.	⅜	1¾	M.C.H.T.	1¼	M.C.H.T.	2	A & C CRADLE, K1, K2
WHC111+	¾	A	ALY.H.T.	⅜	1¾	M.C.H.T.	1¼	M.C.H.T.	2	
WH111+HD	¾	A	ALY.H.T.	½	2	M.C.H.T.	1 7⁄16	M.C.H.T.	2	

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

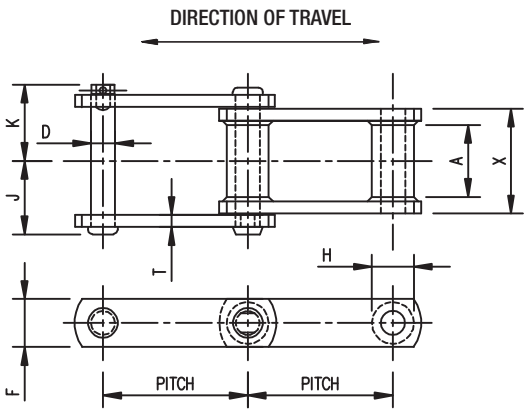
Welded Steel Mill Chains



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

Welded Steel Mill Chains



STRAIGHT STYLE

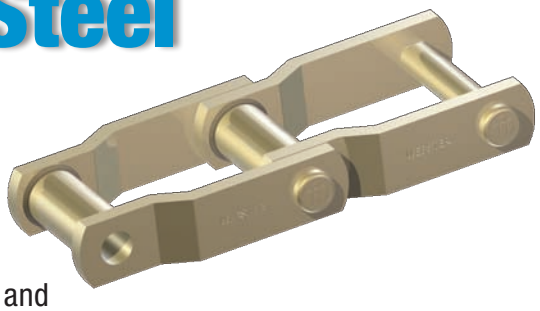
Abbreviations of Material and Treatment

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.			Thk.	Height		Outside Dia.			
	D	Style	Material	T	F	Material	H	Material	A	
WR110	¾	A	ALY.H.T.	⅜	1½	M.C.	1¼	M.C.	1¾	K2
WH110	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1¾	K2
WR106	¾	A	ALY.H.T.	⅜	1½	M.C.	1¼	M.C.	1½	A220SB, C CRADLE, K2
WH106	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	A220SB, C CRADLE, K2
WHX106	¾	A	ALY.I.H.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	A220SB, C CRADLE, K2
WHC106	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1¼	M.C.H.T.	1½	
WH106HD	¾	A	ALY.H.T.	½	1½	M.C.H.T.	1¼	M.C.H.T.	1½	A220SB
WH106XHD	1	F	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	1½	A220SB, C CRADLE
WH166	1	A	ALY.H.T.	⅜	1¾	M.C.H.T.	1⅝	M.C.H.T.	1½	A220SB
WR132	1	F	ALY.H.T.	½	2	M.C.	1¾	M.C.	2¾	A22, A220SB, A42, CHAIR, A B & C CRADLE, K2, M1, PC47, PETER FLIGHTS, RF3, S1
WH132	1	F	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX132	1	F	ALY.I.H.	½	2	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHC132	1	F	ALY.H.T.	½	2	M.C.H.T.	1¾	M.C.H.T.	2¾	
WH132HD	1	F	ALY.H.T.	⅝	2	M.C.H.T.	1¾	M.C.H.T.	2¾	A220SB, A42, A & C CRADLE, K2, M1, PETER FLIGHTS, S1
WH132XHD	1	A	ALY.H.T.	¾	2	M.C.H.T.	1¾	M.C.H.T.	2¾	C CRADLE
WR150	1	F	ALY.H.T.	½	2½	M.C.	1¾	M.C.	2¾	C CRADLE, K2, M1, RF3, RF12, RF18, S1
WH150	1	F	ALY.H.T.	½	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX150	1	F	ALY.I.H.	½	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WH150HD	1	F	ALY.H.T.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	A CRADLE
WH157	1⅛	A	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	A	ALY.I.H.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHC157	1⅛	A	ALY.H.T.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX157XHD	1¼	B	ALY.I.H.	⅝	3	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX155	1⅛	A	ALY.I.H.	9/16	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	C CRADLE, M1
WHX200	1¼	B	ALY.I.H.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX159	1¼	B	ALY.I.H.	⅝	3	M.C.H.T.	2	M.C.H.T.	2¾	
WHX2012A	1¼	B	ALY.I.H.	⅝	2½	M.C.H.T.	1¾	M.C.H.T.	2¾	
WHX3012	1¼	B	ALY.I.H.	⅝	3	M.C.H.T.	1¾	M.C.H.T.	2¾	

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Welded Stainless Steel Mill Chains



Welded stainless steel mill chains are designed for highly corrosive conditions often found in the ethanol, grain, paper, dairy, sugar, food processing, brewing, petroleum and chemical industries. The Type 316L stainless steel sidebars and Type 17-4 PH pins and barrels provide greater wearability and corrosion resistance. The Type 316L stainless steel sidebars have excellent welding characteristics.

MATERIAL

Sidebars are Type 316L stainless steel. Pins and barrels are heat treated Type 17-4 PH stainless steel. Sidebars, pins and barrels are available in other stainless steel alloys to meet the requirements of a specific application.

ASSEMBLY

Welded stainless steel mill chains are cottered construction. Riveted construction with cottered connecting pins is available on request.

INTERCHANGEABILITY

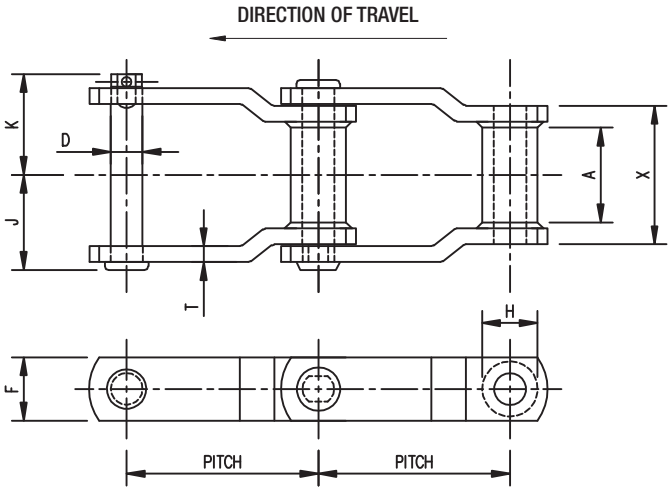
Welded stainless steel mill chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

Welded stainless steel mill chains are used in any application where both wearability and corrosion resistance are required. 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.

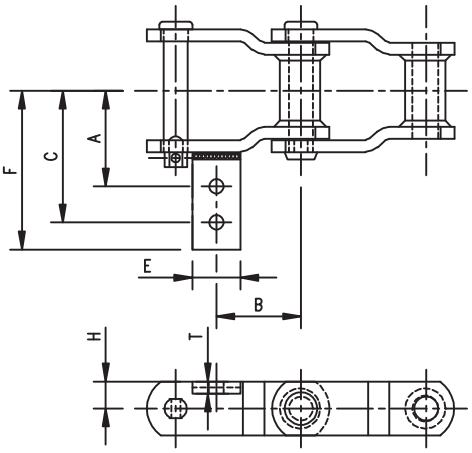


Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs. ☆	General Dimensions			Pins		Sidebars		Barrels	Max. Spkt. Width
						Length of Bearing	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Style	Thk.	Height	Outside Dia.	
						X	K	J	D		T	F	H	A
WS78	2.609	40	4.1	20,000	3,500	2	1 19/32	1 7/16	1/2	F	1/4	1 1/8	7/8	1 1/8
WS82	3.075	39	4.9	25,000	4,200	2 1/4	1 23/32	1 19/32	9/16	F	1/4	1 1/4	1 1/16	1 1/4
WS124	4.000	30	8.5	47,000	7,200	2 3/4	2 7/32	2 1/32	3/4	F	3/8	1 1/2	1 1/4	1 1/2
WS106	6.000	20	7.2	47,000	7,200	2 3/4	2 7/32	2 1/32	3/4	F	3/8	1 1/2	1 1/4	1 1/2
WS132	6.050	20	15.0	78,000	13,000	4 3/8	3 1/4	3 1/8	1	F	1/2	2	1 3/4	2 3/4

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	3⁵⁄₁₆	⁹⁄₁₆	¼	4.6	¼
WH78	2	1¾	2¾	1	3⁵⁄₁₆	⁹⁄₁₆	¼	4.6	¼



A12

A22

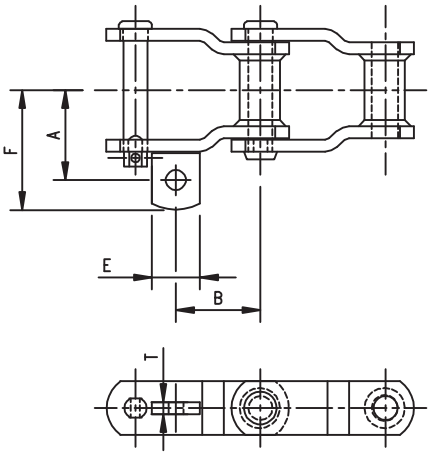
Chain No.	A	B	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	1⅞	1⅝	1	2½	⅜	4.6	⅜
WH78	1⅞	1⅝	1	2½	⅜	4.6	⅜
WR82	2⅛	1⅞	1¼	2¹¹⁄₁₆	¼	5.2	⅜
WH82	2⅛	1⅞	1¼	2¹¹⁄₁₆	¼	5.2	⅜
WR132	4	3¾	1½	4¾	½	15.0	½
WH132	4	3¾	1½	4¾	½	15.0	½
WHX132	4	3¾	1½	4¾	½	15.0	½

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	3³²⁄₃₂	2½	5¾	¾	16.8	⅞
WH132	4½	3³²⁄₃₂	2½	5¾	¾	16.8	⅞
WHX132	4½	3³²⁄₃₂	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



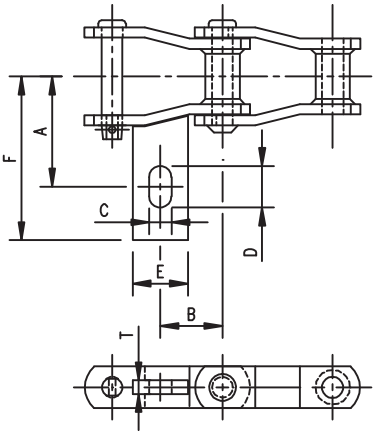
A22, A27 and A42

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Mill Chain Attachments

A220SB

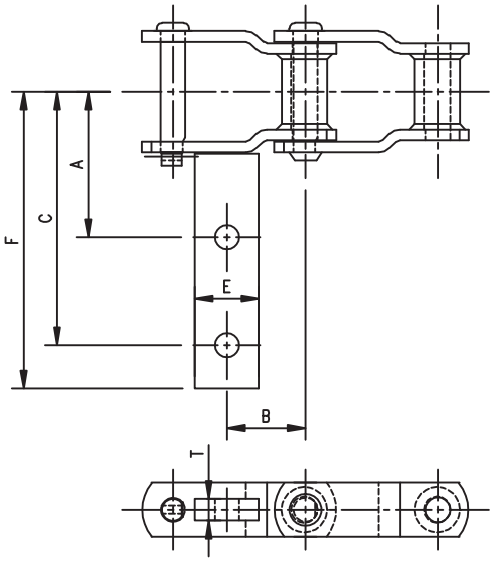
Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR124	4	2¼	13/16	1½	2	5 15/16	½	11.9	¾
WH124	4	2¼	13/16	1½	2	5 15/16	½	11.9	¾
WHX124	4	2¼	13/16	1½	2	5 15/16	½	11.9	¾
WH124HDSPC	4	2 1/32	13/16	1½	2½	5 15/16	½	18.8	¾
WH124XHD	4½	2 5/16	13/16	1½	2	6	⅝	21.5	¾
WR106	4	3½	13/16	1½	3	6	½	10.4	¾
WH106	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



A220SB

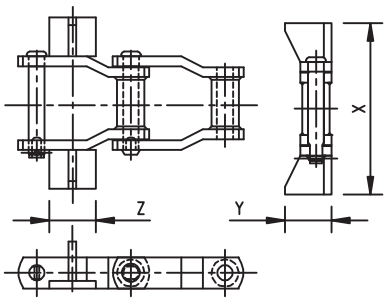
AD474

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

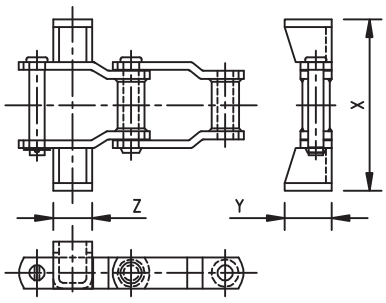


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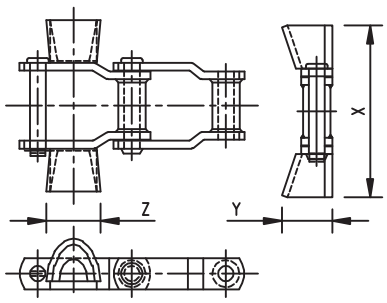
Common Mill Chain Attachments



STYLE A



STYLE B



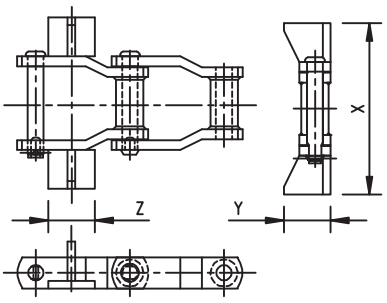
STYLE C

CRADLES

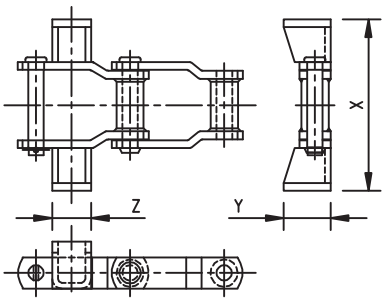
Chain No.	Style A Dimensions				Style B Dimensions				Style C Dimensions			
	X	Y	Z	Weight Per Pair-Lbs.	X	Y	Z	Weight Per Pair-Lbs.	X	Y	Z	Weight Per Pair-Lbs.
WR106	—	—	—	—	—	—	—	—	8	2½	3	4.0
WH106	—	—	—	—	—	—	—	—	8	2½	3	4.0
WHX106	—	—	—	—	—	—	—	—	8	2½	3	4.0
WR111+	—	—	—	—	—	—	—	—	8	2⅝	2½	4.0
WH111+	—	—	—	—	—	—	—	—	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	—	—	—	—	—	—	—	—

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

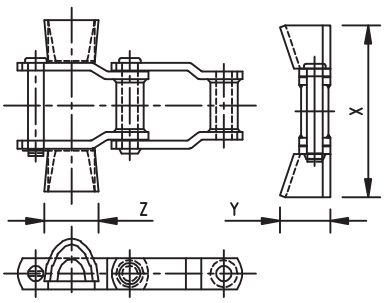
Common Mill Chain Attachments



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

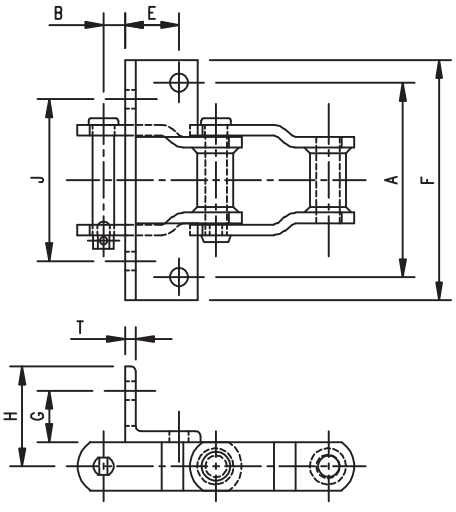
Common Mill Chain Attachments

F2

Chain No.	A	B	E	F	G	H	J	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	—	½	—	4 11/16	7/8	2 5/16	3 3/4	¼	7.6	3/8
WH78	—	½	—	4 11/16	7/8	2 5/16	3 3/4	¼	7.6	3/8

F4

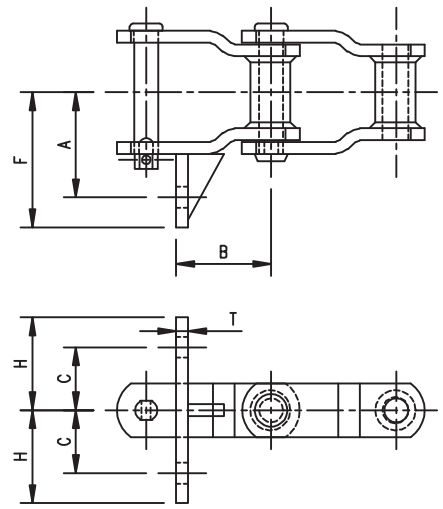
WR78	4½	½	1¼	5 9/16	1 3/16	2 5/16	3 3/4	¼	8.6	3/8
WH78	4½	½	1¼	5 9/16	1 3/16	2 5/16	3 3/4	¼	8.6	3/8
WR82	5	13/16	1⅛	5 15/16	1 3/16	2⅜	4⅛	¼	8.9	3/8
WH82	5	13/16	1⅛	5 15/16	1 3/16	2⅜	4⅛	¼	8.9	3/8
WR124	5¼	⅞	1 7/16	6 3/16	1 5/16	2¾	4⅜	⅜	14.0	3/8
WH124	5¼	⅞	1 7/16	6 3/16	1 5/16	2¾	4⅜	⅜	14.0	3/8
WHX124	5¼	⅞	1 7/16	6 3/16	1 5/16	2¾	4⅜	⅜	14.0	3/8



F2 and F4

G19

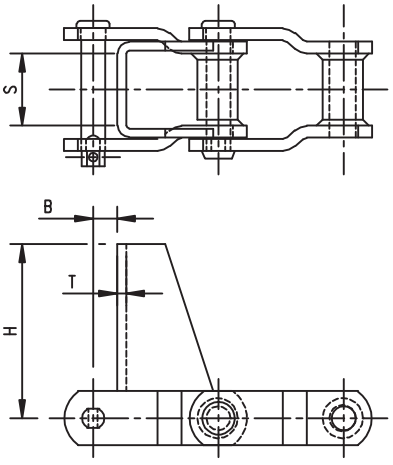
Chain No.	A	B	C	F	H	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	2 3/16	2	1 5/16	2 13/16	1 15/16	¼	6.3	3/8
WH78	2 3/16	2	1 5/16	2 13/16	1 15/16	¼	6.3	3/8



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



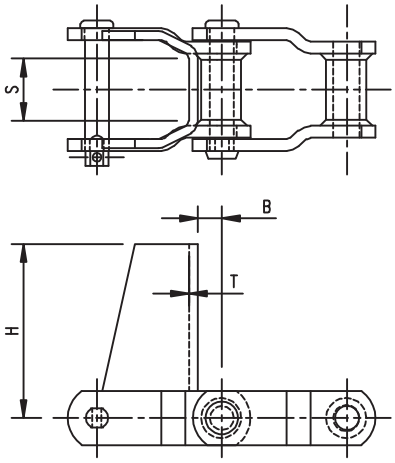
H1

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Mill Chain Attachments

H2

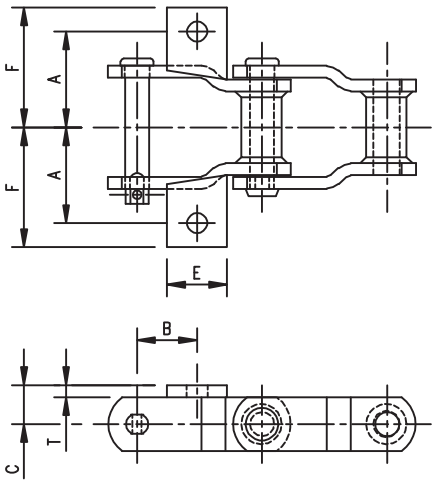
Chain No.	B	H	S	T	Weight Per Foot-Lbs. Δ
WR78	½	3⅝	1½	3/16	7.4
WH78	½	3⅝	1½	3/16	7.4
WR82	⅝	3⅝	1¾	3/16	7.5
WH82	⅝	3⅝	1¾	3/16	7.5



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

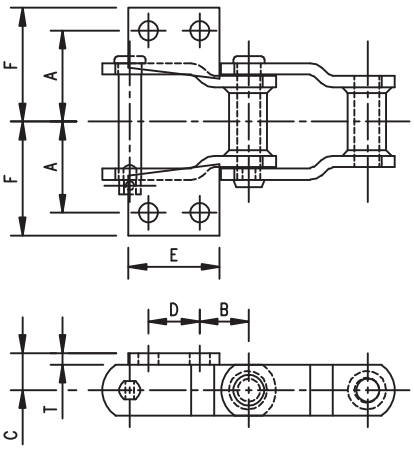


K1

Common Mill Chain Attachments

K2

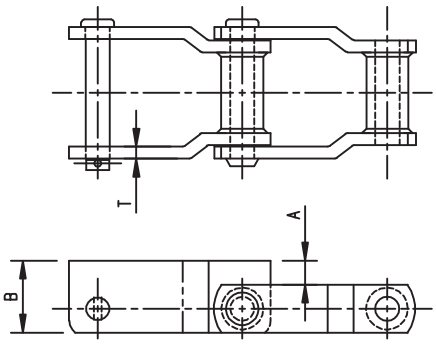
Chain No.	A	B	C	D	E	F	T	Weight Per Foot-Lbs. Δ	Bolt Size
WR78	2	1 5/64	13/16	1 1/8	2	2 1/2	1/4	5.8	3/8
WH78	2	1 5/64	13/16	1 1/8	2	2 1/2	1/4	5.8	3/8
WH78HD	2	1 3/32	7/8	1 1/8	2	2 1/2	1/4	8.3	3/8
WR82	2 1/8	1 5/16	15/16	1 1/4	2 1/4	2 3/4	5/16	7.1	3/8
WH82	2 1/8	1 5/16	15/16	1 1/4	2 1/4	2 3/4	5/16	7.1	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



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



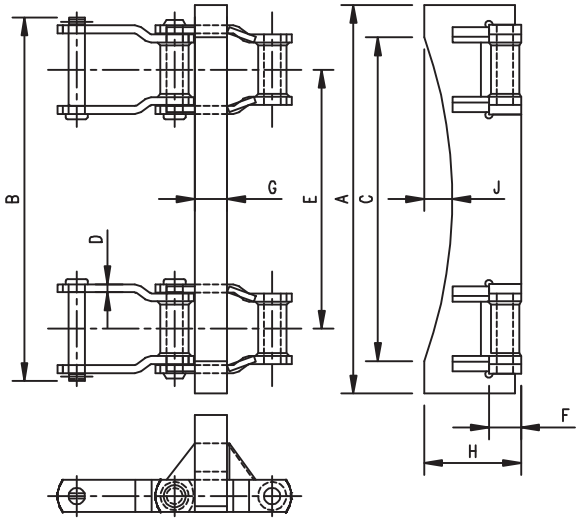
M1

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Mill Chain Attachments

PC47

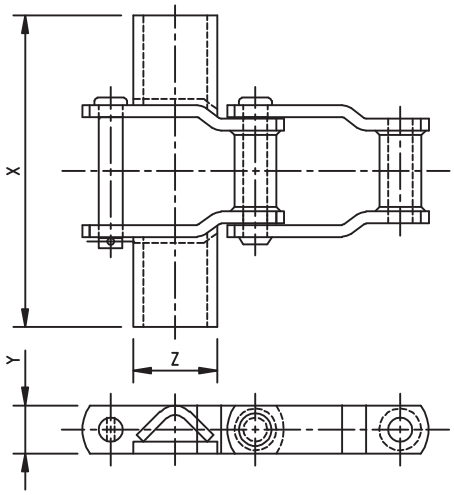
Chain No.	Assembly No.	Min. Spkt. Size	A	B	C	D	E	F	G	H	J	Weight Per Attach.-Lbs.
WH132	PC47-16	9T	18½	16⅜	16	½	10	2	2	6	1¾	50
WHX132	PC47-16	9T	18½	16⅜	16	½	10	2	2	6	1¾	50
WH132	PC47-20	9T	24	22⁷⁄₁₆	20	½	16	2	2	6	1¾	60
WHX132	PC47-20	9T	24	22⁷⁄₁₆	20	½	16	2	2	6	1¾	60



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

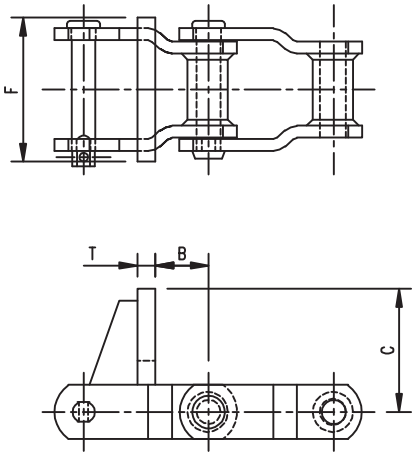


PETER FLIGHTS

Common Mill Chain Attachments

RF2

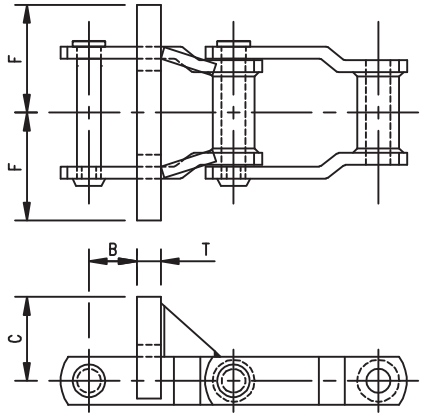
Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR78	1 3/32	2 9/16	3	3/8	7.8
WH78	1 3/32	2 9/16	3	3/8	7.8
WR124	2	3 1/4	4 1/4	3/8	12.8
WH124	2	3 1/4	4 1/4	3/8	12.8
WHX124	2	3 1/4	4 1/4	3/8	12.8
WH124HDSPC	1 9/16	3 1/2	4 3/4	1	25.7



RF2

RF3

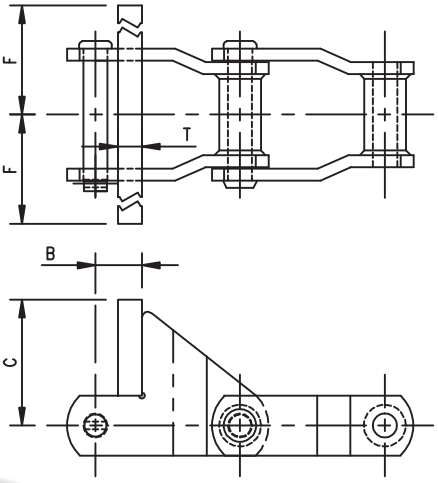
Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR132	2	3 1/2	4 1/2	1	31.1
WH132	2	3 1/2	4 1/2	1	31.1
WHX132	2	3 1/2	4 1/2	1	31.1
WR150	2	3 3/4	4 1/2	1	33.7
WH150	2	3 3/4	4 1/2	1	33.7
WHX150	2	3 3/4	4 1/2	1	33.7



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



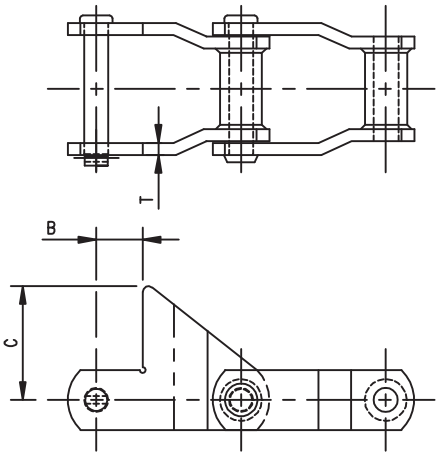
RF12

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Mill Chain Attachments

RF18

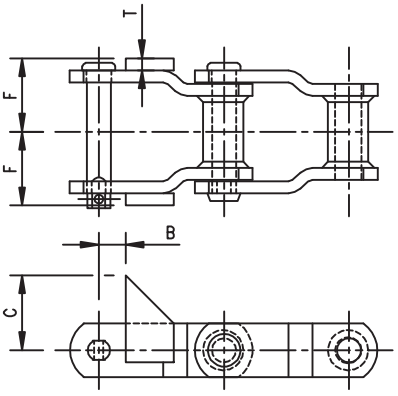
Chain No.	B	C	T	Weight Per Foot-Lbs. Δ
WR150	1 15/16	4 3/4	1/2	22.0
WH150	1 15/16	4 3/4	1/2	22.0
WHX150	1 15/16	4 3/4	1/2	22.0
WH157	1 1/2	4 3/4	5/8	27.9
WHX157	1 1/2	4 3/4	5/8	27.9



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

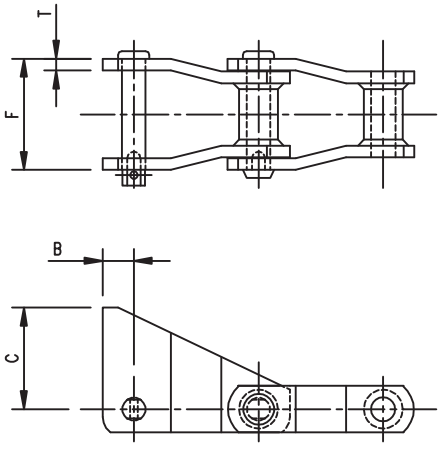


RR

S1

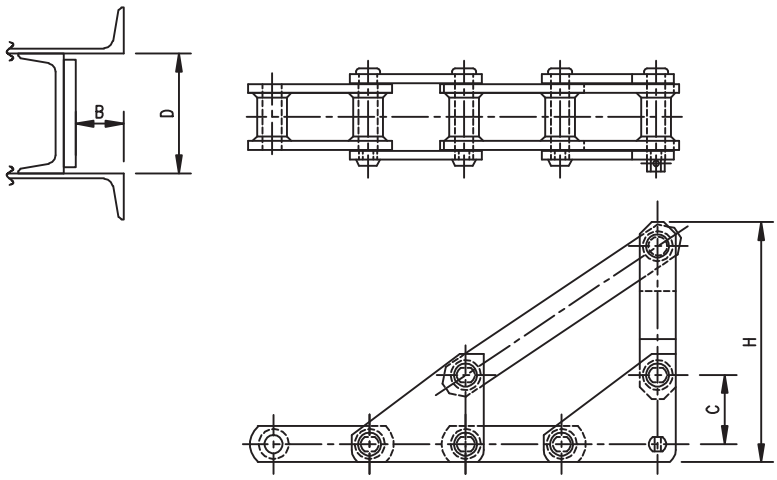
Chain No.	B	C	F	T	Weight Per Foot-Lbs. Δ
WR124	1	3 1/4	3 9/16	3/8	21.8
WH124	1	3 1/4	3 9/16	3/8	21.8
WHX124	1	3 1/4	3 9/16	3/8	21.8
WR132	1 3/16	5	5 1/2	1/2	28.5
WH132	1 3/16	5	5 1/2	1/2	28.5
WHX132	1 3/16	5	5 1/2	1/2	28.5
WH132HD	1 3/16	5	6	5/8	34.3
WR150	1 3/16	5 1/4	5 1/2	1/2	34.3
WH150	1 3/16	5 1/4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



S1

Common Mill Chain Attachments



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	2⅞	5	10	4	7	11.0
WH124	2	2⅞	5	10	4	7	11.0
WHX124	2	2⅞	5	10	4	7	11.0
WR124	2	2⅞	5	12	4	7	13.0
WH124	2	2⅞	5	12	4	7	13.0
WHX124	2	2⅞	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

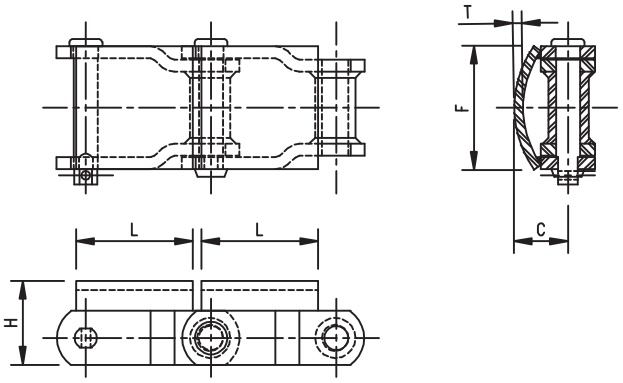
B and D dimensions are recommended trough sizes.
The height of chair depends on angle of lift and maximum diameter of logs.

Common Mill Chain Attachments

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.

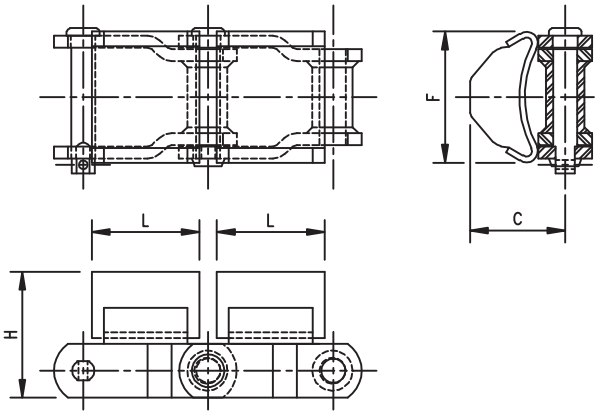


UNIVERSAL ROOFTOP TRANSFER CHAIN

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.

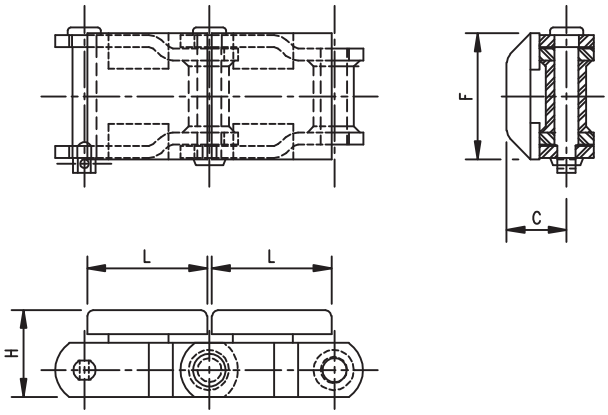


RUBBER ROOFTOP TRANSFER CHAIN

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

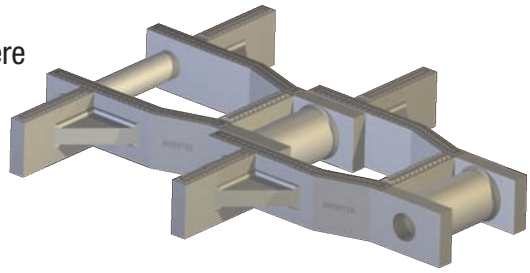
Low tooth profile sprockets must be used with this chain.



UHMW ROOFTOP TRANSFER CHAIN

Welded Steel Clinker Chains

Welded steel clinker chains are designed for applications where severe abrasion and/or high temperatures exist such as cold or hot cement clinkers. The sliding surfaces are hardface welded for additional wear resistance. Sidebars and wings are made from square edge bar for better scraping action and increased conveying capacity.



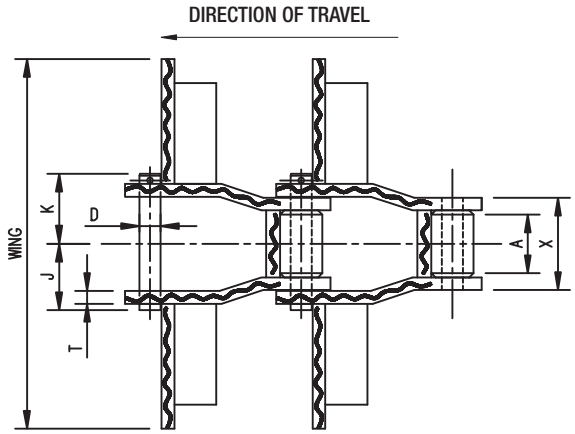
MATERIAL
Sidebars and barrels are medium carbon heat treated steel. Pins are medium carbon alloy heat treated steel and are induction hardened. Wings are unheat treated medium carbon steel.

ASSEMBLY
Welded steel clinker chains are cottered construction.

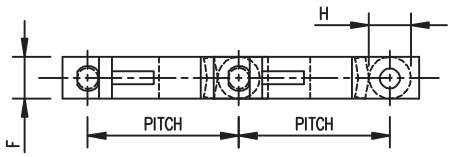
INTERCHANGEABILITY
Welded steel clinker chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION
Welded steel clinker chains are typically used in the cement industry in the cold or hot clinker drag conveyors. However, they are more than suitable for other applications where extreme abrasion and heat resistance are required. 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.



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



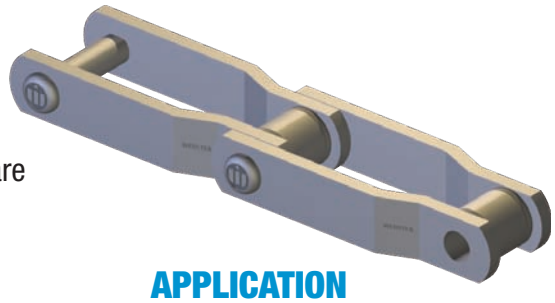
Chain No.	Average Pitch Inches	Approx. Links in 10 Feet	Average Weight Per Ft. Lbs. Plain Chain	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions		
						Length of Bearing	℄ To Cotter End	℄ To Head or Rivet End
						X	K	J
WHX5157HF	6.050	20	28.5	117,000	18,200	4⅝	3⅝	3⅜
WHX6067HF	9.000	13⅓	28.0	195,000	24,000	5½	4 3/16	3 15/16
WHX6121HF	9.000	13⅓	37.0	205,000	27,600	6 5/16	4 31/32	4 23/32
WHX5121HF	9.000	13⅓	37.0	205,000	27,600	6 5/16	4 31/32	4 23/32

Chain No.	Pins			Sidebars			Barrels		Max. Spkt. Width	Common Attachment Numbers
	Dia. D	Style	Material	Thk. T	Height F	Material	Outside Dia. H	Material	A	
WHX5157HF	1⅛	F	ALY.I.H.	⅝	2½	M.C.H.T.	2½	M.C.H.T.	2½	WING
WHX6067HF	1¼	F	ALY.I.H.	¾	2½	M.C.H.T.	2½	M.C.H.T.	3¼	WING
WHX6121HF	1¼	F	ALY.I.H.	1⅛	2½	M.C.H.T.	2½	M.C.H.T.	3¼	WING
WHX5121HF	1¼	F	ALY.I.H.	1⅛	2½	M.C.H.T.	2½	M.C.H.T.	3¼	WING

WHX5121HF runs closed end forward.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Welded Steel 720 Offset Chains



Welded steel 720 offset chains are designed for sewage and water treatment plants. They have more strength and wear resistance compared to their cast equivalents. Their rugged welded construction suits the environment and the sidebars are easily modified for application specific attachments.

MATERIAL

Sidebars and barrels are medium carbon steel. Pins are medium carbon alloy steel. All components are thru hardened for wear resistance and maximum chain life. All components can be furnished in stainless steel alloys and heat treatments as required for the application.

ASSEMBLY

Welded steel 720 offset chains are cottered construction using stainless steel cotters. Riveted construction with cottered connecting pins is available on request.

INTERCHANGEABILITY

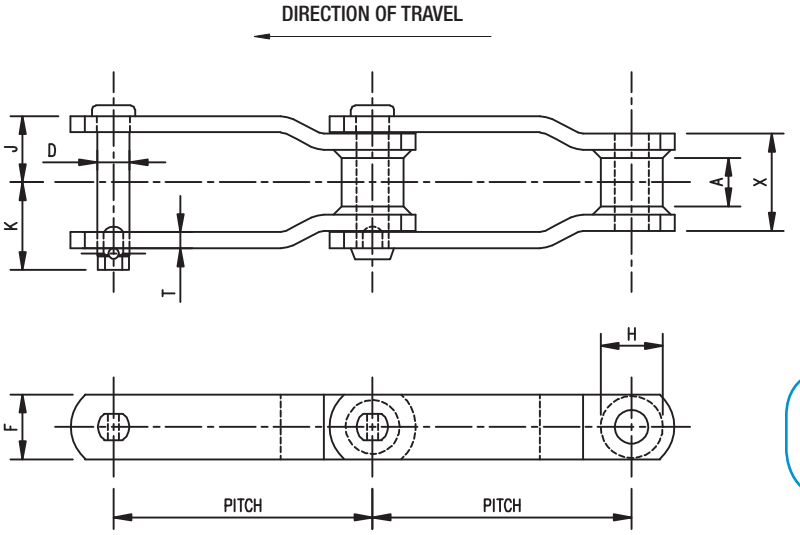
Welded steel 720 offset chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

Welded steel 720 offset chains carry the wooden flights that are conveyed through settling tanks and sludge collectors in water and sewage treatment plants or in similar applications.

OPERATION

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



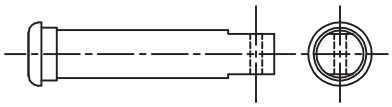
Abbreviations of Material and Treatment
M.C.H.T. . . . . Medium Carbon, Heat Treated
ALY.H.T. . . . . Alloy Steel, Heat Treated

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
WH720S	6.000	20	5.4	47,200	5,500	2⅛	1 27/32	1 21/32
WH720SH	6.000	20	6.3	67,000	5,900	2¼	2 1/32	1 25/32

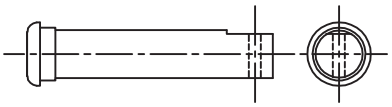
Chain No.	Pins			Sidebars			Barrels		Max. Spkt. Width	Common Attachment Numbers
	Dia. D	Style	Material	Thk. T	Height F	Material	Outside Dia. H	Material	A	
WH720S	¾	A	M.C.H.T.	5/16	1½	M.C.H.T.	1⅜	M.C.H.T.	1	
WH720SH	¾	A	ALY.H.T.	⅜	1½	M.C.H.T.	1 7/16	M.C.H.T.	1	

Mill Chain Pins

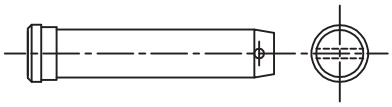
PINS



STYLE A



STYLE B



STYLE F

PIN INTERCHANGE

Previous	Present
Style 1	Style A
Style 5	Style B
Full Round End	Style F

Chain No.	Style	Dia.	Length Under Head	Weight Per 100 Pcs.-Lbs.
WR78	A	½	2⅞	20
WH78	A	½	2⅞	20
WHC78	A	½	2⅞	20
WH78HD	A	9/16	3⅛	21
WR78-4	A	½	2⅞	20
WH78-4	A	½	2⅞	20
WR82	F	9/16	3⅛	21
WH82	F	9/16	3⅛	21
WHC82	F	9/16	3⅛	21
WH82HD	F	⅝	3 13/32	30
WH82XHD	A	¾	3 9/16	45
WR106	A	¾	4 1/16	51
WH106	A	¾	4 1/16	51
WHC106	A	¾	4 1/16	51
WHX106	A	¾	4 1/16	51
WH106HD	A	¾	4 9/16	58
WH106XHD	F	1	4 19/32	103
WR110	A	¾	4¼	54
WH110	A	¾	4¼	54
WR111+	A	¾	4 11/16	59
WH111+	A	¾	4 11/16	59
WHC111+	A	¾	4 11/16	59
WH111+HD	A	¾	5⅛	65
WR124	A	¾	4 1/16	51
WH124	A	¾	4 1/16	51

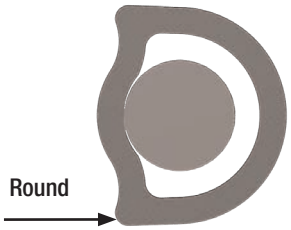
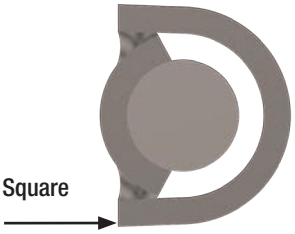
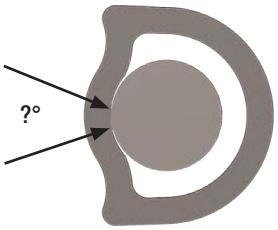
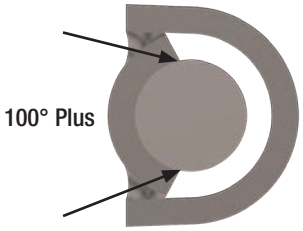
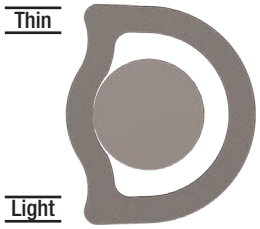
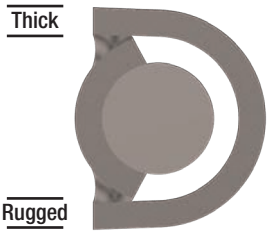
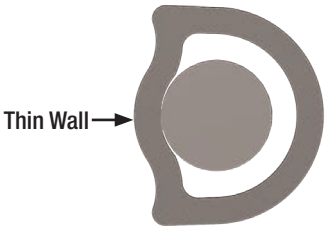
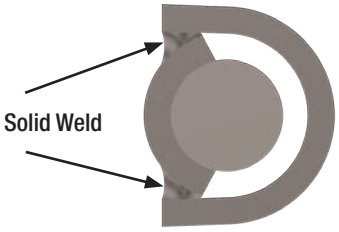
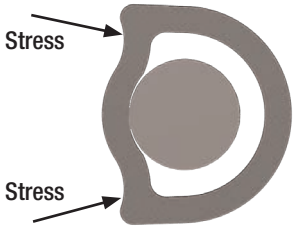
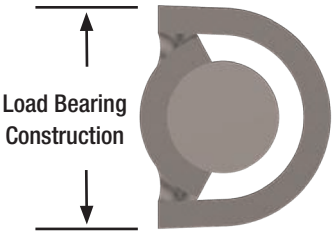
Chain No.	Style	Dia.	Length Under Head	Weight Per 100 Pcs.-Lbs.
WHC124	A	¾	4 1/16	51
WHX124	A	¾	4 1/16	51
WH124HDSPC	F	1	4 19/32	103
WH124XHD	A	1	5⅛	121
WR132	F	1	5 31/32	140
WH132	F	1	5 31/32	140
WHC132	F	1	5 31/32	140
WHX132	F	1	5 31/32	140
WH132HD	F	1	6½	152
WH132XHD	A	1	7	162
WH144	A	1	4 1/16	98
WR150	F	1	5 31/32	140
WH150	F	1	5 31/32	140
WHX150	F	1	5 31/32	140
WH150HD	F	1	6½	152
WHX155	A	1⅛	6⅜	190
WH157	A	1⅛	6 9/16	195
WHC157	A	1⅛	6 9/16	195
WHX157	A	1⅛	6 9/16	195
WHX157XHD	B	1¼	6 9/16	240
WHX159	B	1¼	6 9/16	240
WH166	A	1	4 1/16	98
WHX200	B	1¼	6 9/16	240
WHX2012A	B	1¼	6 9/16	240
WHX3012	B	1¼	6 9/16	240

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Notes

Welded Steel Drag Chain
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 insures 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.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

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.

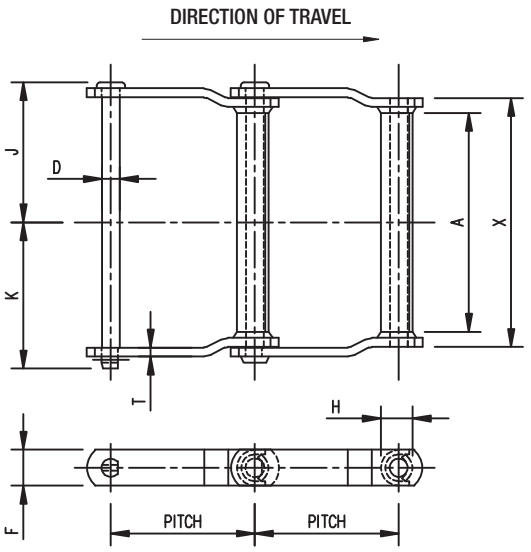
OPERATION

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.

Welded Steel Drag Chains



Abbreviations of Material and Treatment

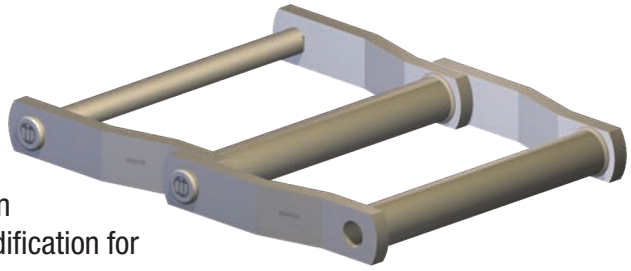
L.C. . . . . Low Carbon
M.C. . . . . Medium Carbon
M.C.H.T. . . . . Medium Carbon, Heat Treated

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

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

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

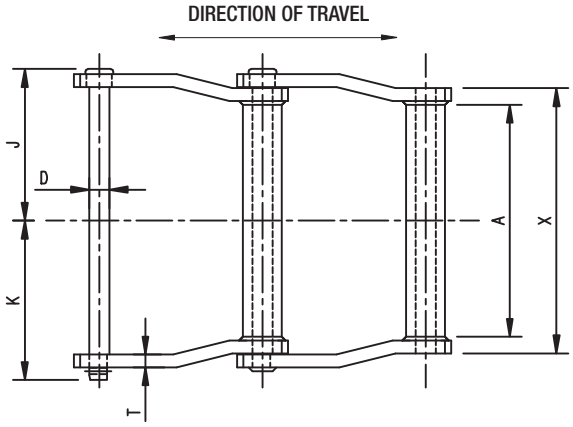
Welded steel heavy-duty drag chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

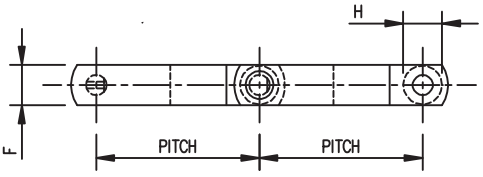
Welded steel heavy-duty drag chains can be used anywhere that our standard welded steel drag chains are used. This includes wood yards, paper mills, OSB plants and powerhouses. They provide longer life with very low maintenance.

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 11/16	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

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

Common Drag Chain Attachments

C1

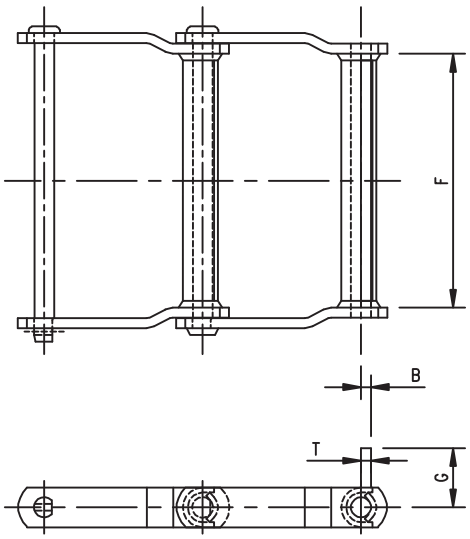
Chain No.	B	F	G	T	Weight Per Attach.-Lbs.
WD102	3/8	6 1/2	2 1/4	3/8	1.2
WDH102	3/8	6 1/2	2 1/4	3/8	1.2
WD104	3/8	4 1/8	2 1/4	3/8	0.8
WDH104	3/8	4 1/8	2 1/4	3/8	0.8
WD110	3/8	9 1/8	2 1/4	3/8	1.6
WDH110	3/8	9 1/8	2 1/4	3/8	1.6
WD112	3/8	9 1/8	2 1/4	3/8	1.6
WDH112	3/8	9 1/8	2 1/4	3/8	1.6
WD116	3/8	12 7/8	2 3/8	3/8	2.2
WDH116	3/8	12 7/8	2 3/8	3/8	2.2
WD480	1/2	11 3/4	2 3/4	1/2	3.1
WDH480	1/2	11 3/4	2 3/4	1/2	3.1
WDH580	1/2	11 3/4	2 1/2	1/2	2.6

C3

WD110	3/8	9 1/8	3	3/8	2.4
WDH110	3/8	9 1/8	3	3/8	2.4
WD113	1/2	9 1/8	3	1/2	3.1
WDH113	1/2	9 1/8	3	1/2	3.1
WD116	3/8	12 7/8	3	3/8	3.1
WDH116	3/8	12 7/8	3	3/8	3.1
WD118	1/2	13 1/4	3	1/2	3.9
WDH118	1/2	13 1/4	3	1/2	3.9
WD120	1/2	8 5/8	3	1/2	2.6
WDH120	1/2	8 5/8	3	1/2	2.6
WD480	1/2	11 3/4	3	1/2	3.5
WDH480	1/2	11 3/4	3	1/2	3.5

C4

WD102	3/8	6 1/2	3 3/4	3/8	2.2
WDH102	3/8	6 1/2	3 3/4	3/8	2.2
WD104	3/8	4 1/8	3 3/4	3/8	1.5
WDH104	3/8	4 1/8	3 3/4	3/8	1.5
WD110	3/8	9 1/8	3 3/4	3/8	3.1
WDH110	3/8	9 1/8	3 3/4	3/8	3.1
WD112	3/8	9 1/8	3 3/4	3/8	3.1
WDH112	3/8	9 1/8	3 3/4	3/8	3.1
WD113	3/8	9 1/8	4 3/4	1/2	5.4
WDH113	3/8	9 1/8	4 3/4	1/2	5.4
WD116	3/8	12 7/8	4 7/8	3/8	5.6
WDH116	3/8	12 7/8	4 7/8	3/8	5.6
WD480	1/2	11 3/4	5	1/2	7.0
WDH480	1/2	11 3/4	5	1/2	7.0



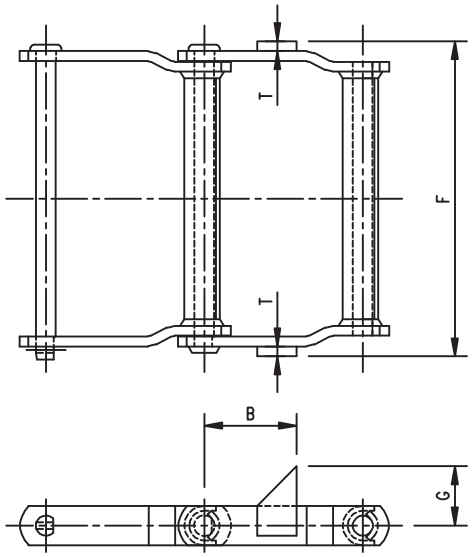
C1, C3 and C4

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Common Drag Chain Attachments

RR

Chain No.	B	F	G	T	Weight Per Pair-Lbs.
WD102	3	9⅜	2¼	⅜	0.6
WDH102	3	9⅜	2¼	⅜	0.6
WD104	3½	7	2¼	⅜	0.6
WDH104	3½	7	2¼	⅜	0.6
WD110	3½	12	2¼	⅜	0.6
WDH110	3½	12	2¼	⅜	0.6
WD112	3½	12	2¼	⅜	0.6
WDH112	3½	12	2¼	⅜	0.6
WD113	3½	12⅝	2¼	⅜	0.6
WDH113	3½	12⅝	2¼	⅜	0.6
WD116	4¾	15¾	2⅝	⅜	0.9
WDH116	4¾	15¾	2⅝	⅜	0.9
WD118	4¾	17	3	½	1.5
WDH118	4¾	17	3	½	1.5
WD480	4¾	14⅞	3	½	1.5
WDH480	4¾	14⅞	3	½	1.5
WDH580	4¾	14⅞	3	½	1.5
WDH680	4¾	15⅜	3	½	1.5



RR

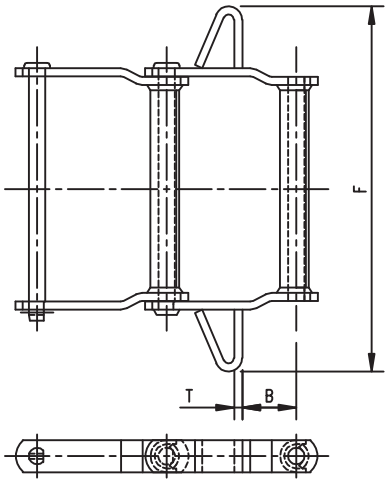
Common Drag Chain Attachments

WING

Chain No.	F	B	T	Weight Per Pair-Lbs.
WD104	11	2½	⅜	1.8
WDH104	11	2½	⅜	1.8
WD104	12	2½	⅜	2.1
WDH104	12	2½	⅜	2.1
WD102	13¼	1¾	⅜	1.8
WDH102	13¼	1¾	⅜	1.8
WD102	14⅜	1¾	⅜	2.2
WDH102	14⅜	1¾	⅜	2.2
WD110	15	2½	⅜	1.4
WDH110	15	2½	⅜	1.4
WD120	15	2¾	½	2.4
WDH120	15	2¾	½	2.4
WD110	16	1⅞	⅜	1.8
WDH110	16	1⅞	⅜	1.8
WD110	17	2½	⅜	2.0
WDH110	17	2½	⅜	2.0
WD112	17	3¼	⅜	2.0
WDH112	17	3¼	⅜	2.0
WD113	17	2½	⅜	2.4
WDH113	17	2½	⅜	2.4
WD120	17	2½	½	3.6
WDH120	17	2½	½	3.6
WD122	17	3	½	3.6
WDH122	17	3	½	3.6
WD480	17	3	½	2.1
WDH480	17	3	½	2.1
WD480	18	3¼	½	2.6
WDH480	18	3¼	½	2.6
WDH680	18	2½	½	2.5
WD110	19	2½	⅜	2.7
WDH110	19	2½	⅜	2.7
WD120	19	2½	½	4.6
WDH120	19	2½	½	4.6
WD480	19	3	½	3.2
WDH480	19	3	½	3.2
WD110	20	2½	⅜	3.0
WDH110	20	2½	⅜	3.0
WD480	20	3	½	3.8
WDH480	20	3	½	3.8
WD110	21	2½	⅜	3.3
WDH110	21	2½	⅜	3.3
WD480	21	3	½	4.4
WDH480	21	3	½	4.4
WD110	22	1⅞	⅜	3.7
WDH110	22	1⅞	⅜	3.7
WD116	22	3	⅜	2.9
WDH116	22	3	⅜	2.9

WING

Chain No.	F	B	T	Weight Per Pair-Lbs.
WD118	22	3	½	3.7
WDH118	22	3	½	3.7
WD120	22	2⅛	½	6.2
WDH120	22	2⅛	½	6.2
WD122	22	3	½	6.4
WDH122	22	3	½	6.4
WD480	22	3	½	5.0
WDH480	22	3	½	5.0
WDH680	22	2½	½	4.9
WD110	23	1⅞	⅜	4.0
WDH110	23	1⅞	⅜	4.0
WD110	24	1⅞	⅜	4.3
WDH110	24	1⅞	⅜	4.3
WD112	24	3	⅜	4.3
WDH112	24	3	⅜	4.3
WD480	24	3	½	6.0
WDH480	24	3	½	6.0
WD118	25	2¾	½	5.6
WDH118	25	2¾	½	5.6
WD480	26	3	½	7.2
WDH480	26	3	½	7.2
WD116	28	3	⅜	5.1
WDH116	28	3	⅜	5.1
WD480	28	2¾	½	8.4
WDH480	28	2¾	½	8.4
WD116	29	3	⅜	5.9
WDH116	29	3	⅜	5.9
WD118	30	2¾	½	8.2
WDH118	30	2¾	½	8.2
WD480	30	2⅝	½	9.5
WDH480	30	2⅝	½	9.5
WD480	32	2¾	½	10.5
WDH480	32	2¾	½	10.5

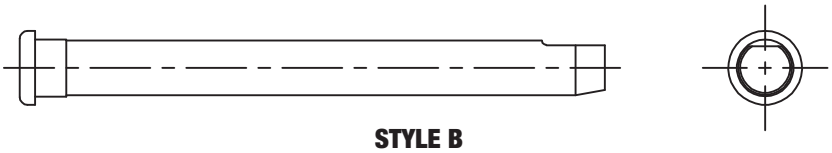


WING

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Drag Chain Pins

PIN



STYLE B

PIN INTERCHANGE

Previous	Present
Style 3	Obsolete
Style 4	Obsolete
Style 5	Style B

Chain No.	Style	Dia.	Length Under Head	Weight Per 100 Pcs.-Lbs.
WD102	B	¾	9	120
WDH102	B	¾	9	120
WD104	B	¾	6 9/16	105
WDH104	B	¾	6 9/16	105
WD110	B	¾	11 9/16	152
WDH110	B	¾	11 9/16	152
WD112	B	¾	11 9/16	152
WDH112	B	¾	11 9/16	152
WD113	B	⅞	12 1/8	217
WDH113	B	⅞	12 1/8	217
WD116	B	¾	15 5/16	200
WDH116	B	¾	15 5/16	200
WD118	B	⅞	16 7/16	378
WDH118	B	⅞	16 7/16	378

Chain No.	Style	Dia.	Length Under Head	Weight Per 100 Pcs.-Lbs.
WDH118HD	B	1	16 15/16	390
WD120	B	⅞	11 11/16	210
WDH120	B	⅞	11 11/16	210
WDH120HD	B	1	12 3/16	283
WD122	B	⅞	11 11/16	210
WDH122	B	⅞	11 11/16	210
WDH122HD	B	1	12 3/16	283
WD480	B	⅞	14 5/16	253
WDH480	B	⅞	14 5/16	253
WDH480HD	B	1	14 13/16	341
WDH520	B	1	11 11/16	273
WDH522	B	1	11 11/16	273
WDH580	B	1	14 5/16	330
WDH680	B	1	14 13/16	341

Notes

Notes

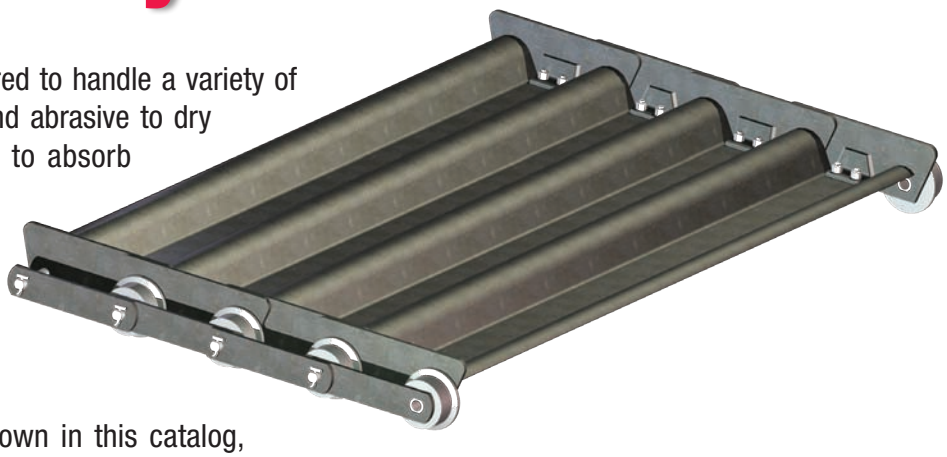
SPECIALTY CHAINS



Specialty chains including apron conveyors and pans, ENDURO-FLITE® and pans, flat top conveyor chains, slat top conveyor chains, gull wing conveyor chains, horizontal curve conveyor chains, double flex chains, Delrin bushed roller chains and traveling water screen chains are covered in this section, along with technical, interchange and application data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.



Apron Conveyors



Apron conveyors are engineered to handle a variety of materials ranging from hot and abrasive to dry and fine. Pans are designed to absorb the impact of large lumps, repeated loading and inclined conveying with minimum spillage or breakage, cleaner discharge and more durable continuous service.

In addition to the designs shown in this catalog, Webster aprons are available with modifications to these standard designs, in total custom designs and as replacements for aprons from other manufacturers.

MATERIAL

Pans are mild steel. Sidebars are medium carbon steel. Pins are thru hardened alloy steel for even more wear resistance. Sidebars and pins can be furnished with additional heat treatment on request. Bushings are furnished in case hardened steel to provide maximum wear resistance and chain life. Rollers are furnished in WEBLOY and provide a grease reservoir and lubrication fittings when internal greasing is required.

ASSEMBLY

Apron conveyor chains are cottered construction.

INTERCHANGEABILITY

Apron conveyor chains are interchangeable with other standard makes of corresponding sizes and numbers.

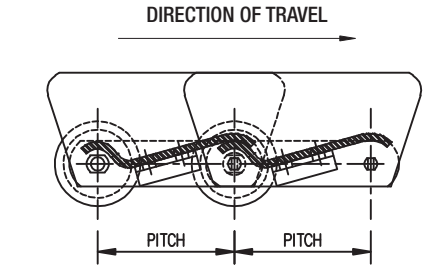
APPLICATION

Aprons are used in conveyors and feeders where the most difficult operating conditions prevail. The rollers provide lower operating friction which helps to increase chain life and reduce conveyor design requirements.

OPERATION

Apron conveyors are best suited for slow or moderate speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

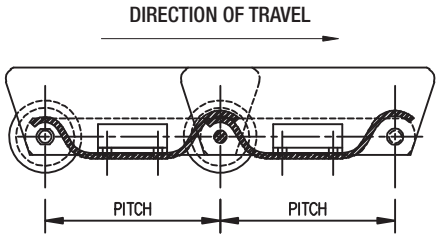
Apron Conveyor Pans



STYLE B

STYLE B

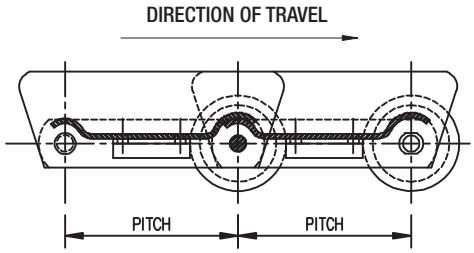
The single beaded pans are a natural for inclined conveyors. The shape of the pan allows for cleaner discharge at the head end and minimizes breakage of fragile materials.



STYLE AD

STYLE AD

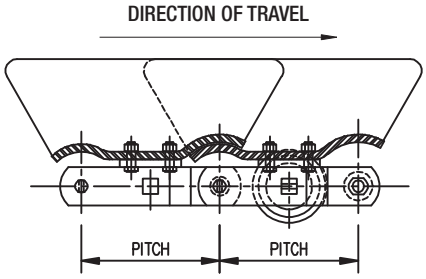
The deep double beaded pans are used for handling large capacities or hot materials. The deep pan can absorb the impact of large lumps as well as carry materials on inclined conveyors.



STYLE A1

STYLE A1

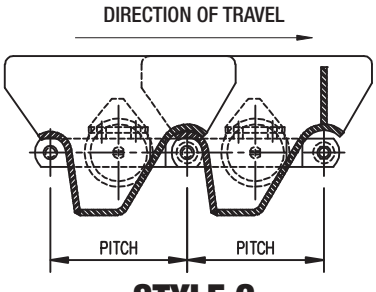
The shallow double beaded pans are recommended for heavy-duty continuous service or for handling abrasive materials.



STYLE A

STYLE A

The double beaded leakproof pans are recommended for fine or hot materials. The design of the pan holds fine or dry materials until they are discharged. Because the chains are mounted underneath with independent outboard rollers, hot materials can be easily handled.



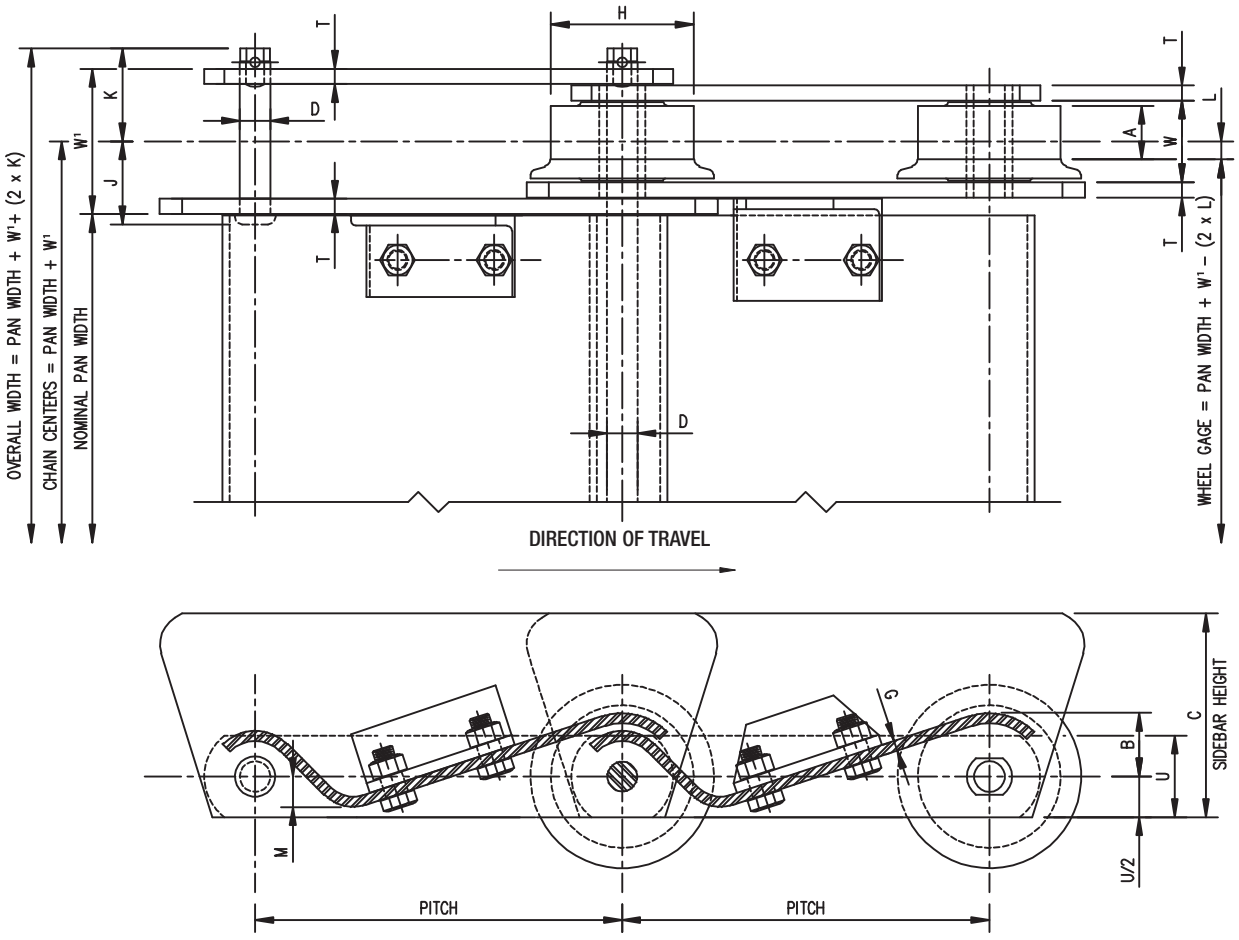
STYLE C

STYLE C

The deep leakproof pan allows fine or hot materials to be carried at steeper inclines and higher capacities.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Apron Conveyors
With Style B Pans



G
PAGE G-4

CHAIN DIMENSIONS

Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions				Pins	Sidebars		Rollers		
						Inside Sidebars	Outside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Thk.	Height	Tread Dia.	Tread Width	℄ Chain To Wheel Ga.
				Dry	Lubed	W	W¹	K	J	D	T	U	H	A	L
RS658F	6.000	30,000	4,650	0.17	0.12	1 5/8	2 11/16	1 27/32	1 17/32	5/8	1/4	2	3	1 1/8	3/8
RS622F	6.000	50,000	7,200	0.16	0.11	2	3 9/16	2 9/32	2 1/32	3/4	3/8	2	3 1/2	1 5/16	7/16
RS922F	9.000	50,000	7,200	0.16	0.11	2	3 9/16	2 9/32	2 1/32	3/4	3/8	2	3 1/2	1 5/16	7/16
RS933F	9.000	56,000	9,200	0.16	0.11	2 1/4	3 13/16	2 15/32	2 5/32	7/8	3/8	2 1/2	4	1 9/16	17/32
RS944F	9.000	90,000	12,700	0.14	0.10	2 5/8	4 11/16	2 27/32	2 19/32	1	1/2	2 1/2	5	1 3/4	19/32
RS1222F	12.000	50,000	7,200	0.16	0.11	2	3 9/16	2 9/32	2 1/32	3/4	3/8	2	3 1/2	1 5/16	7/16
RS1233F	12.000	56,000	9,200	0.16	0.11	2 1/4	3 13/16	2 15/32	2 5/32	7/8	3/8	2 1/2	4	1 9/16	17/32
RS1244F	12.000	90,000	12,700	0.14	0.10	2 5/8	4 11/16	2 27/32	2 19/32	1	1/2	2 1/2	5	1 3/4	19/32

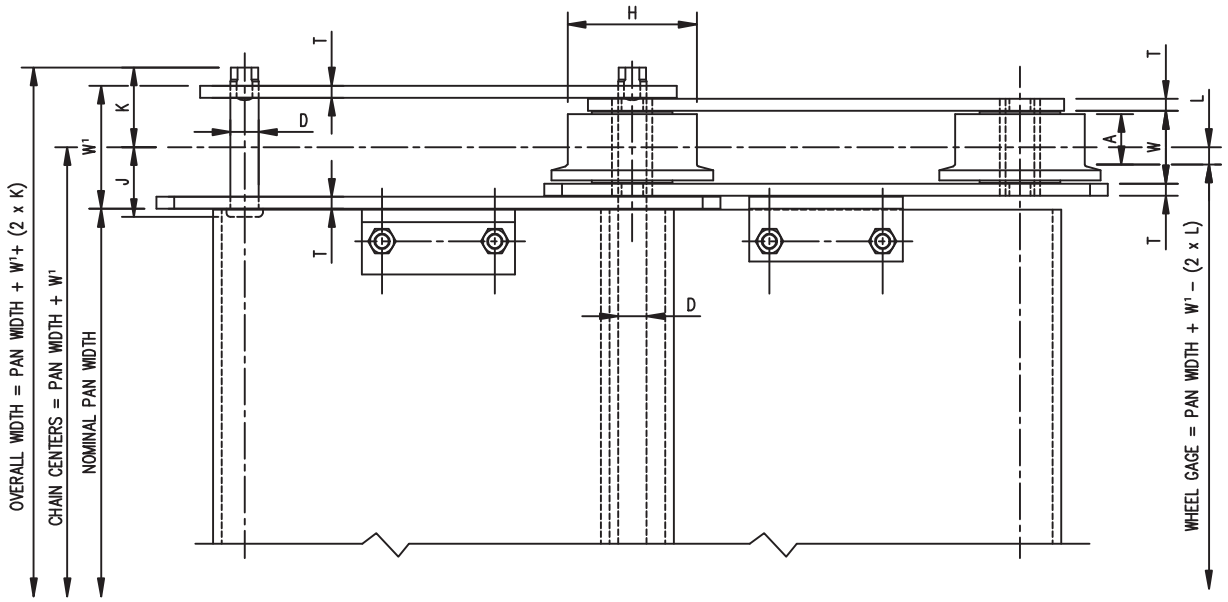
Apron Conveyors
With Style B Pans

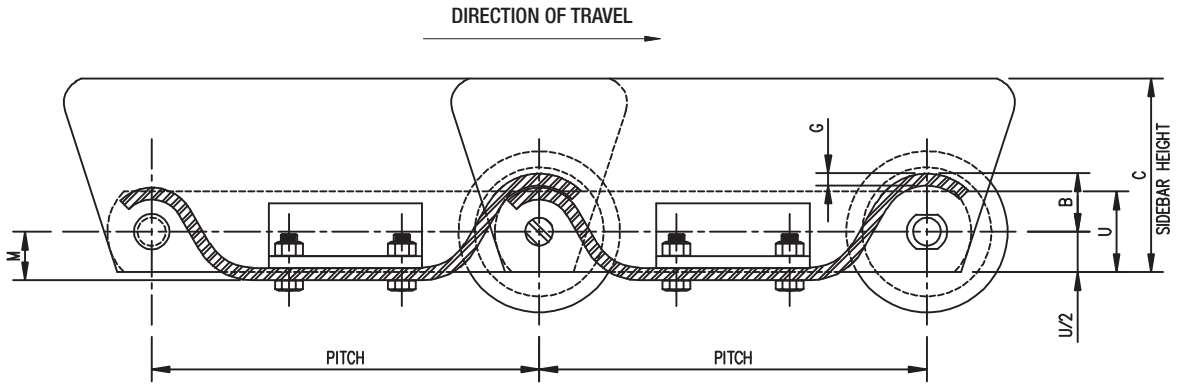
PAN CAPACITIES, WEIGHTS AND DIMENSIONS

Chain No.	Average Pitch Inches	Capacity Dimension C			Weight Lbs. Nominal Pan Width = 1'-0" Dimension C			Add For Each Additional 1'-0" Width in Lbs.	Dimensions		
		4	5	6	4	5	6		G	B	M
RS658F	6.000	10.8	14.8	18.8	38	40	43	11.0	3/16	1 3/16	15/16
		10.8	14.8	18.8	41	44	46	15.0	1/4	1 1/4	15/16
RS622F	6.000	10.8	14.8	18.8	52	56	60	11.0	3/16	1 3/16	15/16
		10.8	14.8	18.8	56	59	63	15.0	1/4	1 1/4	15/16
RS922F	9.000	10.3	14.3	18.3	44	47	50	10.0	3/16	1 1/4	3/4
		10.3	14.3	18.3	47	50	54	13.5	1/4	1 5/16	3/4
		10.0	14.0	18.0	52	55	59	18.5	5/16	1 11/16	1 1/4
		10.0	14.0	18.0	56	59	62	22.0	3/8	1 3/4	1 1/4
RS933F	9.000	9.3	13.3	17.3	50	54	55	10.0	3/16	1 1/4	3/4
		9.3	13.3	17.3	54	57	59	13.5	1/4	1 5/16	3/4
		9.0	13.0	17.0	59	62	65	18.5	5/16	1 11/16	1 1/4
		9.0	13.0	17.0	62	66	69	22.0	3/8	1 3/4	1 1/4
RS944F	9.000	9.3	13.3	17.3	71	75	80	10.0	3/16	1 1/4	3/4
		9.3	13.3	17.3	74	78	83	13.5	1/4	1 5/16	3/4
		9.0	13.0	17.0	79	84	88	18.5	5/16	1 11/16	1 1/4
		9.0	13.0	17.0	83	87	92	22.0	3/8	1 3/4	1 1/4
RS1222F	12.000	9.3	13.3	17.3	49	51	55	19.5	5/16	1 3/4	1
		9.3	13.3	17.3	53	55	59	23.0	3/8	1 13/16	1
RS1233F	12.000	8.3	12.3	16.3	54	57	60	19.5	5/16	1 3/4	1
		8.3	12.3	16.3	58	61	64	23.0	3/8	1 13/16	1
RS1244F	12.000	8.3	12.3	16.3	71	75	79	19.5	5/16	1 3/4	1
		8.3	12.3	16.3	75	79	83	23.0	3/8	1 13/16	1

Capacity is in cubic feet per hour for a pan 1'-0" wide (80% full) traveling at 1'-0" per minute.
Weights are in pounds per foot for a pan 1'-0" wide.

Apron Conveyors
With Style AD Pans





CHAIN DIMENSIONS

Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions				Pins	Sidebars		Rollers		
						Inside Sidebars	Outside Sidebars	℄To Cotter End	℄To Head or Rivet End	Dia.	Thk.	Height	Tread Dia.	Tread Width	℄ Chain To Wheel Ga.
				Dry	Lubed	W	W¹	K	J	D	T	U	H	A	L
RS658F	6.000	30,000	4,650	0.17	0.12	1⅝	2 11/16	1 27/32	1 17/32	⅝	¼	2	3	1⅛	⅜
RS622F	6.000	50,000	7,200	0.16	0.11	2	3 9/16	2 9/32	2 1/32	¾	⅜	2	3½	1 5/16	7/16
RS922F	9.000	50,000	7,200	0.16	0.11	2	3 9/16	2 9/32	2 1/32	¾	⅜	2	3½	1 5/16	7/16
RS933F	9.000	56,000	9,200	0.16	0.11	2¼	3 13/16	2 15/32	2 5/32	⅞	⅜	2½	4	1 9/16	17/32
RS944F	9.000	90,000	12,700	0.14	0.10	2⅝	4 11/16	2 27/32	2 19/32	1	½	2½	5	1¾	19/32
RS1222F	12.000	50,000	7,200	0.16	0.11	2	3 9/16	2 9/32	2 1/32	¾	⅜	2	3½	1 5/16	7/16
RS1233F	12.000	56,000	9,200	0.16	0.11	2¼	3 13/16	2 15/32	2 5/32	⅞	⅜	2½	4	1 9/16	17/32
RS1244F	12.000	90,000	12,700	0.14	0.10	2⅝	4 11/16	2 27/32	2 19/32	1	½	2½	5	1¾	19/32

Apron Conveyors
With Style AD Pans

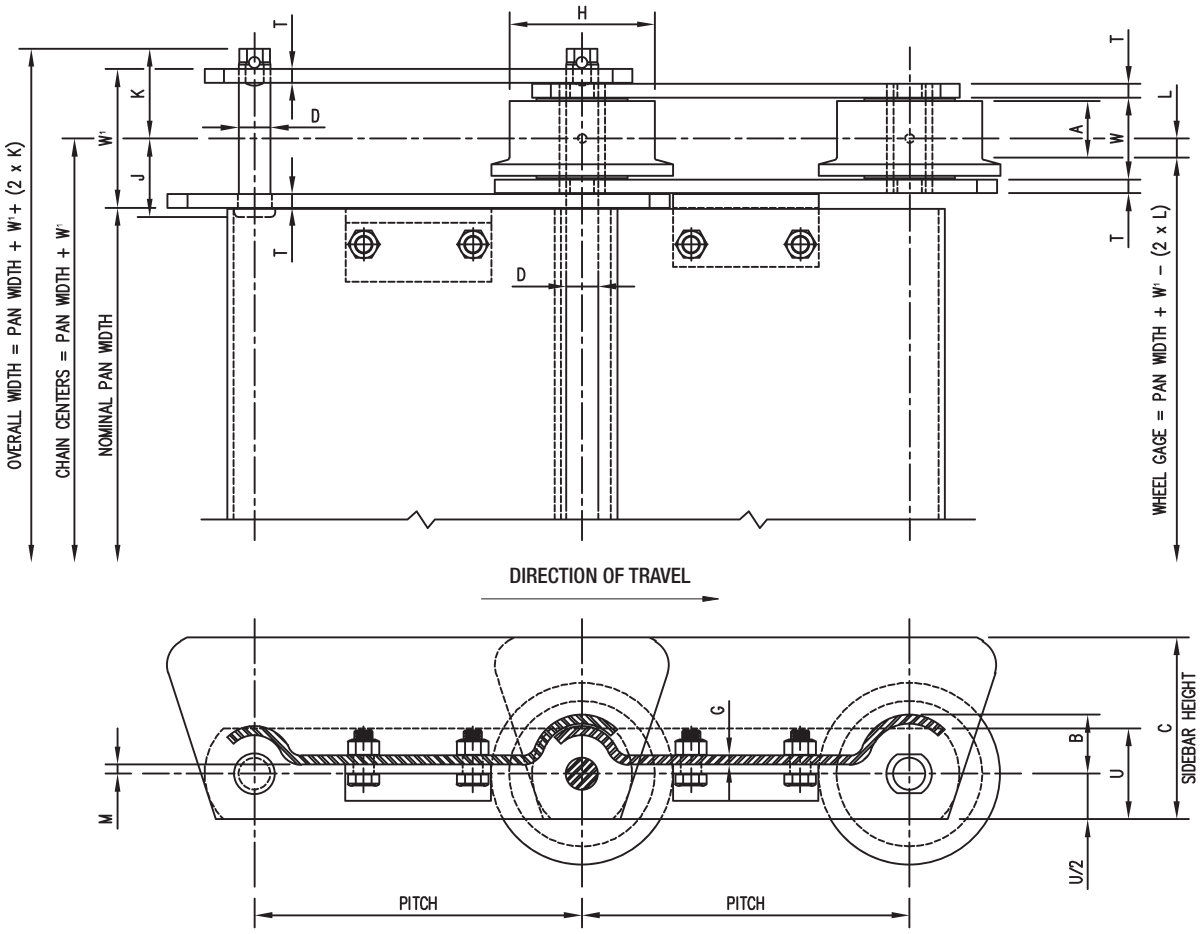
PAN CAPACITIES, WEIGHTS AND DIMENSIONS

Chain No.	Average Pitch Inches	Capacity Dimension C			Weight Lbs. Nominal Pan Width = 1'-0" Dimension C			Add For Each Additional 1'-0" Width in Lbs.	Dimensions		
		4	5	6	4	5	6		G	B	M
RS658F	6.000	12.0	16.0	20.0	39	43	46	12.0	3/16	1 1/8	3/4
		12.0	16.0	20.0	43	47	50	16.0	1/4	1 3/16	3/4
		10.4	14.4	18.4	48	50	53	21.0	5/16	1 1/2	7/8
		10.4	14.4	18.4	52	54	57	25.0	3/8	1 9/16	7/8
RS622F	6.000	12.0	16.0	20.0	53	57	59	12.0	3/16	1 1/8	3/4
		12.0	16.0	20.0	57	61	63	16.0	1/4	1 3/16	3/4
		10.4	14.4	18.4	62	66	70	21.0	5/16	1 1/2	7/8
		10.4	14.4	18.4	66	70	74	25.0	3/8	1 9/16	7/8
RS922F	9.000	12.8	16.8	20.8	44	48	51	11.0	3/16	1 1/4	1
		12.8	16.8	20.8	48	51	55	14.5	1/4	1 5/16	1
		11.0	15.0	19.0	53	57	60	20.0	5/16	1 7/8	1 1/8
		11.0	15.0	19.0	57	61	64	24.0	3/8	1 15/16	1 1/8
RS933F	9.000	11.8	15.8	19.8	51	55	58	11.0	3/16	1 1/4	1
		11.8	15.8	19.8	55	58	61	14.5	1/4	1 5/16	1
		10.0	14.0	18.0	60	64	67	20.0	5/16	1 7/8	1 1/8
		10.0	14.0	18.0	64	68	71	24.0	3/8	1 15/16	1 1/8
RS944F	9.000	11.8	15.8	19.8	72	76	80	11.0	3/16	1 1/4	1
		11.8	15.8	19.8	75	79	84	14.5	1/4	1 5/16	1
		10.0	14.0	18.0	81	85	90	20.0	5/16	1 7/8	1 1/8
		10.0	14.0	18.0	84	89	94	24.0	3/8	1 15/16	1 1/8
RS1222F	12.000	13.8	17.8	21.8	40	43	46	10.0	3/16	1 3/8	1 1/4
		13.8	17.8	21.8	43	46	49	13.5	1/4	1 7/16	1 1/4
		12.7	16.7	20.7	47	50	53	18.0	5/16	1 3/4	1 1/2
		12.7	16.7	20.7	51	54	57	21.5	3/8	1 13/16	1 1/2
RS1233F	12.000	12.8	16.8	20.8	45	48	51	10.0	3/16	1 3/8	1 1/4
		12.8	16.8	20.8	48	51	54	13.5	1/4	1 7/16	1 1/4
		11.7	15.7	19.7	52	55	58	18.0	5/16	1 3/4	1 1/2
		11.7	15.7	19.7	56	59	62	21.5	3/8	1 13/16	1 1/2
RS1244F	12.000	12.8	16.8	20.8	62	66	70	10.0	3/16	1 3/8	1 1/4
		12.8	16.8	20.8	65	69	73	13.5	1/4	1 7/16	1 1/4
		11.7	15.7	19.7	69	73	77	18.0	5/16	1 3/4	1 1/2
		11.7	15.7	19.7	73	77	81	21.5	3/8	1 13/16	1 1/2

Capacity is in cubic feet per hour for a pan 1'-0" wide (80% full) traveling at 1'-0" per minute.
Weights are in pounds per foot for a pan 1'-0" wide.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Apron Conveyors
With Style A1 Pans



CHAIN DIMENSIONS

Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions				Pins	Sidebars		Rollers		
						Inside Sidebars	Outside Sidebars	℄To Cotter End	℄To Head or Rivet End	Dia.	Thk.	Height	Tread Dia.	Tread Width	℄ Chain To Wheel Ga.
				Dry	Lubed	W	W¹	K	J	D	T	U	H	A	L
RS658F	6.000	30,000	4,650	0.17	0.12	1⅝	2¹¹⁄₁₆	1²⁷⁄₃₂	1¹⁷⁄₃₂	⅝	¼	2	3	1⅛	⅜
RS622F	6.000	50,000	7,200	0.16	0.11	2	3⁹⁄₁₆	2⁹⁄₃₂	2¹⁄₃₂	¾	⅜	2	3½	1⁵⁄₁₆	⁷⁄₁₆
RS922F	9.000	50,000	7,200	0.16	0.11	2	3⁹⁄₁₆	2⁹⁄₃₂	2¹⁄₃₂	¾	⅜	2	3½	1⁵⁄₁₆	⁷⁄₁₆
RS933F	9.000	56,000	9,200	0.16	0.11	2¼	3¹³⁄₁₆	2¹⁵⁄₃₂	2⁵⁄₃₂	⅞	⅜	2½	4	1⁹⁄₁₆	¹⁷⁄₃₂
RS944F	9.000	90,000	12,700	0.14	0.10	2⅝	4¹¹⁄₁₆	2²⁷⁄₃₂	2¹⁹⁄₃₂	1	½	2½	5	1¾	¹⁹⁄₃₂
RS1222F	12.000	50,000	7,200	0.16	0.11	2	3⁹⁄₁₆	2⁹⁄₃₂	2¹⁄₃₂	¾	⅜	2	3½	1⁵⁄₁₆	⁷⁄₁₆
RS1233F	12.000	56,000	9,200	0.16	0.11	2¼	3¹³⁄₁₆	2¹⁵⁄₃₂	2⁵⁄₃₂	⅞	⅜	2½	4	1⁹⁄₁₆	¹⁷⁄₃₂
RS1244F	12.000	90,000	12,700	0.14	0.10	2⅝	4¹¹⁄₁₆	2²⁷⁄₃₂	2¹⁹⁄₃₂	1	½	2½	5	1¾	¹⁹⁄₃₂

Apron Conveyors
With Style A1 Pans

PAN CAPACITIES, WEIGHTS AND DIMENSIONS

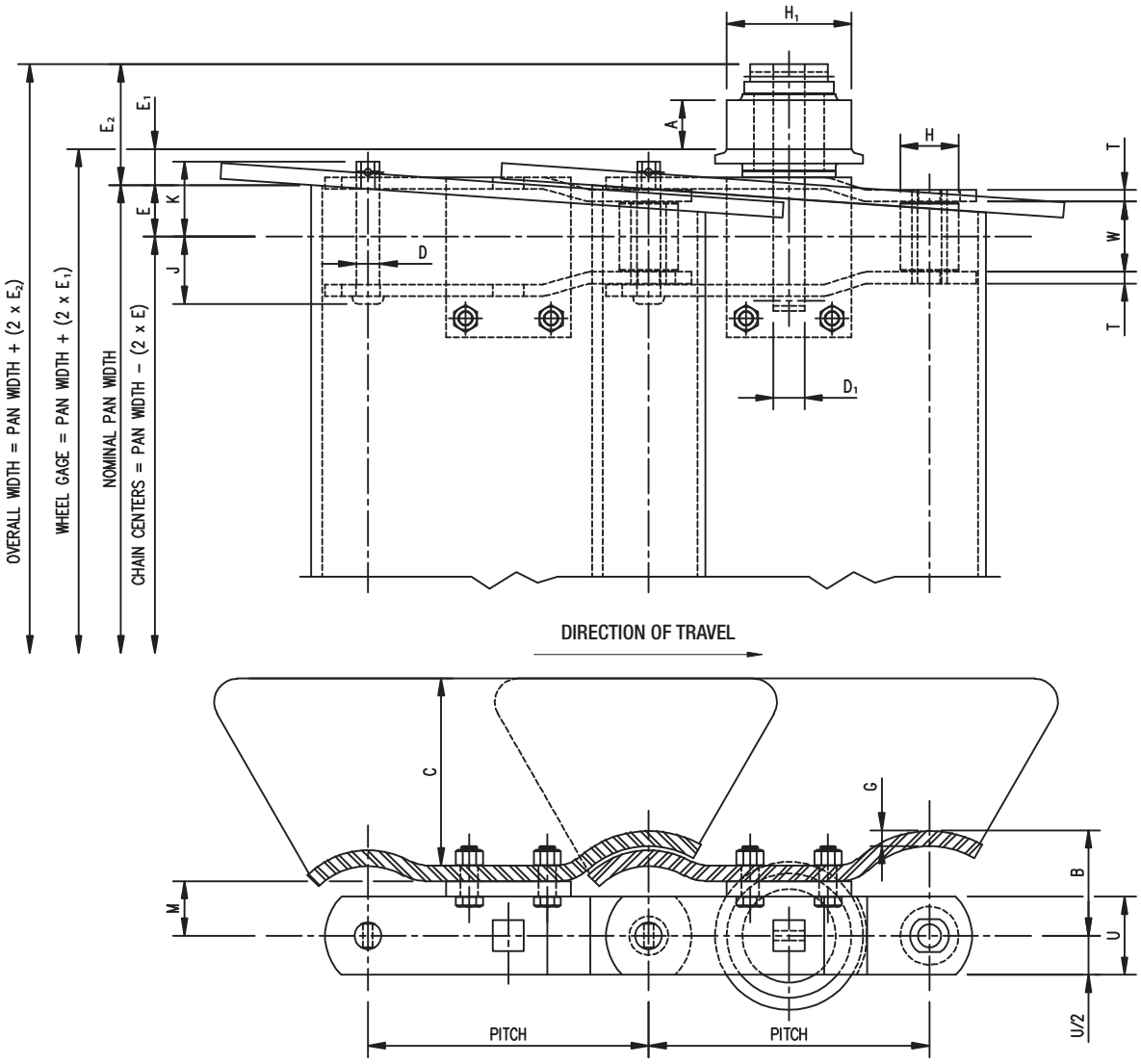
Chain No.	Average Pitch Inches	Capacity Dimension C			Weight Lbs. Nominal Pan Width = 1'-0" Dimension C			Add For Each Additional 1'-0" Width in Lbs.	Dimensions		
		4	5	6	4	5	6		G	B	M
RS658F	6.000	9.2	13.2	17.2	38	42	45	11.0	3/16	1 5/16	3/16
		9.2	13.2	17.2	41	45	48	14.5	1/4	1 3/8	3/16
		8.6	12.6	16.6	45	49	52	18.0	5/16	1 7/16	3/16
		8.6	12.6	16.6	48	52	55	21.0	3/8	1 1/2	3/16
RS622F	6.000	9.2	13.2	17.2	52	56	60	11.0	3/16	1 5/16	3/16
		9.2	13.2	17.2	56	59	64	14.5	1/4	1 3/8	3/16
		8.6	12.6	16.6	59	63	67	18.0	5/16	1 7/16	3/16
		8.6	12.6	16.6	62	66	70	21.0	3/8	1 1/2	3/16
RS922F	9.000	10.0	14.0	18.0	43	47	50	10.0	3/16	1 5/16	—
		10.0	14.0	18.0	47	50	53	13.0	1/4	1 3/8	—
		8.1	12.1	16.1	51	54	58	18.0	5/16	2 1/8	—
		8.1	12.1	16.1	54	58	61	21.0	3/8	2 3/16	—
RS933F	9.000	9.0	13.0	17.0	50	54	57	10.0	3/16	1 5/16	—
		9.0	13.0	17.0	53	57	60	13.0	1/4	1 3/8	—
		7.1	11.1	15.1	58	61	65	18.0	5/16	2 1/8	—
		7.1	11.1	15.1	61	65	68	21.0	3/8	2 3/16	—
RS944F	9.000	9.0	13.0	17.0	71	75	80	10.0	3/16	1 5/16	—
		9.0	13.0	17.0	74	78	83	13.0	1/4	1 3/8	—
		7.1	11.1	15.1	78	83	87	18.0	5/16	2 1/8	—
		7.1	11.1	15.1	81	86	91	21.0	3/8	2 3/16	—
RS1222F	12.000	8.7	12.7	16.7	46	49	53	17.0	5/16	2 1/8	—
		8.7	12.7	16.7	50	53	57	20.5	3/8	2 3/16	—
RS1233F	12.000	7.7	11.7	15.7	52	55	58	17.0	5/16	2 1/8	—
		7.7	11.7	15.7	56	59	62	20.5	3/8	2 3/16	—
RS1244F	12.000	7.7	11.7	15.7	68	72	77	17.0	5/16	2 1/8	—
		7.7	11.7	15.7	72	76	81	20.5	3/8	2 3/16	—

Capacity is in cubic feet per hour for a pan 1'-0" wide (80% full) traveling at 1'-0" per minute.
Weights are in pounds per foot for a pan 1'-0" wide.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Leakproof Apron Conveyors

With Style A Pans and Outboard Rollers



CHAIN DIMENSIONS

Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions			Pins	Sidebars		Chain Roller Dia.	Outboard Rollers					
						Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Thk.	Height		Tread Dia.	Tread Width	Stub Shaft	℄ To Inside Pan End	Inside Pan To Wheel Ga.	Inside Pan To Overall Width
				Dry	Lubed	W	K	J	D	T	U	H	H_1	A	D_1	E	E_1	E_2
SS944+	6.000	73,000	5,900	0.14	0.10	1½	2 1/32	1 25/32	¾	⅜	2	1⅞	4	1 5/16	¾	1	1¼	3⅜
RS928	9.000	50,000	7,200	0.14	0.10	2	2 9/32	2 1/32	¾	⅜	2	1⅞	4	1 5/16	¾	1¼	1¼	3⅜
RS938	9.000	56,000	9,200	0.14	0.10	2¼	2 15/32	2 5/32	⅞	⅜	2½	1⅞	5	1¾	1	1⅜	1 7/16	4⅛
RS946	9.000	85,000	12,700	0.14	0.10	2⅝	2 27/32	2 19/32	1	½	2½	2¼	5	1¾	1	1 3/16	1 7/16	4⅛
RS1228	12.000	50,000	7,200	0.14	0.10	2	2 9/32	2 1/32	¾	⅜	2	1⅞	4	1 5/16	¾	1¼	1¼	3⅜
RS1238	12.000	56,000	9,200	0.14	0.10	2¼	2 15/32	2 5/32	⅞	⅜	2½	1⅞	5	1¾	1	1⅜	1 7/16	4⅛
RS1246	12.000	125,000	12,700	0.14	0.10	2⅝	2 27/32	2 19/32	1	½	2½	2¼	5	1¾	1	1 13/16	1 7/16	4⅛

Leakproof Apron Conveyors
With Style A Pans and Outboard Rollers

PAN CAPACITIES, WEIGHTS AND DIMENSIONS

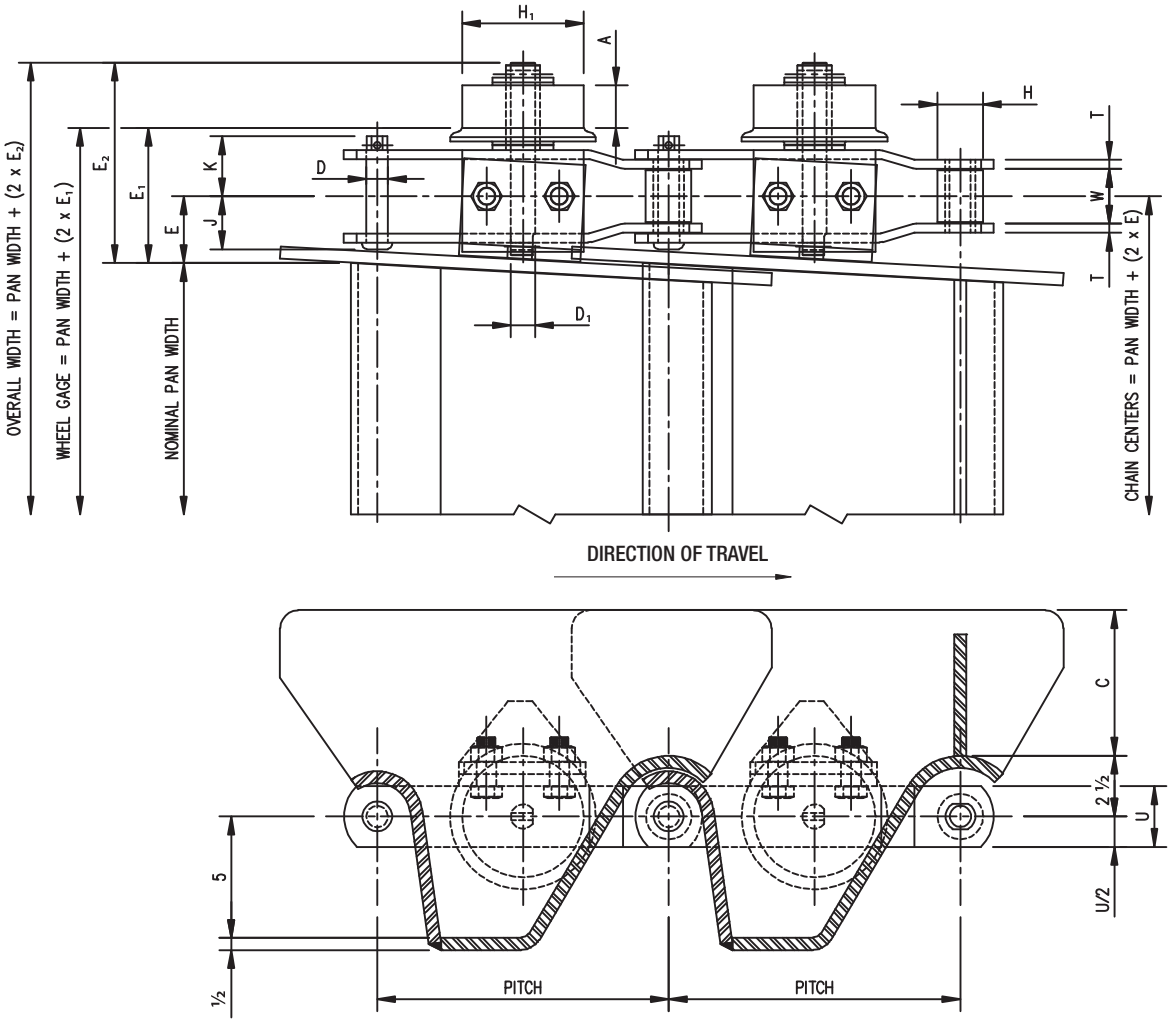
Chain No.	Average Pitch Inches	Capacity Dimension C			Weight Lbs. Nominal Pan Width = 1'-0" Dimension C			Add For Each Additional 1'-0" Width in Lbs.	Dimensions		
		4	5	6	4	5	6		G	B	M
SS944+	6.000	15.0	19.0	23.0	60	62	66	11.0	3/16	2 5/16	1 3/8
		15.0	19.0	23.0	66	70	76	15.0	1/4	2 3/8	1 3/8
		15.0	19.0	23.0	73	78	84	18.5	5/16	2 9/16	1 3/8
		15.0	19.0	23.0	80	85	93	22.5	3/8	2 5/8	1 3/8
RS928	9.000	15.0	19.0	23.0	47	49	52	10.0	3/16	2 1/4	1 1/4
		15.0	19.0	23.0	52	55	60	13.0	1/4	2 5/16	1 1/4
		15.0	19.0	23.0	57	63	68	17.0	5/16	2 11/16	1 1/4
		15.0	19.0	23.0	65	70	76	20.0	3/8	2 3/4	1 1/4
RS938	9.000	15.0	19.0	23.0	65	68	71	11.0	3/16	2 3/4	1 3/4
		15.0	19.0	23.0	71	75	79	14.5	1/4	2 13/16	1 3/4
		15.0	19.0	23.0	76	81	86	17.5	5/16	3	1 3/4
		15.0	19.0	23.0	83	88	94	21.0	3/8	3 1/16	1 3/4
		15.0	19.0	23.0	96	103	111	29.0	1/2	3 3/8	1 3/4
RS946	9.000	15.0	19.0	23.0	76	78	81	11.0	3/16	2 3/4	1 3/4
		15.0	19.0	23.0	82	85	89	14.5	1/4	2 13/16	1 3/4
		15.0	19.0	23.0	86	92	97	17.5	5/16	3	1 3/4
		15.0	19.0	23.0	94	99	105	21.0	3/8	3 1/16	1 3/4
		15.0	19.0	23.0	107	114	122	29.0	1/2	3 3/8	1 3/4
RS1228	12.000	15.0	19.0	23.0	57	60	62	10.0	3/16	2 3/4	1 3/4
		15.0	19.0	23.0	63	66	70	13.5	1/4	2 13/16	1 3/4
		15.0	19.0	23.0	69	73	77	16.5	5/16	3 1/8	1 3/4
		15.0	19.0	23.0	74	79	84	20.0	3/8	3 3/16	1 3/4
		15.0	19.0	23.0	86	92	99	26.5	1/2	3 1/2	1 3/4
RS1238	12.000	15.0	19.0	23.0	69	71	74	10.0	3/16	2 3/4	1 3/4
		15.0	19.0	23.0	74	78	81	13.5	1/4	2 13/16	1 3/4
		15.0	19.0	23.0	80	84	88	16.5	5/16	3 1/8	1 3/4
		15.0	19.0	23.0	86	90	96	20.0	3/8	3 3/16	1 3/4
		15.0	19.0	23.0	95	102	108	26.5	1/2	3 1/2	1 3/4
RS1246	12.000	15.0	19.0	23.0	80	82	85	10.0	3/16	2 3/4	1 3/4
		15.0	19.0	23.0	86	89	92	13.5	1/4	2 13/16	1 3/4
		15.0	19.0	23.0	91	95	99	16.5	5/16	3 1/8	1 3/4
		15.0	19.0	23.0	97	102	107	20.0	3/8	3 3/16	1 3/4
		15.0	19.0	23.0	108	115	122	26.5	1/2	3 1/2	1 3/4

Capacity is in cubic feet per hour for a pan 1'-0" wide (80% full) traveling at 1'-0" per minute.

Weights are in pounds per foot for a pan 1'-0" wide and include outboard rollers with stub shafts every 2nd pitch for 6" and 9" pitch and every pitch for 12" pitch.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Leakproof Apron Conveyors
With Style C Pans and Outboard Rollers



G
PAGE G-12

CHAIN DIMENSIONS

Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions			Pins	Sidebars		Chain Roller Dia.	Outboard Rollers					
						Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Thk.	Height		Tread Dia.	Tread Width	Stub Shaft	℄ To Inside Pan End	Inside Pan To Wheel Ga.	Inside Pan To Overall Width
				Dry	Lubed	W	K	J	D	T	U	H	H_1	A	D_1	E	E_1	E_2
RS1238	12.000	56,000	9,200	0.14	0.10	2¼	2 15/32	2 5/32	⅞	⅜	2½	1⅞	5	1¾	1	2¾	5 9/16	8¼
RS1246	12.000	125,000	12,700	0.14	0.10	2⅝	2 27/32	2 19/32	1	½	2½	2¼	5	1¾	1	3 3/16	6 7/16	9⅛

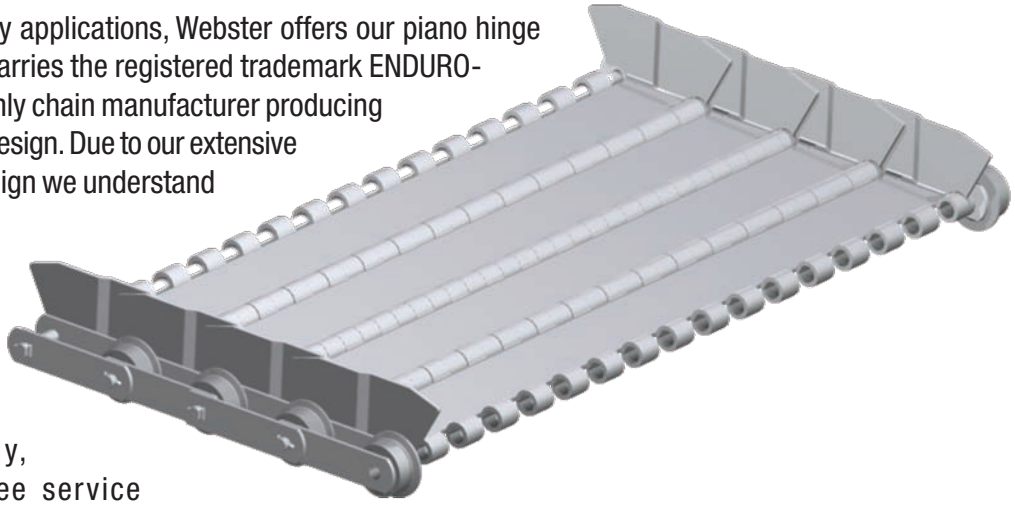
PAN CAPACITIES, WEIGHTS AND DIMENSIONS

Chain No.	Average Pitch Inches	Capacity			Weight Lbs. Nominal Pan Width = 1'-0"			Add For Each Additional 1'-0" Width in Lbs.
		Dimension C			Dimension C			
		4	5	6	4	5	6	
RS1238	12.000	23.0	31.0	39.0	119	130	142	40.0
RS1246	12.000	23.0	31.0	39.0	131	142	154	40.0

Capacity is in cubic feet per hour for a pan 1'-0" wide (80% full) traveling at 1'-0" per minute.
Weights are in pounds per foot for a pan 1'-0" wide and include outboard rollers with stub shafts every pitch.

ENDURO-FLITE®

Formed Piano Hinge Apron Conveyors



For light to medium-duty applications, Webster offers our piano hinge apron conveyor which carries the registered trademark ENDURO-FLITE®. Webster is the only chain manufacturer producing the formed piano hinge design. Due to our extensive background in chain design we understand the importance of controlling pitch tolerance and hole quality. ENDURO-FLITE® components share both load and wear factors evenly, providing trouble free service to your material handling operation. ENDURO-FLITE® is available with formed hinges in both 6" and 9" pitch and with welded hinges in 12" pitch.

MATERIAL

Pans and wings are mild steel. Sidebars are medium carbon steel. Thru rods are alloy steel. Bushings are furnished in case hardened steel to provide maximum wear resistance and chain life. Rollers are WEBLOY for increased life. Rollers can also be furnished in Duramal with needle bearings to reduce friction and further extend chain life.

ASSEMBLY

ENDURO-FLITE® conveyors are cottered construction. Thru rods are also available threaded with locknuts as well as drilled for lubrication.

INTERCHANGEABILITY

ENDURO-FLITE® chain components, pans and wings are fully interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

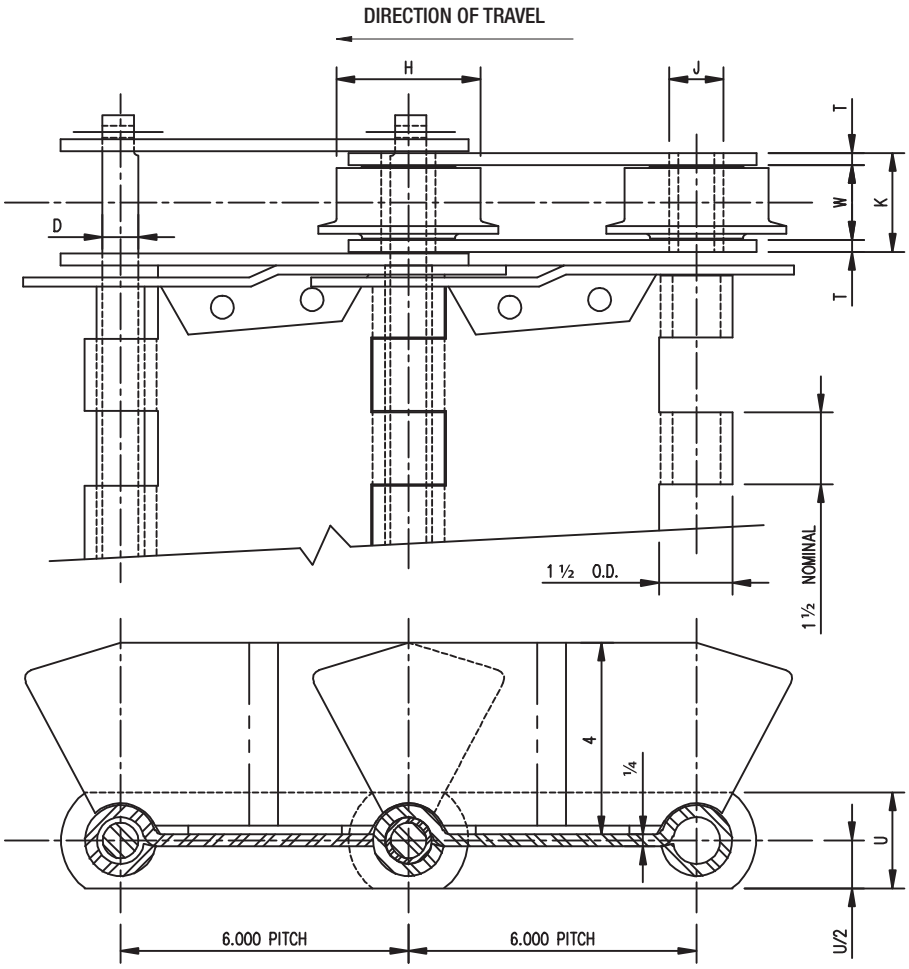
ENDURO-FLITE® conveyors are used in stamping plants, recycling facilities and other industries where a lightweight, yet rugged, conveyor is required. Pans can be furnished dimpled, perforated or both for applications where a nonstick surface or drainage is needed.

OPERATION

ENDURO-FLITE® conveyors are best suited for slow or moderate speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

ENDURO-FLITE®

6" Pitch

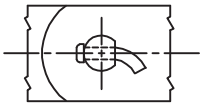


CHAIN DIMENSIONS

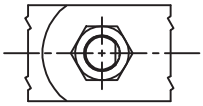
Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions				Pins	Sidebars		Rollers		
						Inside Sidebars	Bushing Outside Dia.	Bushing Length	Roller Ga.	Dia.	Thk.	Height	Tread Dia.	Tread Width	℄ Chain To Wheel Ga.
				Dry	Lubed	W	J	K	M	D	T	U	H	N	L
614P	6.000	32,000	4,600	0.23	0.16	1¼	1⅛	1¾	□□□	¾	¼	2	2½	1 1/16	□□□
624F	6.000	32,000	5,400	0.19	0.13	1 9/16	1⅛	2 1/16	31/32	¾	¼	2	3	1 1/16	11/32
625F	6.000	32,000	5,400	□□	0.05	1 9/16	1⅛	2 1/16	31/32	¾	¼	2	3	1 1/16	11/32
634F	6.000	50,000	7,200	0.14	0.10	2	1⅛	2¾	1 11/32	¾	⅜	2	4	1 5/16	7/16
635F	6.000	50,000	7,200	□□	0.05	2	1⅛	2¾	1 11/32	¾	⅜	2	4	1 5/16	7/16

ENDURO-FLITE®
6" Pitch

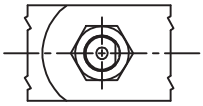
THRU RODS



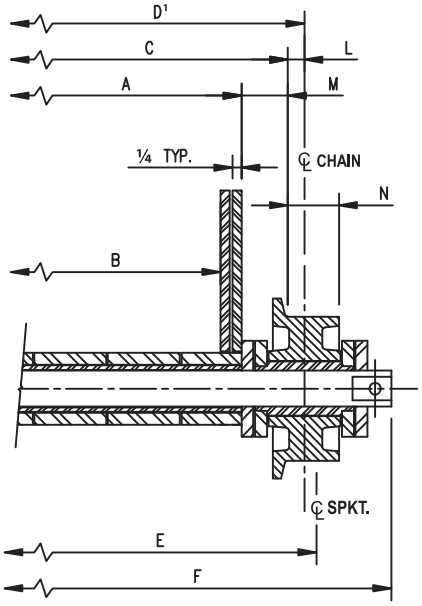
STYLE 3
COTTERED



STYLE 5
LOCKNUT



STYLE 5G
LOCKNUT LUBRICATED



BELT NUMBERING

6 250 T - A - 4 - 624F - 3

- Pitch
- Pan Thk.
- Tube Type
- Nom. Width
- Wing Ht.
- Chain No.
- Thru Rod Style

BELT DATA

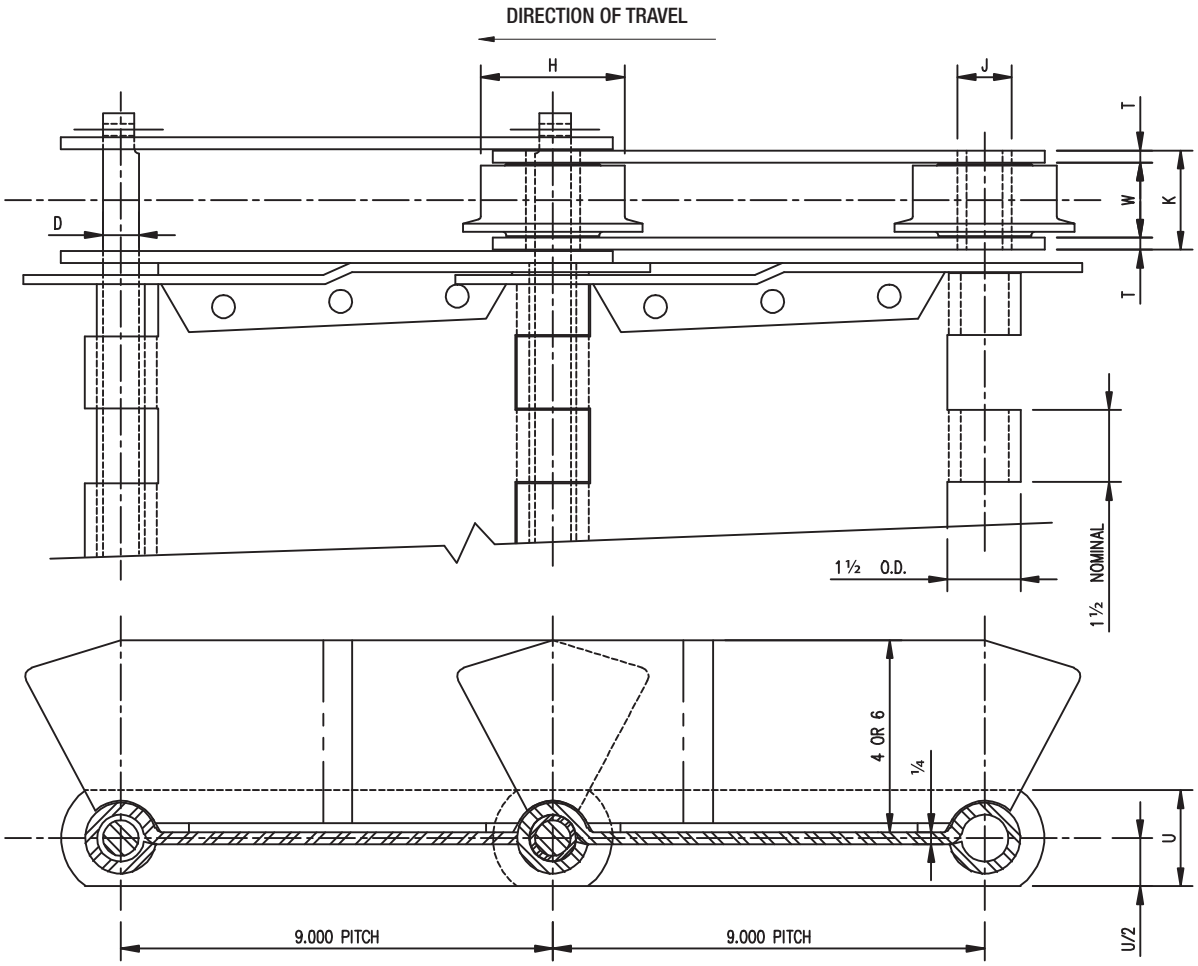
Chain No.	614P	624F	625F	634F	635F
A - Pan Width	12" to 96" Wide				
B - Inside Wings (3/16" Thick)	A - 13/16	A - 13/16	A - 13/16	A - 13/16	A - 13/16
B - Inside Wings (1/4" Thick)	A - 1 1/16	A - 1 1/16	A - 1 1/16	A - 1 1/16	A - 1 1/16
C - Roller Gage	N/A	A + 1 15/16	A + 1 15/16	A + 2 11/16	A + 2 11/16
D¹ - Chain Centers	A + 2 5/16	A + 2 5/8	A + 2 5/8	A + 3 9/16	A + 3 9/16
E - Sprocket Centers	A + 2 5/16	A + 3	A + 3	A + 4	A + 4
F - Overall Width	A + 5 3/8	A + 6 1/4	A + 6 1/4	A + 8 1/8	A + 8 1/8
Weight (Lbs./Ft.) 4" Wings (3/16" Thick)	24.5 + (A x 1.35)	27.5 + (A x 1.35)	27.5 + (A x 1.35)	46.5 + (A x 1.35)	46.5 + (A x 1.35)
Weight (Lbs./Ft.) 4" Wings (1/4" Thick)	27 + (A x 1.35)	30 + (A x 1.35)	30 + (A x 1.35)	49 + (A x 1.35)	49 + (A x 1.35)
Inner Tube	.970 O.D. x .780 I.D.				
Min. Reflex Radius 4" Wings	36"				

F Dimension (Overall Width) - Add 1/4" for Style 5 thru rod and 3/8" for Style 5G thru rod.
Standard wings are 1/4" thick, 3/16" available on request.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

ENDURO-FLITE®

9" Pitch

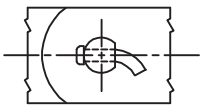


CHAIN DIMENSIONS

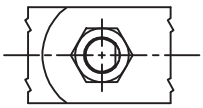
Chain No.	Average Pitch Inches	Average Ultimate Strength in Lbs. Per Strand	Rated Working Load in Lbs.☆ Per Strand	Friction Factor (f_r)		General Dimensions				Pins	Sidebars		Rollers		
						Inside Sidebars	Bushing Outside Dia.	Bushing Length	Roller Ga.	Dia.	Thk.	Height	Tread Dia.	Tread Width	℄ Chain To Wheel Ga.
				Dry	Lubed	W	J	K	M	D	T	U	H	N	L
914P	9.000	32,000	4,600	0.23	0.16	1¼	1⅛	1¾	□□□	¾	¼	2	2½	1 1/16	□□□
924F	9.000	32,000	5,400	0.19	0.13	1 9/16	1⅛	2 1/16	31/32	¾	¼	2	3	1 1/16	11/32
925F	9.000	32,000	5,400	□□	0.05	1 9/16	1⅛	2 1/16	31/32	¾	¼	2	3	1 1/16	11/32
934F	9.000	50,000	7,200	0.14	0.10	2	1⅛	2¾	1 11/32	¾	⅜	2	4	1 5/16	7/16
935F	9.000	50,000	7,200	□□	0.05	2	1⅛	2¾	1 11/32	¾	⅜	2	4	1 5/16	7/16

ENDURO-FLITE®
9" Pitch

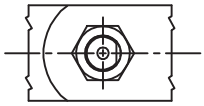
THRU RODS



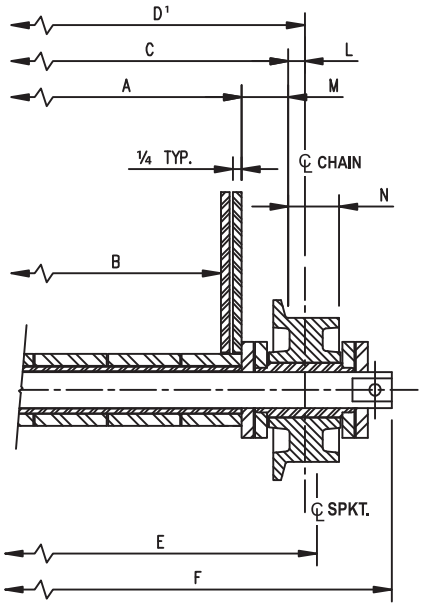
STYLE 3
COTTERED



STYLE 5
LOCKNUT



STYLE 5G
LOCKNUT LUBRICATED



BELT NUMBERING

9 250 T - A - 4 - 924F - 3

- 9 — Pitch
- 250 — Pan Thk.
- T — Tube Type
- A — Nom. Width
- 4 — Wing Ht.
- 924F — Chain No.
- 3 — Thru Rod Style

BELT DATA

Chain No.	914P	924F	925F	934F	935F
A - Pan Width	12" to 96" Wide				
B - Inside Wings (3/16" Thick)	A - 13/16	A - 13/16	A - 13/16	A - 13/16	A - 13/16
B - Inside Wings (1/4" Thick)	A - 1 1/16	A - 1 1/16	A - 1 1/16	A - 1 1/16	A - 1 1/16
C - Roller Gage	N/A	A + 1 15/16	A + 1 15/16	A + 2 11/16	A + 2 11/16
D¹ - Chain Centers	A + 2 5/16	A + 2 5/8	A + 2 5/8	A + 3 9/16	A + 3 9/16
E - Sprocket Centers	A + 2 5/16	A + 3	A + 3	A + 4	A + 4
F - Overall Width	A + 5 3/8	A + 6 1/4	A + 6 1/4	A + 8 1/8	A + 8 1/8
Weight (Lbs./Ft.) 4" Wings (3/16" Thick)	20.5 + (A x 1.35)	22.5 + (A x 1.35)	22.5 + (A x 1.35)	35.5 + (A x 1.35)	35.5 + (A x 1.35)
Weight (Lbs./Ft.) 4" Wings (1/4" Thick)	23 + (A x 1.35)	25 + (A x 1.35)	25 + (A x 1.35)	38 + (A x 1.35)	38 + (A x 1.35)
Weight (Lbs./Ft.) 6" Wings (3/16" Thick)	25.5 + (A x 1.35)	26.5 + (A x 1.35)	26.5 + (A x 1.35)	40.5 + (A x 1.35)	40.5 + (A x 1.35)
Weight (Lbs./Ft.) 6" Wings (1/4" Thick)	29 + (A x 1.35)	31 + (A x 1.35)	31 + (A x 1.35)	44 + (A x 1.35)	44 + (A x 1.35)
Inner Tube	.970 O.D. x .780 I.D.				
Min. Reflex Radius 4" Wings	30"				
Min. Reflex Radius 6" Wings	42"				

F Dimension (Overall Width) - Add 1/4" for Style 5 thru rod and 3/8" for Style 5G thru rod.
Standard wings are 1/4" thick, 3/16" available on request.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Flat Top Conveyor Chains

Flat top conveyor chains are used widely in the automotive industry for final assembly, mechanical or paint repair and water test or wash applications. They are also used for roll handling in paper mills. In addition to the standard design shown, Webster can design and build a flat top chain for your specific application needs.



MATERIAL
Top plates are mild steel. Sidebars are medium carbon steel. Thru rods are cold finished alloy steel. Inboard bushings and rollers and outboard bushings are carburized to provide maximum wear resistance and service life. Outboard rollers are furnished in various configurations of bearings, materials and heat treatment as shown below. Flat top chains can be furnished in stainless steel with UHMW outboard rollers for wet applications.

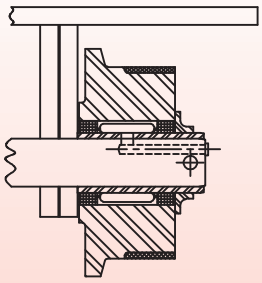
ASSEMBLY
Flat top conveyor chains are cottered construction.

INTERCHANGEABILITY
Flat top conveyor chains are made to order. However, chains used in the automotive industry are designed in accordance with the automaker's specifications and are interchangeable with other manufacturers.

APPLICATION
Flat top conveyor chains are primarily used for handling automobiles or paper rolls. Typically the conveyors are long and handling large or heavy loads requiring a heavy-duty chain as well as reduced rolling friction in the outboard rollers.

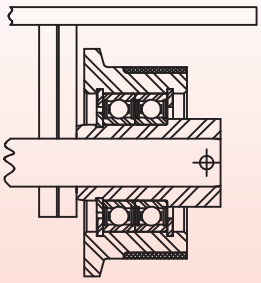
OPERATION
Flat top conveyor chains are best suited for slow speed applications. Eight tooth sprockets are most common with these chains. For Conveyor Service see Table 2, Section A.

OUTBOARD ROLLERS



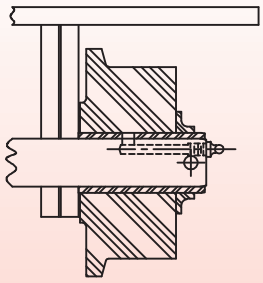
ROLLER STYLE
Roller bearing,
steel or Duramal roller with induction hardened tread.

FRICTION FACTOR
3" diameter roller .04
4" diameter roller .03



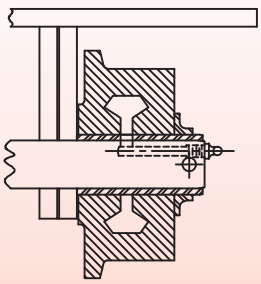
ROLLER STYLE
Double roll ball bearing,
steel or Duramal roller with induction hardened tread.

FRICTION FACTOR
3" diameter roller .03
4" diameter roller .025



ROLLER STYLE
Plain bearing,
UHMW polyethylene roller.

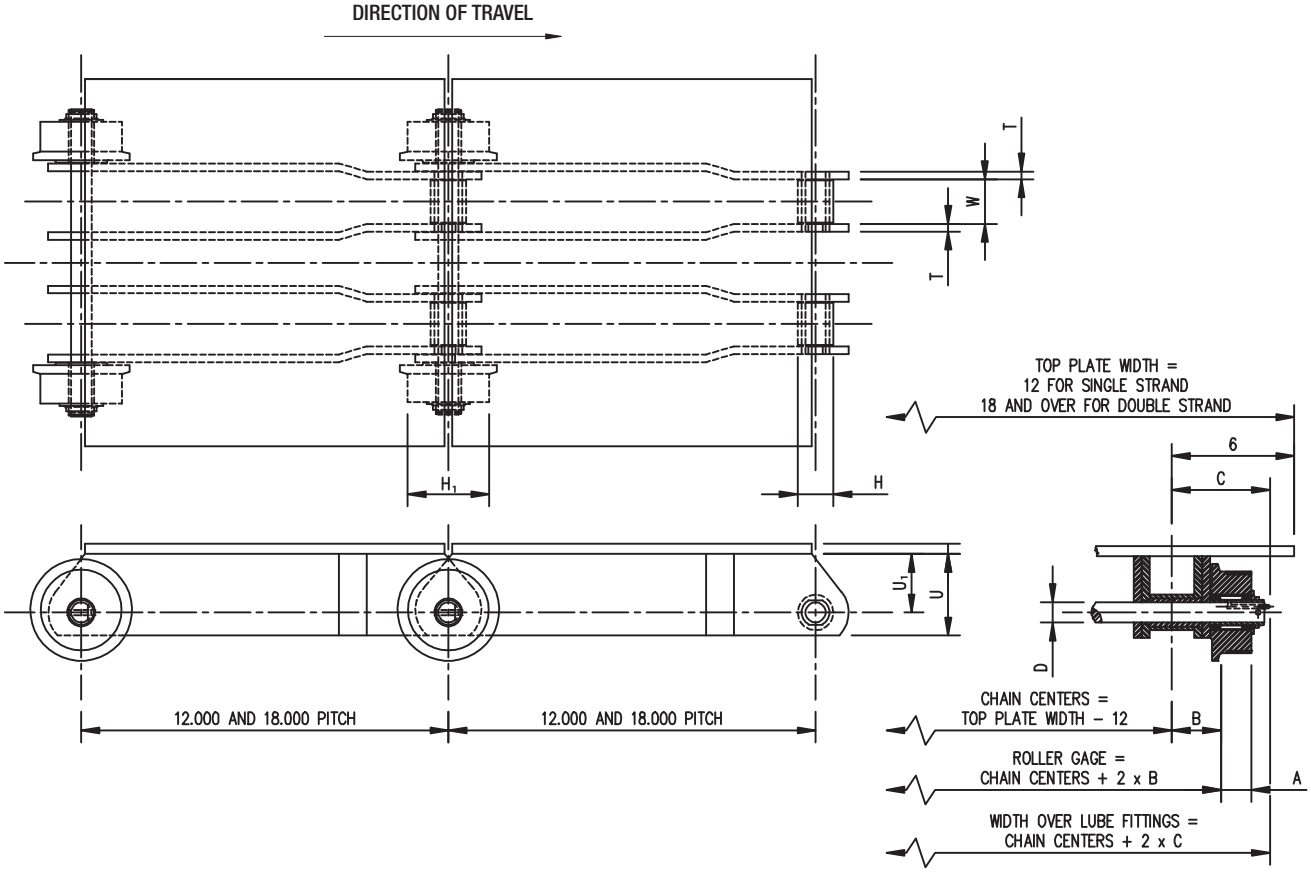
FRICTION FACTOR
3" diameter roller .06
4" diameter roller .05



ROLLER STYLE
Plain bearing,
white iron roller.

FRICTION FACTOR
3" diameter roller .15

Flat Top Conveyor Chains



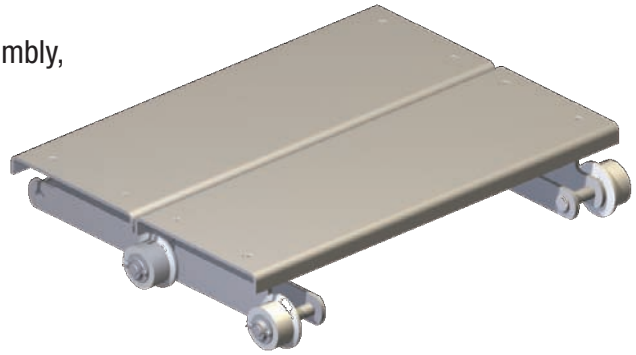
FLAT TOP DIMENSIONS

Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	Max. Load Per Outboard Roller	General Dimensions			Pins	Sidebars			Rollers		
			Inside Sidebars	℄ Chain To Roller Ga.	℄ Chain To Overall Width	Dia.	Thk.	Height	℄ To Top Plate	Inboard Dia.	Outboard Dia.	Outboard Tread Width
			W	B	C	D	T	U	U_1	H	H_1	A
64,000	8,230	3,500	1 15/16	2 5/16	4 5/8	7/8	3/8	3 1/2	2 3/8	1 3/4	3	1 3/8
								4	2 7/8		4	
61,000	8,750	5,000	1 3/4	2 1/4	4 9/16	1	3/8	3 1/2	2 1/4	1 3/4	3	1 3/8
								4	2 3/4		4	
56,000	9,400	5,000	1 15/16	2 3/8	4 25/32	1	3/8	4	2 7/8	1 7/8	4	1 1/2
85,000	12,850	7,500	1 15/16	2 9/16	5	1 1/4	1/2	4	2 11/16	2 1/4	4	1 17/32

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Slat Top Conveyor Chains

Slat top conveyor chains are used widely in final assembly, mechanical paint repair and water test or wash applications. In addition to the standard design shown Webster can design and build a slat top chain for your specific application needs.



MATERIAL

Top plates are mild steel. Sidebars are medium carbon steel. Pins are medium carbon heat treated steel. Inboard bushings and rollers and outboard bushings are carburized to provide maximum wear resistance and service life. Outboard rollers are furnished in various configurations of bearings, materials and heat treatment as shown on page G-18. Slat top chains can be furnished in stainless steel with UHMW outboard rollers for wet applications.

ASSEMBLY

Slat top conveyor chains are cottered construction.

INTERCHANGEABILITY

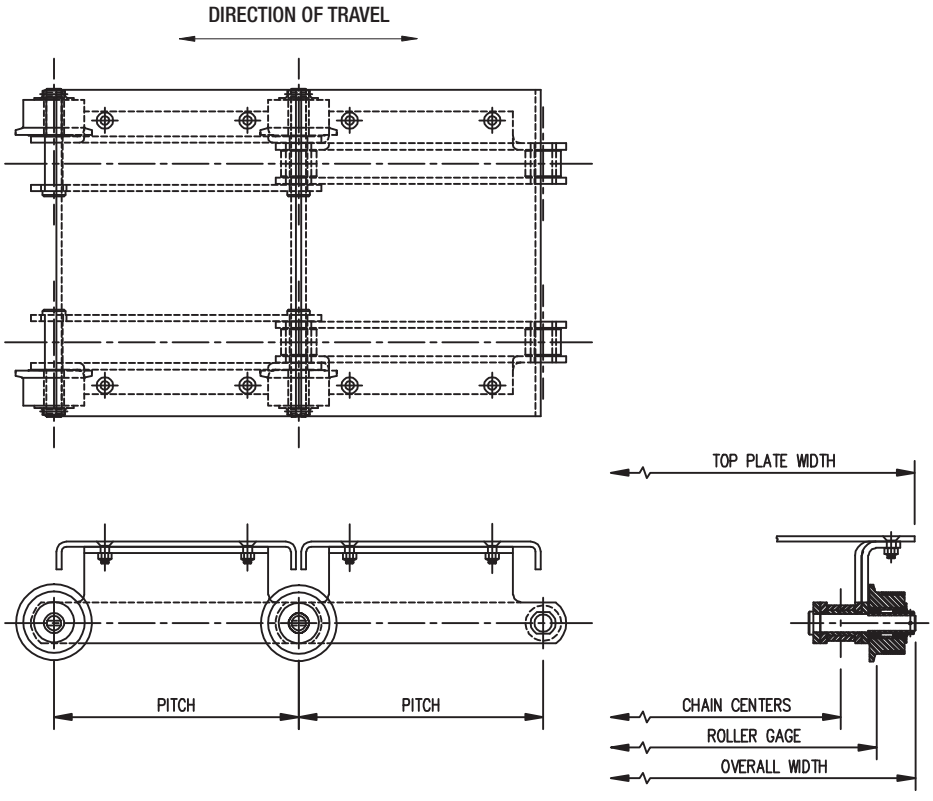
Slat top conveyor chains are made to order. However, chains used in the automotive industry are designed in accordance with the automaker's specifications and are interchangeable with other manufacturers.

APPLICATION

Slat top conveyor chains are primarily used for handling automobiles. Typically the conveyors are long and handling large or heavy loads requiring a heavy-duty chain as well as reduced rolling friction in the outboard rollers.

OPERATION

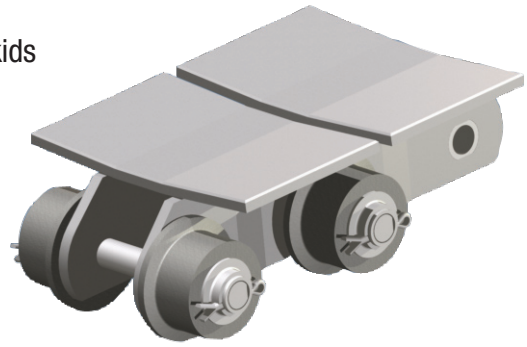
Slat top conveyor chains are best suited for slow speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.



Gull Wing Conveyor Chains

Automotive and Steel Rolls

Gull wing conveyor chains are used in transfer conveyors for skids with casters in the automotive industry. Larger versions are used for steel roll handling. The dimensions shown here can be changed to meet customer requirements and for special applications.



MATERIAL

Top plates are mild steel. Sidebars are medium carbon steel. Thru rods are cold finished alloy steel. Inboard bushings and rollers and outboard bushings are carburized to provide maximum wear resistance and service life. Outboard rollers are furnished in various configurations of bearings, materials and heat treatment as shown on page G-18.

ASSEMBLY

Gull wing conveyor chains are cottered construction.

INTERCHANGEABILITY

Gull wing conveyor chains are made to order. However, chains used in the automotive industry are designed in accordance with the automaker's specifications and are interchangeable with other manufacturers.

APPLICATION

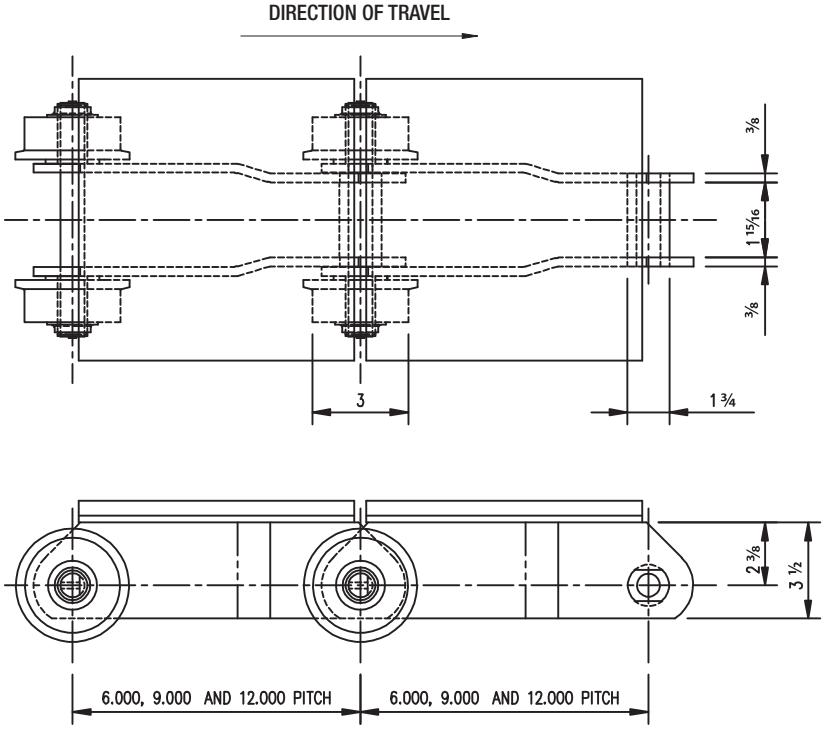
These gull wing conveyor chains are primarily used for handling automobiles or steel rolls. Typically the conveyors are long and handling large or heavy loads requiring a heavy-duty chain as well as reduced rolling friction in the outboard rollers.

OPERATION

Gull wing conveyor chains are best suited for slow speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

CHAIN SPECIFICATIONS

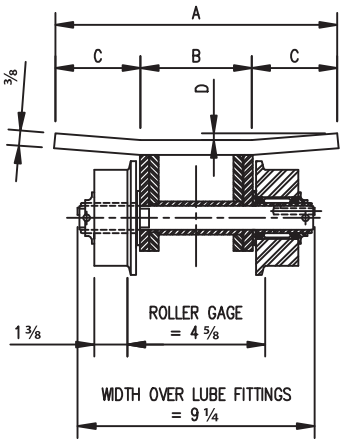
Rated Working Load: 8,230 Lbs.
Average Ultimate Strength: 64,000 Lbs.
Max. Roller Load: 3,500 Lbs.



Typical dimensions shown.

TOP PLATE DIMENSIONS

A	B	C	D
9	2	3½	¼
9	3	3	½
6½	3	1¾	15/32

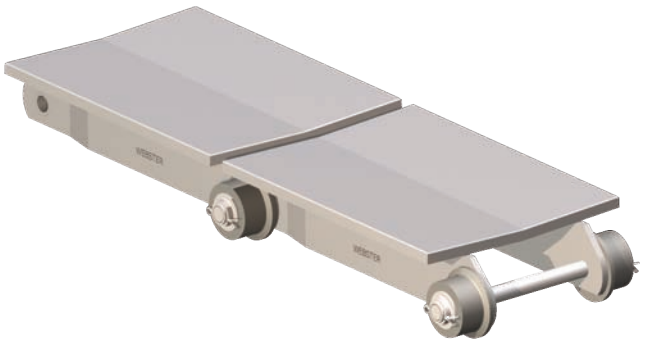


Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Gull Wing Conveyor Chains

Paper Rolls

Gull wing conveyor chains with V-shaped top plates are used almost exclusively to handle paper rolls. The outboard rollers have a wider wheel gage and provide more stability for the rolls.



MATERIAL

Top plates are mild steel. Sidebars are medium carbon steel. Thru rods are cold finished alloy steel. Inboard bushings and rollers and outboard bushings are carburized to provide maximum wear resistance and service life. Outboard rollers are furnished in various configurations of bearings, materials and heat treatment as shown on page G-18.

ASSEMBLY

Gull wing conveyor chains are cottered construction.

INTERCHANGEABILITY

Gull wing conveyor chains are made to order. However, chains used in the paper industry are designed in accordance with the user or OEM's specifications and are interchangeable with other manufacturers.

APPLICATION

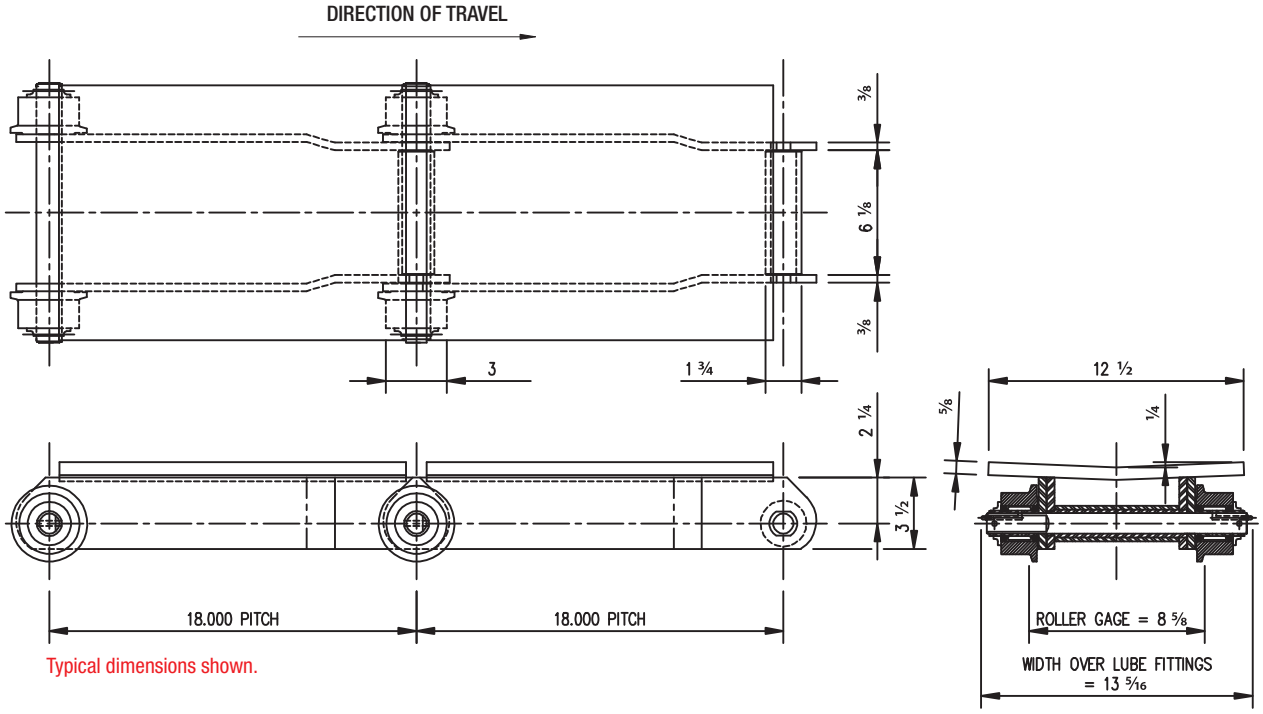
These gull wing conveyor chains are primarily used for handling paper rolls. Typically the conveyors are long and handling large or heavy loads requiring a heavy-duty chain as well as reduced rolling friction in the outboard rollers.

OPERATION

Gull wing conveyor chains are best suited for slow speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.

CHAIN SPECIFICATIONS

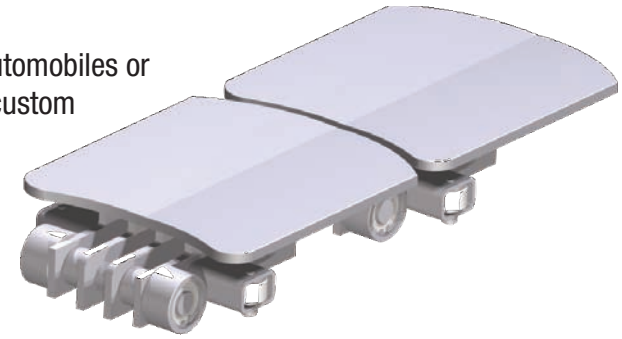
Rated Working Load: 12,000 Lbs.
Average Ultimate Strength: 71,500 Lbs.
Max. Roller Load: 5,000 Lbs.



Typical dimensions shown.

Horizontal Curve Conveyor Chains

Horizontal curve conveyor chains are used to transport automobiles or paper rolls through curves up to 180°. These chains are custom designed to suit the operating environment.



MATERIAL

Top plates are mild steel. Sidebars are medium carbon steel. Thru rods are heat treated alloy steel. Inboard bushings and rollers and outboard bushings are carburized to provide maximum wear resistance and service life. The application will determine the outboard roller configuration of bearings, materials and heat treatment.

ASSEMBLY

Horizontal curve conveyor chains are cottered construction.

INTERCHANGEABILITY

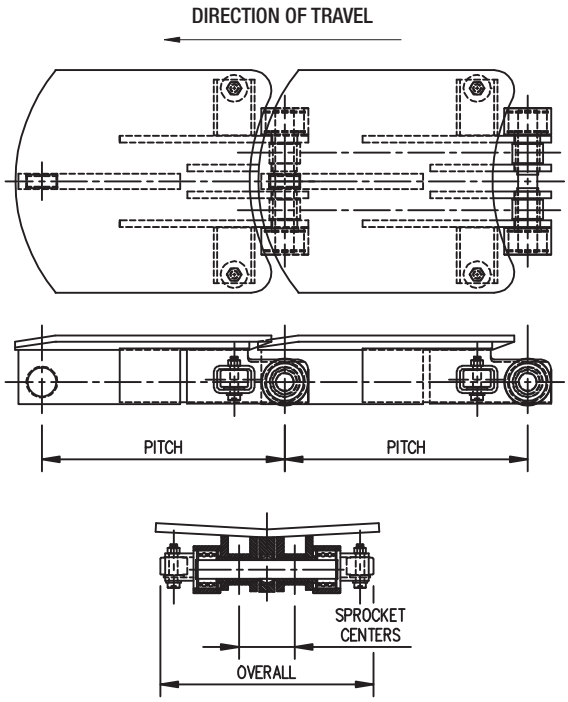
Horizontal curve conveyor chains are made to order. However, chains used in the automotive and paper industries are designed in accordance with the user or OEM's specifications and are interchangeable with other manufacturers.

APPLICATION

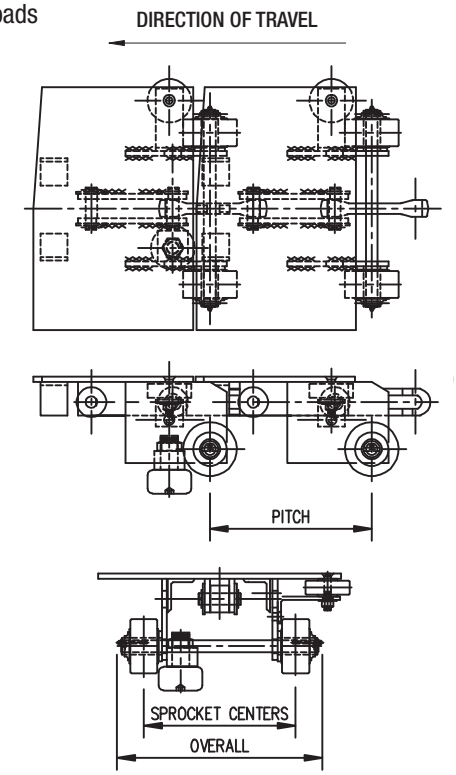
Horizontal curve conveyor chains are primarily used for handling automobiles or paper rolls. Typically the conveyors are long and handling large or heavy loads requiring a heavy-duty chain as well as reduced rolling friction in the outboard rollers.

OPERATION

Horizontal curve conveyor chains are best suited for slow speed applications. Maximum chain speed depends upon size of sprockets. For Conveyor Service see Table 2, Section A.



PAPER ROLLS

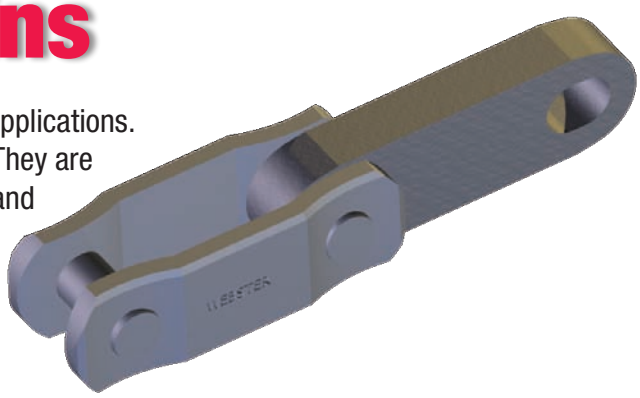


AUTOMOBILES

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

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

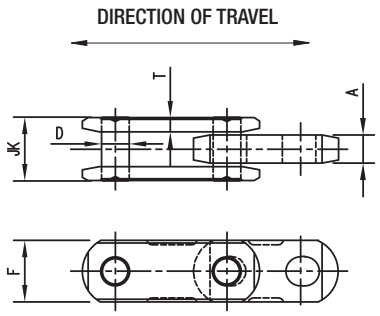
Double flex chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

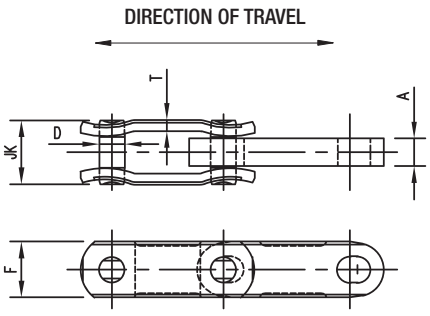
Double flex chains are primarily used in the dairy and forest product industries. The conveyors are usually multiple strands, moving boards and crates around corners.

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.



DF3498



DF3500

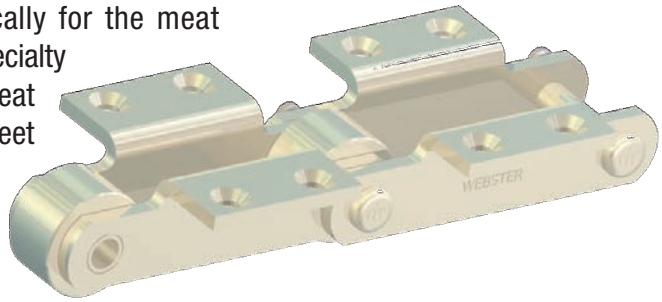
Chain No.	Average Pitch Inches	Average Weight Per Ft. Lbs.	Rated Working Load in Lbs.	General Dimensions					
				Overall Width JK	Max. Spkt. Width A	Sidebar Thickness T	Sidebar Height F	Pin Dia. D	Min. Flex Radius
DF3498	1.750 2.500	4.5	See Table Below	1 7/16	5/8	5/16	1 3/8	5/8	16
DF3500	2.500 3.000	3.3	See Table Below	1 1/2	5/8	1/4	1 1/4	9/16	20

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

Delrin Bushed Roller Chains

Delrin bushed roller chains are designed specifically for the meat processing industry. Stainless steel, zinc plated and specialty bushed parts provide excellent service without the threat of contamination. Special rollers can be furnished to meet customer requirements.



MATERIAL

Sidebars are zinc plated medium carbon steel. Pins are made of heat treated alloy steel that have been zinc plated for corrosion resistance. Chain bushings are heat treated stainless steel. Rollers are case hardened steel which have been zinc plated with a Delrin sleeve pressed in reducing friction and increasing corrosion resistance. Various stainless steels can be used for all components as the operating atmosphere requires.

ASSEMBLY

Delrin bushed chains are cottered construction with stainless steel cotters.

INTERCHANGEABILITY

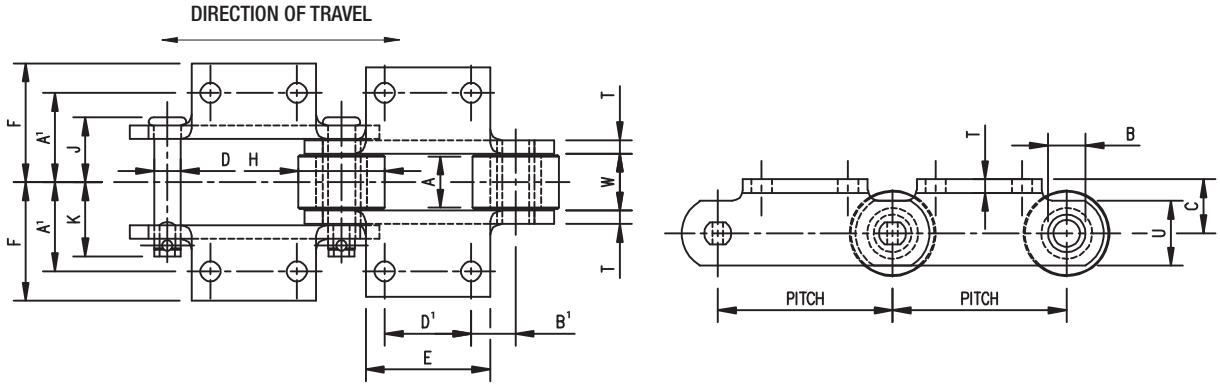
Delrin bushed chains are interchangeable with other standard makes of corresponding sizes and numbers.

APPLICATION

Delrin bushed chains are used in the meat industry predominantly in conveyors for visceration tables.

OPERATION

Delrin bushed chains are best suited for slow or moderate speed applications. 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			Pins	Sidebars		Bushings	Rollers	
						Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Thk.	Height	Outside Dia.	Tread Dia.	Tread Width
						W	K	J	D	T	U	B	H	A
S1113D	4.040	30	11.4	28,000	3,150	1 5/16	1 25/32	1 1/2	5/8	5/16	1 1/2	7/8	2	1 3/16
S1670D	6.000	20	9.0	28,000	3,150	1 5/16	1 25/32	1 1/2	5/8	5/16	1 1/2	7/8	2 1/4	1 3/16

K2 ATTACHMENT →→

Chain No.	A¹	B¹	C	D¹	E	F Max.	T	Weight Per Foot-Lbs. Δ	Bolt Size
S1113D	2 1/16	1 17/64	1 1/4	1 1/2	2 7/8	2 3/4	5/16	11.4	3/8
S1670D	2	2	1 3/8	2	3 1/2	2 5/8	5/16	9.0	3/8

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Traveling Water Screen Chains

Traveling water screen chains are specifically designed for water filtration. These chains are typically 24" pitch but are available in other sizes. They are designed to each application with a variety of stainless steel and plating options.



MATERIAL

Traveling water screen chains have medium carbon steel sidebars. Pins are heat treated medium carbon alloy steel which has been induction hardened for increased wear resistance. Bushings and rollers are case hardened steel for longer service life. Chains can be furnished in stainless steel or other corrosion resistant alloys to meet specific environments.

ASSEMBLY

Traveling water screen chains are cottered construction.

INTERCHANGEABILITY

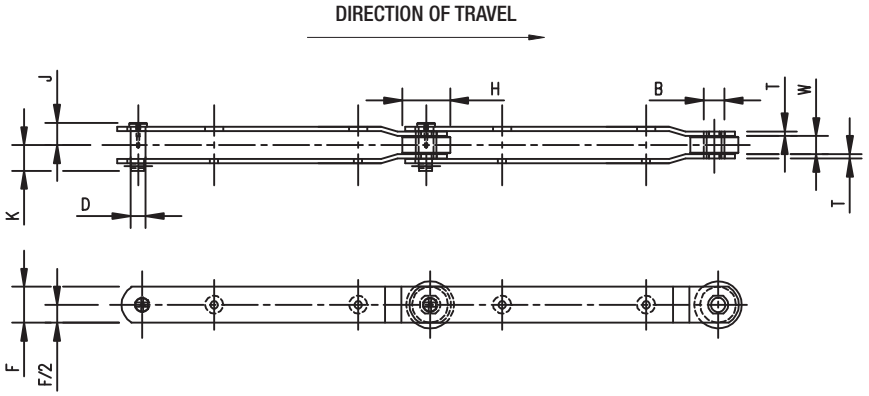
Traveling water screen chains are interchangeable with other standard makes of corresponding sizes and numbers. They can be custom designed to match the pitch, size or attachment required.

APPLICATION

Traveling water screen chains are used in water screening applications. They can be found in paper mills, steel mills, power generation plants or any other facility that consumes large quantities of water as part of their production process.

OPERATION

Traveling water screen chains are best suited for slow or intermittent speed applications. For Conveyor Service see Table 2, Section A.



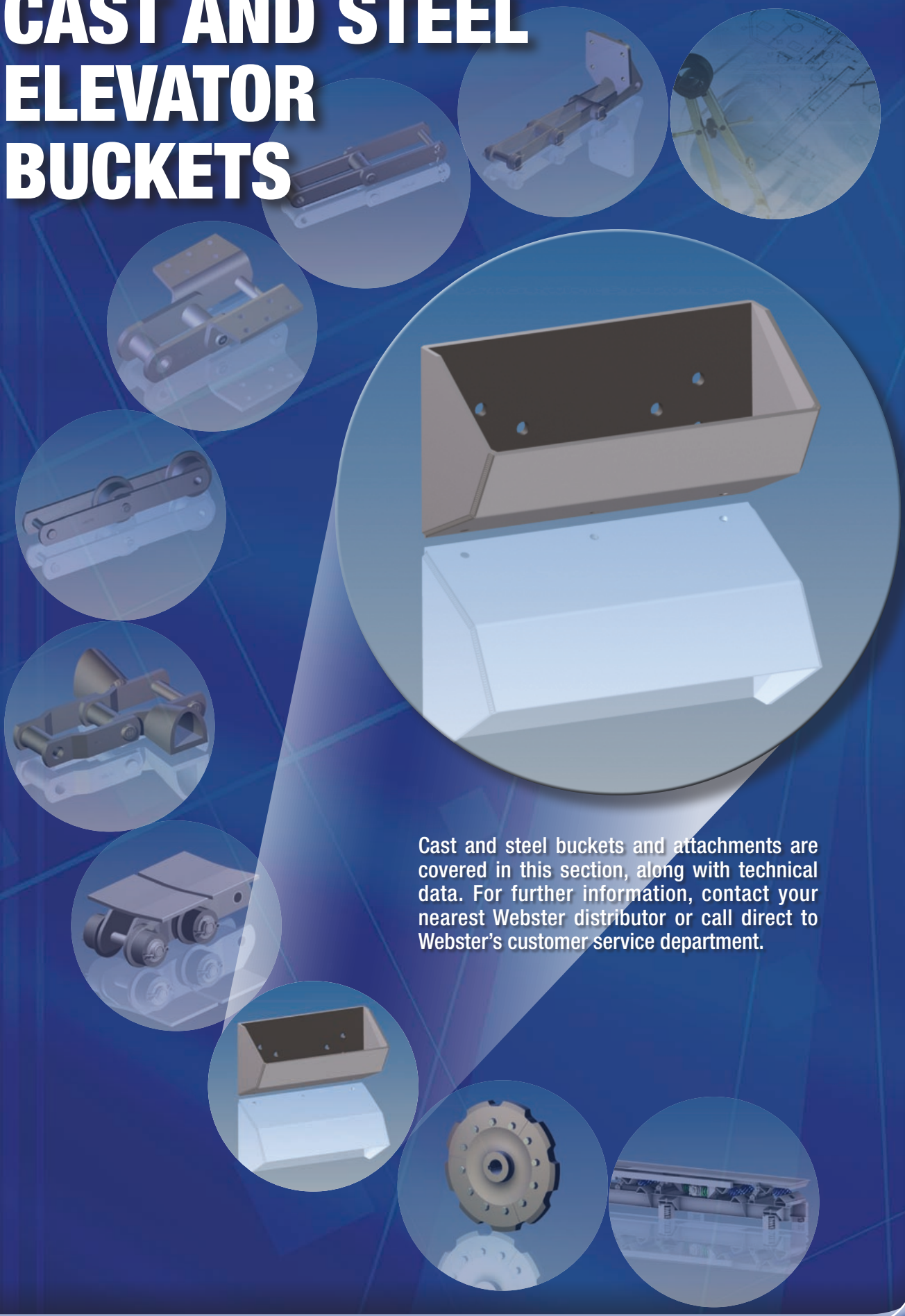
Chain No.	Average Pitch Inches	Average Weight Per Ft. Lbs.	Average Ultimate Strength in Lbs.	Rated Working Load in Lbs.☆	General Dimensions			Pins	Sidebars		Bushings	Rollers
					Inside Sidebars	℄ To Cotter End	℄ To Head or Rivet End	Dia.	Thk.	Height	Outside Dia.	Tread Dia.
					W	K	J	D	T	F	B	H
S15041A	24.000	12	65,000	9,850	1½	2 5/32	1 27/32	1¼	⅜	3	1¾	4
S13917	24.000	11	65,000	10,400	1⅝	2 7/32	1 29/32	1¼	⅜	2¾	1¾	3¾
S15030	24.000	11	65,000	10,665	1 11/16	2¼	1 15/16	1¼	⅜	2¾	1¾	3¾
S11524	24.000	14	86,000	11,760	1 11/16	2½	2 3/16	1¼	½	2¾	1¾	3¾

Notes

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

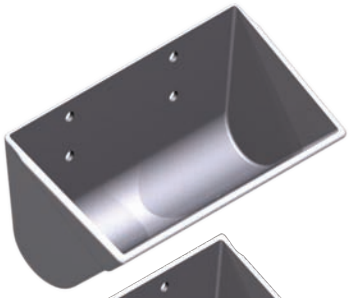
Notes

CAST AND STEEL ELEVATOR BUCKETS

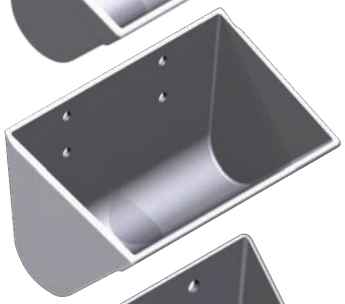


Cast and steel buckets and attachments are covered in this section, along with technical data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

Cast Elevator Buckets



STYLE AA



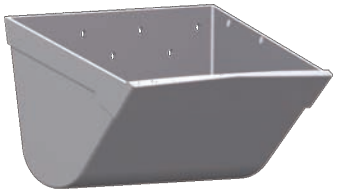
STYLE AA-RB



STYLE B



STYLE C



MODERN STYLE



STYLE SC



STYLE AC

Modern methods, technical experience, research and careful laboratory control of metals insure quality and quantity production of malleable iron buckets that resist abrasive wear, rust and corrosion.

Cast malleable iron elevator buckets are designed to fill properly in loading and to discharge freely and cleanly. They are smooth and seamless with reinforced corners which render them strong and extremely durable.

All Webster cast elevator buckets are also available in Duramal metal, a product developed to provide greater strength and greater resistance to abrasive wear. Specify Duramal elevator buckets for severe and abrasive service conditions. Zinc or other protective coatings can be applied to buckets.

STYLE AA cast elevator buckets are used for handling various materials such as coal, ash, sand, gravel and stone. Buckets are designed with a heavy reinforcing band which is cast along the front edge and corners for additional wear life.

STYLE AA-RB cast elevator buckets are used for handling heavy abrasive products under severe service and impact conditions. Buckets are designed similar to style AA with backs twice the normal thickness.

STYLE B cast elevator buckets are used on inclined elevators handling coarsely broken materials such as coke, stone, ore, etc. Clean discharge at relatively slow speeds is made possible by the low front design.

STYLE C cast elevator buckets are designed to handle materials which tend to stick or pack in buckets such as clay, sugar, salt, wet grain and finely pulverized wet ore.

MODERN STYLE cast elevator buckets are used primarily for handling fertilizer and materials which require buckets of maximum strength. Buckets are strongest where the strain is the heaviest with extra thickness where wear is the greatest. Front lips have heavy cutting edge for digging and backs have reinforcing ribs for added strength.

STYLE SC cast elevator buckets were designed primarily for handling foundry sand. Buckets have an extra heavy body with a reinforcing band cast along front edge and around ends for added strength.

STYLE AC cast elevator buckets provide fast, thorough discharge of cement, lime, and other dry or free-flowing fine materials. Vent holes in the bottom of each bucket release air trapped in filling and allow material to empty from bucket quickly and completely on discharge.

Steel Elevator Buckets

Modern manufacturing methods and technical expertise insure quality and quantity production of fabricated steel buckets for the application required.

Steel elevator buckets are laser cut from plates and robotically welded in our fabrication department to insure quality manufacturing and a precise match with the mating chain attachment.

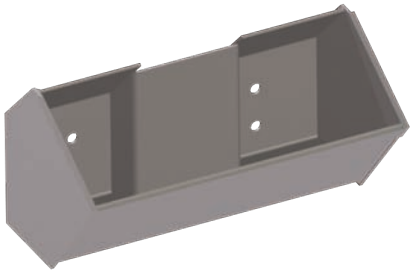
Steel elevator buckets are available in a variety of materials with numerous options such as hardface welding or wear lips to resist abrasion. Steel elevator buckets are available for nearly any application.

STYLE ACS steel elevator buckets are designed for high capacity when handling free-flowing fine materials. Welded steel buckets feature a wraparound design with much of the load in dual compartments. The recessed back, for chain mounting, provides additional strength and durability.

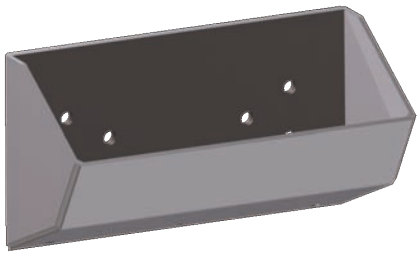
STYLE HC steel elevator buckets are designed primarily for handling cement and other free-flowing materials in centrifugal discharge elevators operating at higher than normal speeds. These buckets are welded construction and made of heavy gauge steel.

SUPER CAPACITY STYLE steel elevator buckets are designed to handle greater capacities and larger lumps than ordinary continuous style buckets. Buckets are mounted between two strands of chain with the back of the buckets extending beyond the chain centerline. This results in greater carrying capacity. These buckets are made in two styles: Vertical Regular and Vertical Overlapping.

CONTINUOUS STYLE steel elevator buckets are used for handling gritty or bulky materials such as sand, stone, gravel, coal and ore at slow speeds or light, pulverized, free-flowing fine materials which will not discharge properly at higher speeds. The flanged front forms a chute for the clean discharge from each succeeding bucket.



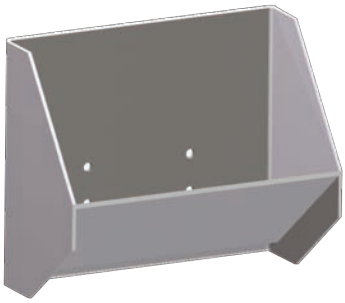
STYLE ACS



STYLE HC



SUPER CAPACITY STYLE



CONTINUOUS STYLE

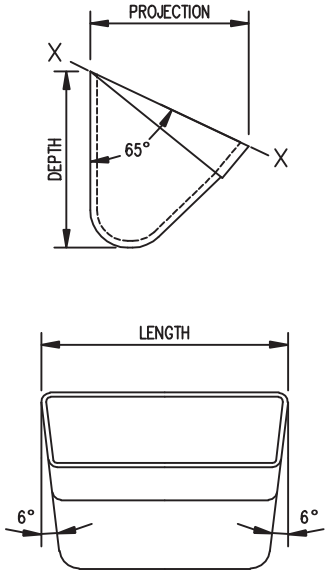
Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Cast Elevator Buckets

Styles - AA and B

STYLE AA

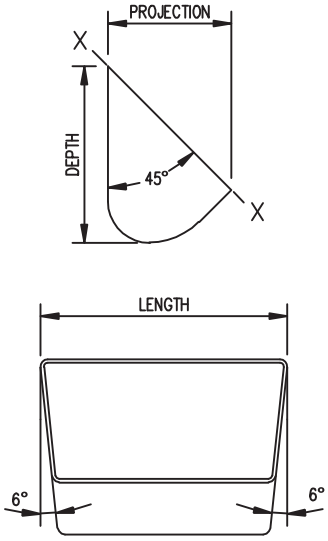
Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.
	Length	Projection	Depth		
4 x 2¾	4	2¾	3	.016	1.0
5 x 3½	5	3½	3¾	.02	1.5
6 x 4	6	4	4½	.03	3.0
7 x 4½	7	4½	5	.05	3.5
8 x 5	8	5	5½	.07	5.0
9 x 6	9	6	6¼	.11	6.5
10 x 6	10	6	6¼	.12	8.0
11 x 6	11	6	6¼	.13	9.0
12 x 6	12	6	6¼	.14	9.4
12 x 7	12	7	7¼	.19	12.0
14 x 7	14	7	7¼	.23	14.0
15 x 7	15	7	7¼	.25	14.8
16 x 7	16	7	7¼	.27	16.0
14 x 8	14	8	8½	.30	19.0
16 x 8	16	8	8½	.34	22.0
18 x 8	18	8	8½	.39	24.0
20 x 8	20	8	8½	.44	26.0
24 x 8	24	8	8½	.57	32.0
18 x 10	18	10	10½	.61	36.0
24 x 13	24	13	12¾	1.10	50.0



STYLE AA

STYLE B

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.
	Length	Projection	Depth		
7 x 3½	7	3½	5	.03	2.5
8 x 3½	8	3½	5	.04	3.0
10 x 4	10	4	5½	.06	5.0
12 x 5½	12	5½	7½	.14	7.0
16 x 6½	16	6½	9	.24	14.0



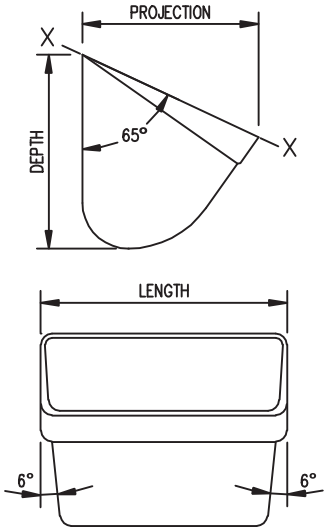
STYLE B

Cast Elevator Buckets

Styles - AA-RB and C

STYLE AA-RB

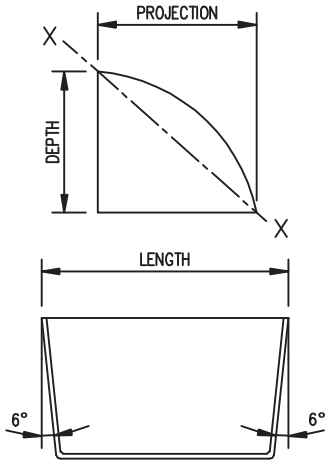
Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.
	Length	Projection	Depth		
8 x 5	8	5	5½	.07	5.5
10 x 6	10	6	6¼	.12	9.5
11 x 6	11	6	6¼	.13	10.0
12 x 6	12	6	6¼	.14	11.0
12 x 7	12	7	7¼	.19	14.0
14 x 7	14	7	7¼	.23	16.0
16 x 7	16	7	7¼	.27	19.0
14 x 8	14	8	8½	.30	22.0
16 x 8	16	8	8½	.34	26.0
18 x 8	18	8	8½	.39	30.0
24 x 8	24	8	8½	.57	40.0
18 x 10	18	10	10½	.61	45.0
24 x 10	24	10	10½	.79	55.0



STYLE AA-RB

STYLE C

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.
	Length	Projection	Depth		
6 x 4½	6	4½	4	.026	2.5
8 x 4½	8	4½	4	.035	3.5
10 x 5	10	5	4	.052	4.5
12 x 5	12	5	4	.061	5.5
14 x 7	14	7	5½	.138	10.0
16 x 7	16	7	5½	.158	12.0
18 x 8	18	8	8	.304	20.0



STYLE C

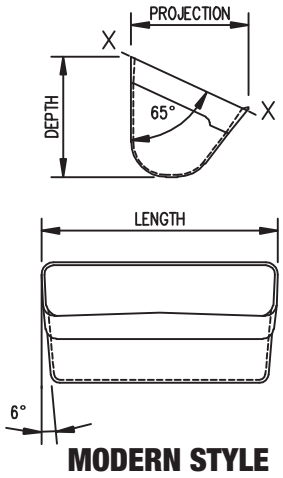
Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Cast Elevator Buckets

Styles - Modern, SC and AC

MODERN STYLE

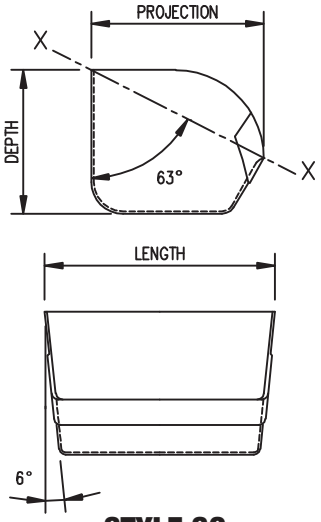
Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.
	Length	Projection	Depth		
14 x 7	14¾	7	7 5/16	.23	17.0
16 x 8	16½	8	8⅜	.34	23.3



MODERN STYLE

STYLE SC

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.
	Length	Projection	Depth		
8 x 6	8	6	5	.073	6.0
10 x 8	10	8	7	.170	11.5
12 x 8	12	8	7	.210	14.0
14 x 8	14	8	7	.250	16.0
16 x 8	16	8	7	.280	19.0
18 x 8	18	8	7	.317	22.0

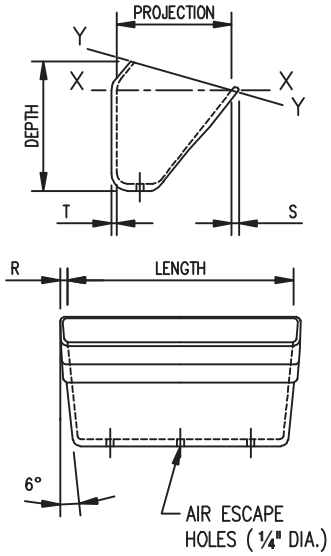


STYLE SC

STYLE AC

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★		Weight Per Bucket-Lbs.	R	S	T
	Length	Projection	Depth	X-X	Y-Y				
12 x 8	12	8	8½	.21	.28	29.0	⅜	9/16	⅜
16 x 8	16	8	8½	.28	.38	35.0	⅜	½	⅜
18 x 10	18	10	10½	.49	.62	55.0	½	1 1/16	7/16
24 x 10	24	10	10½	.68	.85	75.0	½	1⅛	7/16

Water level for AC bucket = 75% of Y-Y.



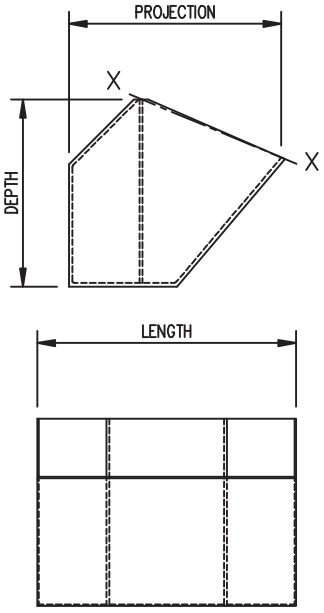
STYLE AC

Steel Elevator Buckets

Styles - ACS and HC

STYLE ACS

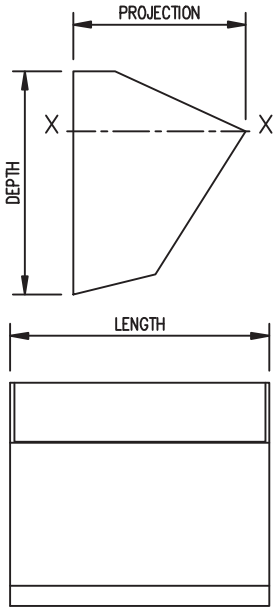
Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.				
	Length	Projection	Depth		No. 10 Ga. Steel	3/16" Steel	1/4" Steel	5/16" Steel	3/8" Steel
16 x 12	16	12	11	.67	24	34	46	57	68
18 x 12	18	12	11	.77	27	38	50	62	75
16 x 14	16	14	13	.91	31	43	56	71	85
18 x 14	18	14	13	1.05	33	46	61	76	91
21 x 14	21	14	13	1.26	37	51	68	85	101
24 x 14	24	14	13	1.46	40	56	74	93	111



STYLE ACS

STYLE HC

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.			
	Length	Projection	Depth		No. 12 Ga. Steel	No. 10 Ga. Steel	3/16" Steel	1/4" Steel
9 x 6	9	6	7¾	.086	6.0	8.1	10.8	14.0
10 x 6	10	6	7¾	.095	6.5	8.5	11.5	15.5
11 x 6	11	6	7¾	.105	7.0	9.3	12.5	16.0
12 x 6	12	6	7¾	.115	7.5	10.0	13.3	17.5
9 x 6	9	6	9	.110	7.5	9.6	12.8	17.0
10 x 6	10	6	9	.121	7.9	10.0	13.4	17.8
11 x 6	11	6	9	.133	8.5	10.8	14.4	19.0
12 x 6	12	6	9	.145	9.0	11.5	15.4	20.4
12 x 7	12	7	8¾	.191	9.9	12.6	16.8	22.3
14 x 7	14	7	8¾	.223	10.8	13.8	18.4	24.4
15 x 7	15	7	8¾	.239	11.3	14.4	19.2	25.4
16 x 7	16	7	8¾	.255	12.2	15.6	20.8	27.6
14 x 8	14	8	9¾	.271	12.2	15.6	20.8	27.6
16 x 8	16	8	9¾	.304	13.6	17.4	23.2	30.7
18 x 8	18	8	9¾	.347	14.7	19.0	25.3	33.7
20 x 8	20	8	9¾	.386	15.5	20.0	26.8	35.1
24 x 8	24	8	9¾	.465	17.9	23.0	30.6	40.8



STYLE HC

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

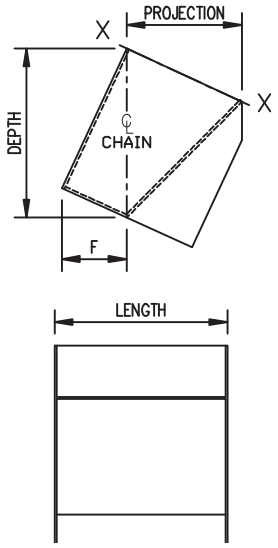
Steel Elevator Buckets

Style - Super Capacity

Vertical Regular and Vertical Overlapping

SUPER CAPACITY STYLE – VERTICAL REGULAR

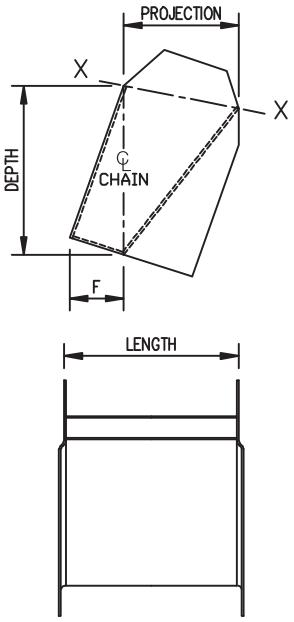
Dimensions in Inches					Capacity Cubic Feet★★	Weight Per Bucket-Lbs.				
Bucket Size			Chain Pitch	F		No. 10 Ga. Steel	3/16" Steel	1/4" Steel	5/16" Steel	3/8" Steel
Length	Projection	Depth								
12	8	11¾	12	4½	.50	22	29	—	—	—
14	8	11¾	12	4½	.58	24	32	—	—	—
16	8	11¾	12	4½	.66	26	35	—	—	—
16	12	17¾	18	6¾	1.49	46	62	82	103	—
18	8	11¾	12	4½	.74	28	38	—	—	—
20	8	11¾	12	4½	.82	31	41	—	—	—
20	12	17¾	18	6¾	1.87	—	71	94	119	—
20	16	23¾	24	8½	3.25	—	—	143	181	215
24	12	17¾	18	6¾	2.24	—	80	106	134	—
24	16	23¾	24	8½	3.90	—	—	166	210	249
30	12	17¾	18	6¾	2.80	—	94	124	157	—
30	16	23¾	24	8½	4.89	—	—	200	254	300
36	12	17¾	18	6¾	3.37	—	107	142	180	—
36	16	23¾	24	8½	5.85	—	—	235	298	351
42	16	23¾	24	8½	6.84	—	—	270	342	401
48	16	23¾	24	8½	7.80	—	—	305	386	452



SUPER CAPACITY STYLE VERTICAL REGULAR

SUPER CAPACITY STYLE – VERTICAL OVERLAPPING

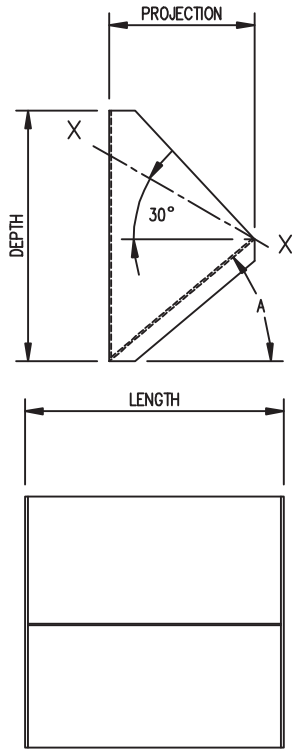
Dimensions in Inches					Capacity Cubic Feet★★	Weight Per Bucket-Lbs.				
Bucket Size			Chain Pitch	F		No. 10 Ga. Steel	3/16" Steel	1/4" Steel	5/16" Steel	3/8" Steel
Length	Projection	Depth								
12	8	11¾	12	3¾	.50	24	31	—	—	—
14	8	11¾	12	3¾	.58	26	34	—	—	—
16	8	11¾	12	3¾	.66	28	37	—	—	—
16	12	17¾	18	5⅝	1.49	—	64	84	107	—
18	8	11¾	12	3¾	.74	30	40	—	—	—
20	8	11¾	12	3¾	.82	32	43	—	—	—
20	12	17¾	18	5⅝	1.87	—	79	99	125	—
20	16	23¾	24	7⅝	3.25	—	—	153	194	230
24	12	17¾	18	5⅝	2.24	—	94	113	143	—
24	16	23¾	24	7⅝	3.90	—	—	168	273	253
30	12	17¾	18	5⅝	2.80	—	99	134	170	—
30	16	23¾	24	7⅝	4.89	—	—	190	242	286
36	12	17¾	18	5⅝	3.37	—	114	155	199	—
36	16	23¾	24	7⅝	5.85	—	—	213	270	319
42	16	23¾	24	7⅝	6.84	—	—	236	299	352
48	16	23¾	24	7⅝	7.80	—	—	258	327	385



SUPER CAPACITY STYLE VERTICAL OVERLAPPING

Steel Elevator Buckets

Style - Continuous No. 2



CONTINUOUS STYLE
No. 2

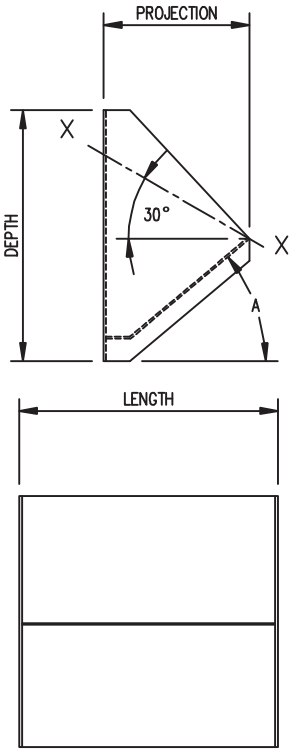
CONTINUOUS STYLE – No. 2

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★		Weight Per Bucket-Lbs.					
	Length	Projection	Depth	Angle A 40°	Angle A 30°	No. 16 Ga. Steel	No. 14 Ga. Steel	No. 12 Ga. Steel	No. 10 Ga. Steel	3⁄16" Steel	1⁄4" Steel
8 x 4½	8	4½	7¾	.067	.055	4.0	4.9	6.3	7.8	—	—
8 x 5	8	5	7¾	.079	.064	4.2	5.3	6.7	8.3	—	—
10 x 5	10	5	7¾	.100	.081	5.1	6.3	7.9	9.9	—	—
10 x 6	10	6	11¾	.145	.120	7.2	9.0	11.5	14.5	—	—
10 x 7	10	7	11¾	.195	.160	7.9	9.9	12.6	15.9	—	—
12 x 6	12	6	11¾	.177	.143	8.1	10.4	12.9	16.2	—	—
12 x 7	12	7	11¾	.239	.193	8.8	11.0	14.1	17.7	24.1	—
12 x 8	12	8	11¾	.307	.253	—	12.0	15.3	19.3	26.2	—
14 x 7	14	7	11¾	.280	.224	—	12.2	15.5	19.5	26.5	33.6
14 x 8	14	8	11¾	.364	.297	—	13.2	16.8	21.2	28.8	36.6
16 x 8	16	8	11¾	.416	.339	—	14.4	18.4	23.1	31.4	39.0
18 x 8	18	8	11¾	.475	.382	—	—	20.0	25.1	34.0	43.2
20 x 8	20	8	11¾	.521	.425	—	—	—	27.0	38.6	46.4

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Steel Elevator Buckets

Style - Continuous No. 7

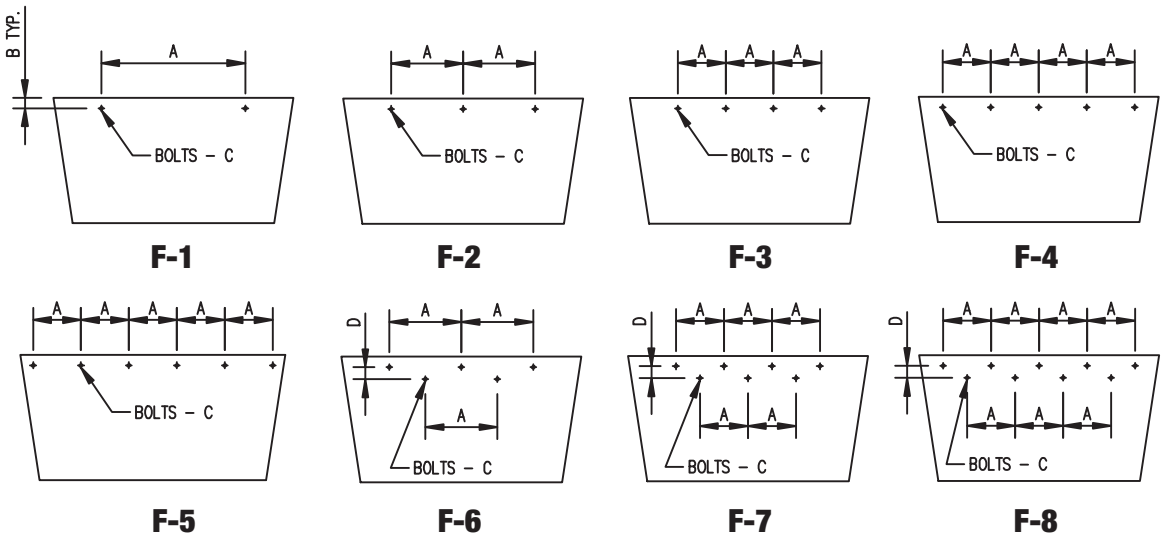


CONTINUOUS STYLE
No. 7

CONTINUOUS STYLE – No. 7

Bucket Size	Dimensions in Inches			Capacity Cubic Feet★★	Weight Per Bucket-Lbs.					
	Length	Projection	Depth	Angle A 40°	No. 16 Ga. Steel	No. 14 Ga. Steel	No. 12 Ga. Steel	No. 10 Ga. Steel	3/16" Steel	1/4" Steel
8 x 4½	8	4½	7¾	.067	4.0	4.9	6.3	7.8	—	—
8 x 5	8	5	7¾	.074	2.8	3.6	5.0	6.4	—	—
10 x 5	10	5	7¾	.100	5.1	6.3	7.9	9.9	—	—
10 x 6	10	6	11¾	.145	7.2	9.0	11.5	14.5	—	—
10 x 7	10	7	11¾	.186	5.6	6.9	9.7	12.5	—	—
12 x 6	12	6	11¾	.177	8.1	10.4	12.9	16.2	—	—
12 x 7	12	7	11¾	.224	6.3	7.8	11.0	14.1	19.2	—
12 x 8	12	8	11¾	.295	—	8.4	11.8	15.2	20.7	—
14 x 7	14	7	11¾	.263	—	8.7	12.2	15.7	21.3	28.4
14 x 8	14	8	11¾	.346	—	9.4	13.1	16.9	22.9	30.6
16 x 8	16	8	11¾	.396	—	10.3	14.4	18.6	25.2	33.7
18 x 8	18	8	11¾	.446	—	—	15.8	20.3	27.5	36.7
20 x 8	20	8	11¾	.521	—	—	—	27.0	36.6	46.4

Bucket Punching for Belt



F-1 F-2 F-3 F-4

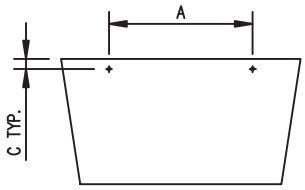
F-5 F-6 F-7 F-8

Bucket Length	Light Duty Buckets				Cast and Steel Buckets Handling Lump Material				Continuous Buckets			
	Punch	A	B	C	Punch	A	B	C	Punch	A	B	C
2½	F-1	⅞	½	¼	F-1	1⅜	¾	¼				
3		1⅜										
3½		1⅞										
4		2⅝	⅝			2⅝	¾					
4½		2¾										
5		3⅜				3⅜	1					
5½		3⅝										
6		4⅜				4⅜	1					
7	F-2	2¹¹⁄₁₆	¾	¼-⅝	F-2	2½	1	¼				
8		3⅛	⅞		F-6	3	⅞	¼-⅝	F-6	3	B = DEPTH - 1" / 2	¼-⅝
9		3⅝				3				3		
10		3¾				3½				3½		
11	F-3	3	⅞	¼-⅝		4				4		
12		3⅜				4½				4½		
13		3¾			F-7	3½	⅞	⅝		4½		
14	F-4	3	⅞	¼-⅝		4			F-7	4		⅝
15		3¼				4				4		
16-17	F-5	2⅞	⅞	¼-⅝		4½				4½		
18		3⅛				5				5		
19-20		3½			F-8	4	⅞	⅝	F-8	4		⅝
21-22		4				4½				4½		
23-24		4⅝				5				5		

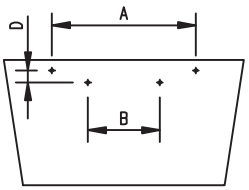
C Dimension (Bolt Diameter) = ¼" up to 6" projection and ⅝" for 6" projection and over.
D Dimension = 1" constant.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Bucket Punching for Chain



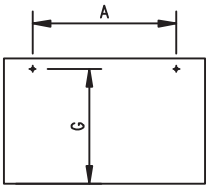
F-1



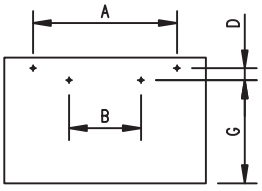
F-9

STYLE AA, AA-RB, B, C, HC, SC and MODERN BUCKETS

Chain Type	Chain No.	Attachment No.	Punching Layout	Bolt Hole Spacing in Inches				Bolt Size
				A	B	C	D	
Pintle	H74	K1	F-1	2⅞	—	¾	—	5/16
Pintle	H78	K1	F-1	4	—	1	—	⅜
HSB	825	K2	F-9	6	6	¾	2⅝	½
HSB	844	K2	F-9	6	4⅞	1	2¾	½
HSB	102½	K2	F-9	5 5/16	5 5/16	¾	1¾	½
Combination	102½	K2	F-9	5 5/16	5 5/16	¾	1¾	⅜
Combination & HSB	102B	K2	F-9	5 5/16	5 5/16	¾	1¾	⅜
Combination & HSB	110	K2	F-9	5 5/16	5 5/16	⅞	1¾	⅜
Combination & HSB	111	K2	F-9	6¼	6¼	¾	2 5/16	½
Combination & HSB	111SPC	K2	F-9	6¼	6¼	⅞	2 5/16	½
Combination & HSB	131	K1	F-1	4⅛	—	1	—	⅜
Combination & HSB	131	K2	F-9	4⅛	4⅛	1	1½	½
Combination	132	K2	F-9	7½	7½	1	2¾	½
Combination & HSB	188	K1	F-1	3¾	—	1	—	⅜
Combination & HSB	188	K2	F-9	4 3/16	4 3/16	¾	1¼	5/16
HSB	856	K2	F-9	6 5/16	6 5/16	1	2¼	½
HSB	150	K2	F-9	7½	7½	1	2¾	½



F-10



F-11

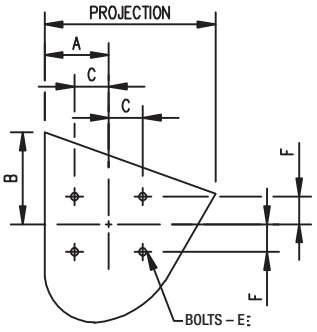
CONTINUOUS BUCKETS

Chain Type	Chain No.	Attachment No.	Min. Bucket Length	Punching Layout	Bolt Hole Spacing in Inches				Bolt Size
					A	B	D	G	
Combination & HSB	188	K1	5	F-10	3¾	—	—	2⅛	⅜
Combination & HSB	188	K2	5½	F-11	4 3/16	4 3/16	1¼	2¾	5/16
Combination & HSB	102B	K2	7	F-11	5 5/16	5 5/16	1¾	2	⅜
Combination & HSB	110	K2	7	F-11	5 5/16	5 5/16	1¾	2⅜	⅜
Combination & HSB	111	K2	8	F-11	6¼	6¼	2 5/16	2⅛	½
Combination	132	K2	9	F-11	7½	7½	2¾	3	½
HSB	150	K2	9	F-11	7½	7½	2¾	3	½
HSB	833	K2	9	F-11	6¼	6¼	2¼	3⅛	½
HSB	856	K2	10	F-11	6 5/16	6 5/16	2¼	3⅛	½
Closed End Pintle	730	K2	8	F-11	6	6	2⅝	3	½

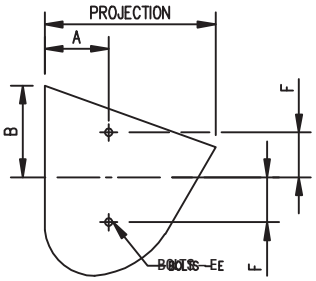
Bucket Punching for Chain

A and B WING ATTACHMENTS

Wing No.	Dimensions in Inches					
	Projection	Style AA		C	E	F
		A	B			
3A	10	3¾	5⅜	2	½	1⅝
4A	10	3¾	5⅜	2	½	1⅝
23A	5	—	—	1⅛	⅜	1⅛
23A	6	—	—	1⅛	⅜	1⅛
23A	7	2¼	4⅞	1⅛	⅜	1⅛
23A	8	2⅜	5⅝	1⅛	⅜	1⅛
23A	10	3⅛	6⅞	1⅛	⅜	1⅛
27A	7	—	—	1 25/32	⅜	⅝
27A	8	2¾	5⅜	1 25/32	⅜	⅝
27A	10	3½	6⅞	1 25/32	⅜	⅝
1B	7	2½	4	—	½	1⅞
1B	8	2⅝	4½	—	½	1⅞
1B	10	3¾	5⅜	—	½	1⅞



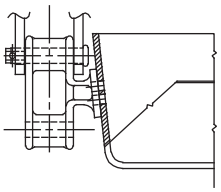
A WING ATTACHMENT



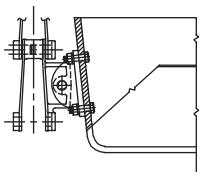
B WING ATTACHMENT

MOUNTING ELEVATOR BUCKETS ON CHAIN

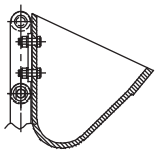
Elevator buckets are attached to chain by means of hex head machine bolts with nuts. Spring lock washers are recommended to keep the bolts tight.



G Attachment



Wing Attachment

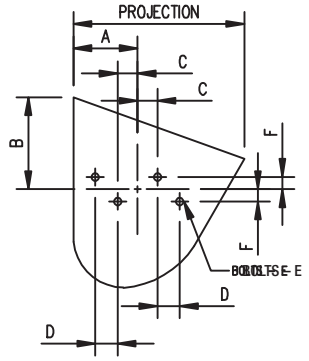


K Attachment

G6 WING ATTACHMENT

Chain No.	Dimensions in Inches				
	Min. Projection Style AA	C	D	E	F
131	7	7/8	21/32	3/8	9/32
188	7	27/32	11/16	1/4	9/32

Dimensions in Inches		
Projection	Style AA	
	A	B
7	2½	3¾
8	2⅝	4⅞
10	3¾	5⅜

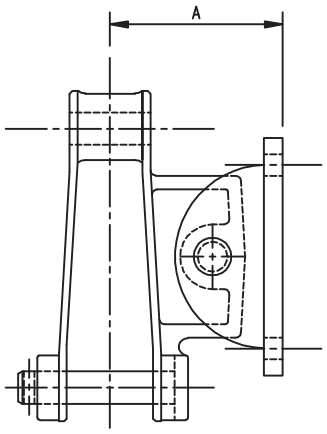


G6 WING ATTACHMENT

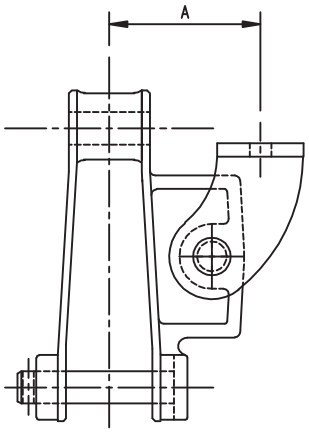
Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Bucket, Flight and Pipe Wings

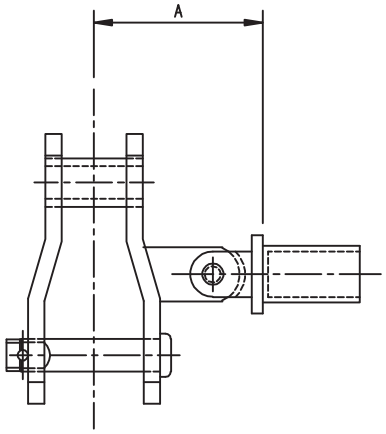
Hinged bucket, flight and pipe wings are used for attaching buckets, flights or crossrods to A22 or A42 attachments on double strand elevators and conveyors. This combination provides a hinged or swivel connection which is very desirable to compensate for the tendency of one chain to run ahead of the other during the life of the chain. Wings are made of malleable iron, Duramal or fabricated steel. Those shown are the most commonly used for elevator and conveyor chains.



BUCKET WING



FLIGHT WING



PIPE WING

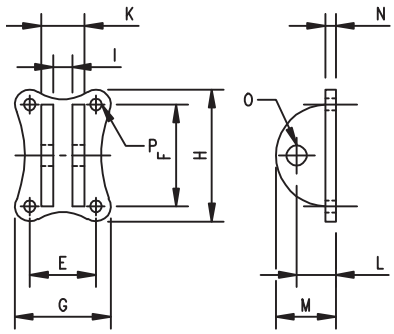
Chain No.	Attachment No.	Dimension A									
		Bucket Wings					Flight Wings↔			Pipe Wings↔	
		4AA	6A	23A	27A	1B	2C	6C	15C	16T	17T
4103	A22	3 5/16	3 5/16	3 3/8	3 3/16	3 5/16	3 1/8	—	—	—	—
720	A42	3 11/16	3 11/16	3 3/4	3 9/16	3 11/16	3 1/2	—	—	—	—
720S	A42	3 11/16	3 11/16	3 3/4	3 9/16	3 11/16	3 1/2	—	—	—	—
730S	A42	3 3/4	3 3/4	—	3 5/8	3 3/4	3 9/16	—	—	—	—
N102B	A22	4 1/4	4 1/4	4 5/16	4 1/8	4 1/4	4 1/16	—	—	—	—
102½	A42	3 7/8	3 7/8	3 15/16	3 3/4	3 7/8	3 11/16	—	—	—	—
131	A42	—	—	—	—	—	—	—	—	—	3 1/2
188	A42	—	—	—	—	—	—	2 13/16	2 1/4	2 9/16	—
188	A42	—	—	—	—	—	—	3 5/32	2 19/32	2 29/32	—
HSB131	A42	—	—	—	—	—	—	—	—	—	3 1/2
HSB188	A22	—	—	—	—	—	—	3 5/32	2 19/32	2 29/32	—
HSB188	A42	—	—	—	—	—	—	3 5/32	2 19/32	2 29/32	—
HSB825	A42	4 1/16	4 1/16	4 1/8	3 15/16	4 1/16	3 7/8	—	—	—	—
S1113	A22	3 11/16	3 11/16	3 3/4	3 9/16	3 11/16	3 1/2	—	—	—	—
S1116	A42	3 21/32	3 21/32	3 23/32	3 17/32	3 21/32	3 15/32	—	—	—	—
S1121	A42	—	—	—	—	—	—	3	2 7/16	2 3/4	—
S1131	A42	3 29/32	3 29/32	—	—	3 29/32	—	—	—	—	—
S1184	A42	—	—	—	—	—	—	—	2 3/8	2 11/16	—
SS6	A42	3 7/8	3 7/8	—	3 3/4	3 7/8	3 11/16	—	—	—	—
ZA2184+	A42	3 15/16	3 15/16	—	3 13/16	3 15/16	3 3/4	—	—	—	—

Wings can be furnished on other A22 and A42 attachments shown here by completing one or more of the following operations: Increasing attachment thickness with washers to accommodate wing clevis. Decreasing attachment thickness by grinding to accommodate wing clevis. Redrilling attachment holes to suit wing swivel. Redrilling wing swivel holes to suit attachments.

Bucket, Flight and Pipe Wings

A BUCKET WING

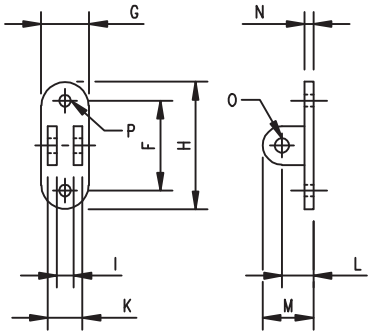
Wing No.↔	Weight Each Lbs.	Dimensions in Inches										
		E	F	G	H	I	K	L	M	N	Rivet Dia. O	Bolt Size P
3A●●	3.1	4	3¼	5½	4¾	13/16	1 9/16	1 5/16	2⅛	⅜	⅞	½
4A●●	3.2	4	3¼	5½	4¾	11/16	1 7/16	1 5/16	2⅛	⅜	⅝	½
4AA	2.8	3	3	4½	4½	⅝	1⅜	1 5/16	2 1/16	5/16	⅝	½
6A●●	1.4	3⅜	1¼	4½	2¼	21/32	1 5/32	1 5/16	2	¼	⅝	⅜
23A	1.0	2¼	2¼	3 9/16	3½	9/16	1 1/16	1⅜	2 5/16	9/32	⅝	⅜
27A	1.5	3½	1¼	5	2⅜	11/16	1 7/16	1 3/16	2 3/16	5/16	⅝	⅜



A BUCKET WING

B BUCKET WING

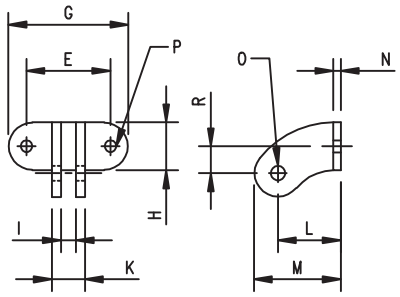
Wing No.↔	Weight Each Lbs.	Dimensions in Inches									
		F	G	H	I	K	L	M	N	Rivet Dia. O	Bolt Size P
1B●●	1.3	3¾	2	5 5/16	11/16	1 7/16	1 5/16	2⅛	⅜	⅝	½



B BUCKET WING

C FLIGHT WING

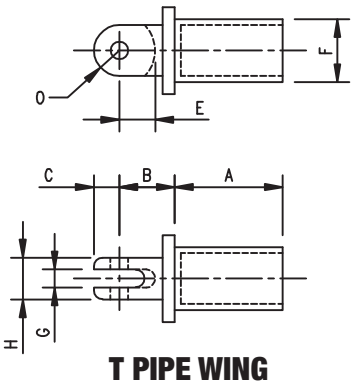
Wing No.↔	Weight Each Lbs.	Dimensions in Inches										
		E	G	H	I	K	L	M	N	Rivet Dia. O	Bolt Size P	R
1C●●	2.2	3½	5	2	9/16	1 5/16	1 9/16	2¼	5/16	⅝	½	1
2C	2.2	3½	5	2	⅝	1⅜	2⅝	3⅝	5/16	⅝	½	1⅛
6C	.6	2½	3¾	1⅝	13/32	1	13/16	1 7/16	7/32	⅜	⅜	1⅜
15C●●	.6	2½	3½	1¾	7/16	15/16	1⅛	1⅝	¼	⅜	5/16	13/16



C FLIGHT WING

T PIPE WING

Wing No.↔	Weight Each Lbs.	Dimensions in Inches								
		A	B	C	E	F	G	H	Rivet Dia. O	Pipe Size
16T	.9	2¼	1⅛	9/16	¾	1 5/16	⅜	⅞	⅜	1¼
17T	.6	2¾	1	⅝	⅝	⅞	⅜	1	½	1¼ XX



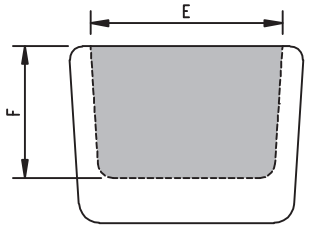
T PIPE WING

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

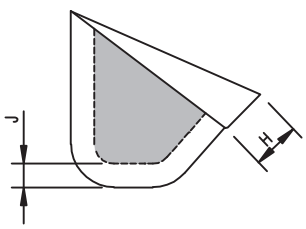
Minimum Bucket Sizes and Dimensions of Flat Surfaces

MINIMUM SIZE CAST BUCKETS

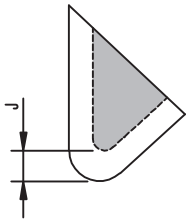
Chain Type	Chain No.	Attachment No.	Min. Bucket Sizes for Listed Attachment			
			AA	B	C	Modern
Pintle	74	K1	6 x 4	7 x 3½	7 x 4½	—
Pintle	78	K1	6 x 4	7 x 3½	6 x 4½	—
Combination & HSB	102½	K2	8 x 5	8 x 3½	8 x 4½	—
Combination & HSB	102B	K2	8 x 5	8 x 3½	8 x 4½	—
Combination & HSB	110	K2	8 x 5	8 x 3½	8 x 4½	—
Combination & HSB	111	K2	10 x 6	10 x 4	10 x 5	10 x 6
Combination & HSB	111SPC	K2	10 x 6	10 x 4	10 x 5	—
Combination & HSB	131	K1	8 x 5	7 x 3½	7 x 4½	—
Combination & HSB	131	K2	8 x 5	7 x 3½	7 x 4½	—
Combination	132	K2	11 x 6	12 x 5½	14 x 7	12 x 6
Combination & HSB	188	K1	6 x 4	7 x 3½	6 x 4½	—
Combination & HSB	188	K2	6 x 4	7 x 3½	6 x 4½	—
HSB	856	K2	10 x 6	10 x 4	10 x 5	10 x 6
HSB	150	K2	11 x 6	12 x 5½	14 x 7	12 x 6



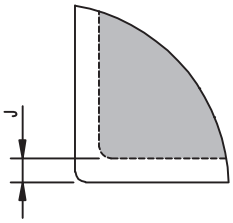
STYLE AA, B and C



STYLE AA



STYLE B



STYLE C

STYLE AA

Size	4 x 2¾	5 x 3½	6 x 4	7 x 4½	8 x 5	9 x 6	10 x 6	11 x 6
E	3½	4	5	5¾	6½	7¾	8½	9¼
F	2	2¾	3¼	3¾	4¼	4¾	4½	4½
H	11/16	⅞	1	1⅛	1⅛	1½	1½	1½
J	⅜	½	½	½	½	⅝	⅝	¾

STYLE AA - CONTINUED

Size	12 x 6	12 x 7	14 x 7	15 x 7	16 x 7	14 x 8	16 x 8	18 x 8	18 x 10
E	10¼	10¼	12	13	14	14	14	16	16
F	4½	5½	5½	5½	5½	6½	6½	6½	8
H	1½	1¾	1¾	1¾	1¾	2	2	2	2½
J	¾	¾	¾	¾	¾	¾	¾	1	1

STYLE B

Size	7 x 3½	8 x 3½	10 x 4	12 x 5½	16 x 6½
E	5¾	6½	8¾	10¼	14
F	3¼	3½	3¾	5¼	6
J	⅜	⅜	⅝	¾	¾

STYLE C

Size	6 x 4½	8 x 4½	10 x 5	12 x 5	14 x 7	16 x 7	18 x 10
E	5	7	9	10¾	13	15	17
F	3½	3½	3½	3½	5	5	5¾
J	½	½	½	⅝	⅝	⅝	¾

Notes

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Notes

SPROCKETS AND TRACTION WHEELS



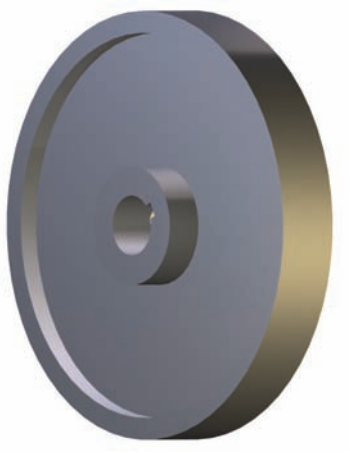
Cast and steel sprockets and traction wheels are covered in this section, along with technical data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

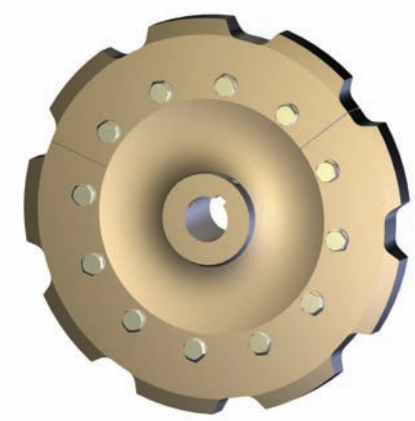


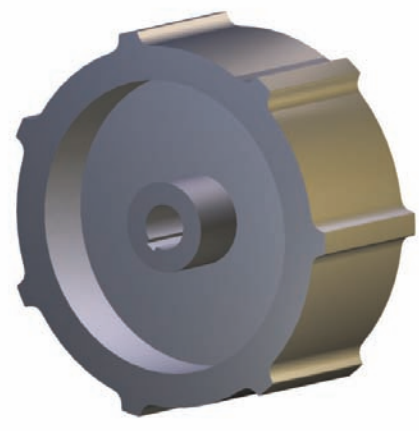
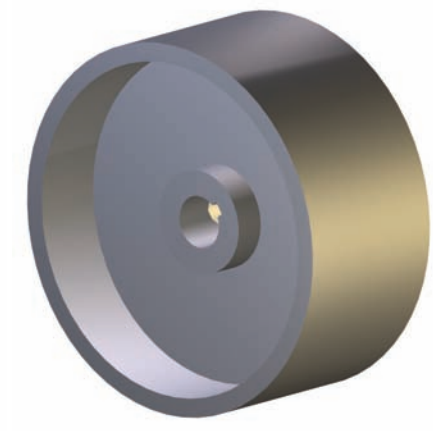
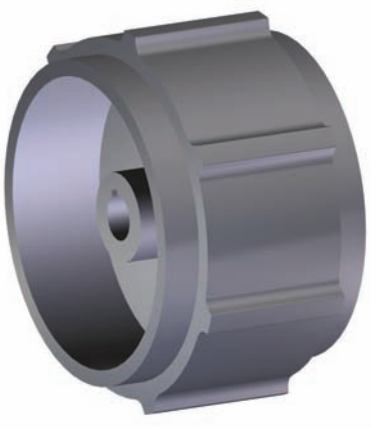


Sprockets and Traction Wheels







SPROCKETS

Sprockets and Traction Wheels
Selection Procedure

The following information should be given when ordering sprockets or traction wheels:

1. **QUANTITY** Number required.
2. **CHAIN** Number and type to be used.
3. **TEETH** Number of teeth. For flame cut flame hardened sprockets, any number of teeth are available. For cast sprockets, contact Webster's customer service department for the various numbers of teeth available for a specific chain. The effective number of teeth should be specified when ordering a double duty, hunting tooth or skip tooth sprocket.
4. **PITCH DIAMETER** For traction wheels, the outside diameter should be specified in place of the pitch diameter. Flame cut flame hardened traction wheels can be furnished in any diameter. For cast traction wheels, contact Webster's customer service department for the various diameters available.
5. **MATERIAL** Cast iron chilled rim or flame cut flame hardened steel should be specified.

   Cast iron chilled rim sprockets and traction wheels have smooth, hard, iron wear surfaces. These sprockets are especially well suited for applications handling abrasive materials such as sand, gravel, ash or cement.

   Flame cut flame hardened sprockets and traction wheels are used for extremely abrasive applications with high and/or shock loading. The inherent strength and flame hardened teeth of these sprockets provide maximum service in the most severe environments. The versatility of flame cut sprockets allows for specialized designs for a variety of customer requirements.
6. **CONSTRUCTION** Standard, split or segmental construction should be specified.

   Arm center and plate center sprockets and traction wheels are standard and are of one-piece construction.

   Split sprockets and traction wheels are used where ease of installation or replacement is required without disturbing the shaft, bearings or other sprockets.

   Segmental sprockets and traction wheels have removable segments of teeth or rims. This allows for replacement of worn teeth or rims without disturbing the shaft, bearings or other sprockets. Rim segments may be replaced without removing the chain by rotating the sprocket until one segment is free from the chain, replacing it, then rotating to the next segment. Often sprocket segments can be reversed to utilize the opposite side of the teeth, thus acquiring double life. Segmental sprockets and traction wheels have flame cut flame hardened rims mounted on either cast iron or steel bodies and hubs. Either may be furnished as solid or split construction. Segments must be replaced in complete sets. For selection of segmental sprockets and traction wheels, refer to pages I-14 and I-15.
7. **TYPE** Standard, hunting tooth, double duty, chain saver, etc., must be specified. Flame cut flame hardened sprockets can be furnished in any type. For gap or skip tooth sprockets provide specific details.

   Chain saver sprockets increase their life by having flanges on each side of the teeth so that the sidebar engages the flange, thereby distributing the wear over a greater area.

   Hunting tooth sprockets have an odd number of teeth, with the pitch of the teeth one half that of the chain. This makes the chain barrel advance one half pitch for each sprocket revolution. This action alternates the teeth which are in contact with the chain, thereby doubling the sprocket life.

   Multiple duty sprockets are a combination of the chain saver and the hunting tooth to further increase sprocket life.

   Double duty sprockets have two teeth for each pitch. When one set of teeth is worn the chain can be moved over to the other set, thereby increasing the life of the sprocket.

   Skip tooth sprockets have an even number of teeth with every other one omitted so the tooth pitch is twice the chain pitch.

   Gap tooth sprockets are used with chains having thru rods or rollers located mid-pitch.

   Minimum pitch line clearance sprockets should be specified for use on conveyors or drives which are reversed and where normal backlash is not desirable.

TABLE 1 - STANDARD BORE TOLERANCES

Hub Bore Inches	Standard Fit Bore Diameter Tolerance in Inches		Loose Fit Bore Diameter Tolerance in Inches	
	Min.	Max.	Min.	Max.
Up to 2	Nominal Size	Nominal Size +0.002	Nominal Size +0.002	Nominal Size +0.004
Over 2 through 4	Nominal Size	Nominal Size +0.003	Nominal Size +0.003	Nominal Size +0.006
Over 4 through 6	Nominal Size	Nominal Size +0.004	Nominal Size +0.004	Nominal Size +0.008
Over 6	Nominal Size	Nominal Size +0.005	Nominal Size +0.005	Nominal Size +0.010

8. **BORE** Sprockets and traction wheels are usually furnished with specific bores to meet customer requirements. The exact diameter of the shaft should be specified. Standard tolerances are shown in Table 1. Closer tolerances must be specified if desired.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Sprockets and Traction Wheels

Selection Procedure

9. HUB SIZE

GENERAL INFORMATION

Unless otherwise specified, solid cast and steel sprockets and traction wheels will be furnished with hub dimensions as shown in Tables 4 and 5. These sizes are based on the recommended maximum working load of the chain. The largest allowable keyseated bore for these hubs is also shown in these tables. If a bore larger than listed is required, or if a more economical selection is desired for lower working loads, follow the instructions for hub selection below. Non-keyed hubs are finished on both sides. Hubs are symmetrical about the centerline of the sprocket or traction wheel except those with lengths of 2½" or less. These are finished on one side only, the other side being flush. For offset hubs, specific details must be supplied. Flame cut flame hardened and split cast sprockets and traction wheels will be furnished with the largest hub listed in Tables 5 and 6 for a specific bore size unless otherwise specified. To determine a specific hub selection, follow the instructions below. For segmental sprocket hub and body selection, see pages I-14 and I-15. Split hubs for flame cut flame hardened sprockets and traction wheels, bronze bushed hubs and shear pin hubs are available on a special order basis. Contact Webster's customer service department for additional information.

HUB SELECTION

The required hub size for a sprocket or traction wheel is based on the amount of torque the wheel is to transmit and the bore size.

1. Torque determines the hub class (A, B, C, etc.) and can be found with one of the following formulas with T = torque (in lbs.):

   T = W x R
   W = working load of chain (lbs.)
   R = pitch radius (in.)
   where R = ½ PD (in.)
   PD = pitch diameter (in.)

   For cast iron chilled rim and flame cut flame hardened steel sprockets the pitch diameter can be found in Table 8 or use the following formula:

   PD = P x M
   P = chain pitch (in.)
   M = sprocket factor from Table 2,
   where N = number of teeth.

   For traction wheels the pitch diameter can be found using the following formula:

   PD = OD + B
   OD = outside diameter of traction wheel (in.)
   B = barrel or roller diameter of the chain (in.)

   If the horsepower transmitted is known then the torque can be found by:

   T = HP x 63,000/rpm of wheel

2. After the torque has been determined find the correct hub size by using the following procedure. Locate the appropriate table on the following pages:

   A. Use Table 4 for solid cast iron hubs.
   B. Use Table 5 for solid steel hubs.
   C. Use Table 6 for split cast iron hubs.

   The hub class and allowable torque are listed at the top of each table. Locate the proper column for the required torque; locate the proper row for the required bore size. The intersection of the row and column will fall on the appropriate hub OD. The appropriate hub length is listed in the same column at the bottom of the table. The keyseat and setscrews are determined by the bore size and are shown in the left-hand column.

   NOTE A: When the hub size falls in the blank area to the right of the listed hub diameters, it indicates that the shaft is the limiting factor. When an intersection falls into this space, use the largest hub diameter listed for that bore.

   NOTE B: When the hub size falls in the blank area to the left of the listed hub diameters, it indicates that a relatively small amount of torque is being transmitted by a relatively large shaft. When an intersection falls into this area, the smallest hub diameter listed for that bore should be used. For cast split hubs, Table 6, the intersection of allowable torque and bore size falls on the appropriate hub number. Split hubs should be ordered by this number. Table 6 also indicates if rim lugs are required. If required, these will be supplied. For cast split hub dimensions see Table 7 and Figure 2, page I-9.

TABLE 2 - SPROCKET FACTORS

N	M	N	M	N	M	N	M
6	2.000	14	4.494	22	7.027	30	9.567
7	2.305	15	4.810	23	7.344	31	9.884
8	2.613	16	5.126	24	7.661	32	10.202
9	2.924	17	5.442	25	7.979	33	10.520
10	3.236	18	5.759	26	8.296	34	10.838
11	3.550	19	6.076	27	8.614	35	11.156
12	3.864	20	6.392	28	8.931	36	11.474
13	4.179	21	6.710	29	9.249	—	—

10. KEYSEATS, KEYWAYS AND SETSCREWS

One straight keyway with two setscrews over it; one keyway with one setscrew over it and one at 90 degrees; or one taper keyway without setscrews can be furnished without extra charge. For split hubs two setscrews are normally furnished over the key, one on each side of the hub, see Figure 2, page I-9. Keyways may be aligned for pairs of sprockets at no additional charge. When ordering a tapered keyway, the end from which the key is to be driven must be specified. Keys are not included with sprockets or traction wheels.

The dimensions given in Table 3, cover parallel (straight), plain taper and gib head taper keys. Dimension T also covers the large ends of gib head taper keys measured at a distance W from the large end. Keyseats in shafts are identical for parallel and taper keys. The bottoms of the keyseats are parallel with the axis of the shaft.

The standard taper of ⅛" per foot (a ratio of 1 to 96) is cut in the hubs of sprockets, gears, pulleys, clutches, etc., where taper keys are used. The depths of keyseats are measured from their edges as shown in Figure 1.

The size and type of keyseats which are supplied as standard are listed in Tables 4, 5 and 6 for the various types of hubs. If a special keyseat is required, specific details must be supplied.

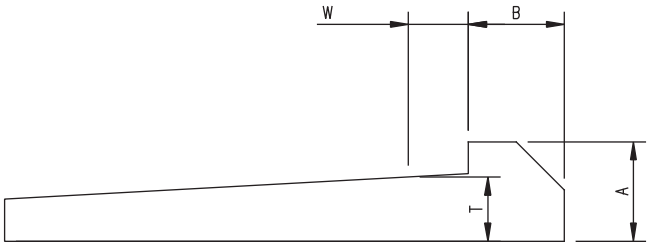
11. EXACT DELIVERY ADDRESS

12. HOW TO BE SHIPPED

TABLE 3 - STANDARD KEY DIMENSIONS

Dimensions in Inches								
Shaft Dia.	Parallel, Taper and Gib Head				Gib Head			
	Square		Flat		Square		Flat	
D	W	T	W	T	A	B	A	B
½ - 9/16	⅛	⅛	⅛	3/32	¼	¼	3/16	⅛
5/8 - ⅞	3/16	3/16	3/16	⅛	5/16	5/16	¼	3/16
5/16 - 1¼	¼	¼	¼	3/16	7/16	⅜	5/16	¼
1¼ - 1⅜	5/16	5/16	5/16	¼	½	7/16	⅜	5/16
1 7/16 - 1¾	⅜	⅜	⅜	¼	5/8	½	7/16	⅜
1 13/16 - 2¼	½	½	½	⅜	⅞	5/8	5/8	½
2 5/16 - 2¾	5/8	5/8	5/8	7/16	1	¾	¾	5/8
2⅞ - 3¼	¾	¾	¾	½	1⅛	⅞	⅞	¾
3⅜ - 3¾	⅞	⅞	⅞	5/8	1⅜	1	1 1/16	⅞
3⅞ - 4½	1	1	1	¾	1 5/8	1⅛	1¼	1
4⅝ - 5½	1¼	1¼	1¼	⅞	2	1 7/16	1½	1¼
5⅝ - 6½	1½	1½	1½	1	2⅜	1¾	1¾	1½
6⅝ - 7½	1¾	1¾	1¾	1¼	2¾	2	2	1¾
7⅝ - 9	2	2	2	1½	3½	2¼	2½	2
9¼ - 11	2½	2½	2½	1¾	4	3	3	2½
11¼ - 13	3	3	3	2	5	3½	3½	3
13¼ - 15	3½	3½	3½	2½	6	4	4	3½

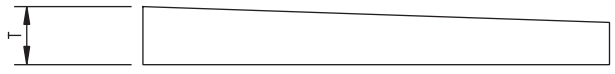
Taper on keys shown ⅛" in 12".
Use flat key when hub diameter does not permit use of square key.
Preferred sizes: square keys through 1½", flat keys above 1½".
Taper key has same dimension at large end as for parallel key, with keyseat parallel in shaft.



GIB HEAD TAPER KEY



PARALLEL KEY



TAPER KEY

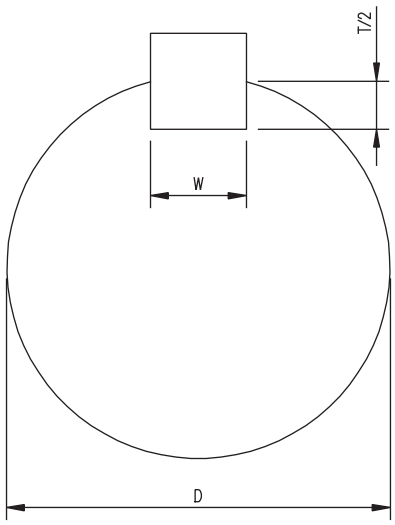


FIGURE 1 - STANDARD KEYSEAT DIMENSIONS

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Solid Cast Iron Hub Sizes

TABLE 4 - SOLID CAST IRON HUBS

Bore	Size, Square Key	Size, Setscrew	Allowable Torque in Inch-Pounds																										
			500	1,000	2,000	3,500	5,600	8,500	12,500	17,000	23,000	30,000	38,000	47,000	60,000	70,000	100,000	140,000	190,000	245,000	325,000	400,000	500,000	600,000	720,000	850,000	1,000,000	1,250,000
			Hub Class																										
			A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	T	U	V	W	X	Y	Z	
			Diameter of Hub																										
15/16	1/4	3/8	1 3/4	2																									
1 3/16	1/4	3/8	2	2 1/4	2 1/4																								
1 7/16	3/8	3/8	2 1/2	2 1/2	2 3/4	3																							
1 11/16	3/8	3/8	2 3/4	2 3/4	3	3 1/4	3 1/2																						
1 15/16	1/2	1/2	3 1/4	3 1/4	3 1/4	3 1/2	3 3/4	4																					
2 3/16	1/2	1/2	3 1/2	3 1/2	3 1/2	3 3/4	4	4 1/4	4 1/2																				
2 7/16	5/8	5/8	4	4	4	4	4 1/4	4 1/2	4 3/4	5																			
2 11/16	5/8	5/8	4 1/4	4 1/4	4 1/4	4 1/4	4 1/2	4 3/4	5	5 1/4	5 1/2																		
2 15/16	3/4	5/8	4 1/2	4 1/2	4 1/2	4 1/2	4 3/4	5	5 1/4	5 1/2	5 3/4	6																	
3 3/16	3/4	5/8	4 3/4	4 3/4	4 3/4	4 3/4	5	5 1/4	5 1/2	5 3/4	6	6 1/4	6 1/2																
3 7/16	7/8	3/4		5 1/4	5 1/4	5 1/4	5 1/4	5 1/2	5 3/4	6	6 1/4	6 1/2	6 3/4	6 3/4															
3 11/16	7/8	3/4			5 1/2	5 1/2	5 1/2	5 3/4	6	6 1/4	6 1/2	6 3/4	7	7	7														
3 15/16	1	3/4				6 1/4	6 1/4	6 1/4	6 1/4	6 1/2	6 3/4	7	7 1/4	7 1/4	7 1/2	7 1/2													
4 7/16	1	3/4					6 3/4	6 3/4	6 3/4	6 3/4	7	7 1/4	7 1/2	7 1/2	8	8	8												
4 15/16	1 1/4	7/8						7 1/2	7 1/2	7 1/2	7 1/2	7 1/2	8	8	8 1/2	8 1/2	8 1/2	9											
5 7/16	1 1/4	7/8							8 1/2	8 1/2	8 1/2	8 1/2	8 1/2	8 1/2	9	9	9 1/2	9 1/2	10										
5 15/16	1 1/2	1								9 1/2	9 1/2	9 1/2	9 1/2	9 1/2	9 1/2	9 1/2	10	10	10 1/2	11									
6 1/2	1 1/2	1									10	10	10	10	10	10	10 1/2	10 1/2	11	11 1/2	12								
7	1 1/2	1										10 1/2	10 1/2	10 1/2	10 1/2	10 1/2	11	11	11 1/2	12	12 1/2	13							
7 1/2	1 3/4	1 1/4											11 1/2	11 1/2	11 1/2	11 1/2	11 1/2	11 1/2	12	12 1/2	13	13	14						
8	1 3/4	1 1/4												12	12	12	12	12	12 1/2	13	13 1/2	13 1/2	14	15					
8 1/2	1 3/4	1 1/4													13	13	13	13	13 1/2	14	14 1/2	14 1/2	15	15	16				
9	1 3/4	1 1/4														14	14	14	14	14 1/2	15	15	15	16	16	17			
9 1/2	1 3/4	1 1/4															15	15	15	15	15 1/2	15 1/2	15 1/2	16	17	17	18		
10	2	1 1/4																16	16	16	16	16	16 1/2	16 1/2	17	18	18	19	
Std. and Min.			→	→	→	→	→																						
Hub Length			1 1/4	1 1/2	1 3/4	2	2 1/2	2 3/4	3 1/4	3 1/2	4	4 1/4	4 1/2	5	5 1/4	5 1/2	6	6 1/2	7	7 3/4	8 1/2	9 1/2	10	10 1/2	11	11 1/2	12	12 1/2	

For hub diameter of loose or setscrewed wheels use smallest hub size shown for bore desired.
For hub length of loose or setscrewed wheels use same as keyseated.
Hub length can be furnished longer for an additional charge.

Solid Steel Hub Sizes

TABLE 5 - SOLID STEEL HUBS

Bore	Size, Square Key	Size, Setscrew	Allowable Torque in Inch-Pounds																										
			500	1,000	2,000	3,500	5,600	8,500	12,500	17,000	23,000	30,000	38,000	47,000	60,000	70,000	100,000	140,000	190,000	245,000	325,000	400,000	500,000	600,000	720,000	850,000	1,000,000	1,250,000
			Hub Class																										
			A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	T	U	V	W	X	Y	Z	
			Diameter of Hub																										
15/16	1/4	5/16	1 3/4	1 3/4																									
1 3/16	1/4	3/8	2	2	2																								
1 7/16	3/8	3/8	2 1/4	2 1/4	2 1/2	2 3/4																							
1 11/16	3/8	3/8	2 3/4	2 3/4	2 3/4	3	3																						
1 15/16	1/2	1/2	3	3	3	3 1/4	3 1/4	3 1/4																					
2 3/16	1/2	1/2	3 1/4	3 1/4	3 1/4	3 1/2	3 1/2	3 1/2	3 3/4																				
2 7/16	5/8	1/2	3 3/4	3 3/4	3 3/4	3 3/4	4	4	4 1/4	4 1/4																			
2 11/16	5/8	1/2	4 1/4	4 1/4	4 1/4	4 1/4	4 1/4	4 1/4	4 1/2	4 1/2	4 1/2																		
2 15/16	3/4	5/8	4 1/2	4 1/2	4 1/2	4 1/2	4 1/2	4 3/4	4 3/4	4 3/4	5	5																	
3 3/16	3/4	5/8	4 3/4	4 3/4	4 3/4	4 3/4	4 3/4	5	5	5	5 1/4	5 1/4	5 1/4																
3 7/16	7/8	3/4		5 1/4	5 1/4	5 1/4	5 1/4	5 1/4	5 1/4	5 1/4	5 1/2	5 1/2	5 3/4	5 3/4															
3 11/16	7/8	3/4			5 1/2	5 1/2	5 1/2	5 1/2	5 1/2	5 1/2	5 3/4	5 3/4	6	6	6														
3 15/16	1	3/4				6	6	6	6	6	6 1/4	6 1/4	6 1/2	6 1/2	6 1/2	6 1/2													
4 7/16	1	3/4					6 1/2	6 1/2	6 1/2	6 1/2	6 3/4	6 3/4	7	7	7	7	7												
4 15/16	1 1/4	7/8						7 1/4	7 1/4	7 1/4	7 1/4	7 1/4	7 1/2	7 1/2	7 1/2	8	8	8											
5 7/16	1 1/4	7/8							8	8	8	8	8	8	8	8 1/2	8 1/2	8 1/2	8 1/2										
5 15/16	1 1/2	1								9	9	9	9	9	9	9 1/2	9 1/2	9 1/2	9 1/2	9 1/2									
6 1/2	1 1/2	1									9 1/2	9 1/2	9 1/2	9 1/2	9 1/2	10	10	10	10	10	10								
7	1 3/4 ■■	1										10	10	10	10	10 1/2	10 1/2	10 1/2	10 1/2	10 1/2	10 1/2	11							
7 1/2	2 ■■	1											11	11	11	11 1/2	11 1/2	11 1/2	11 1/2	11 1/2	11 1/2	12	12						
8	2 ■■	1												11 1/2	11 1/2	12	12	12	12	12	12	12 1/2	12 1/2	12 1/2					
8 1/2	2 ■■	1													12	12 1/2	12 1/2	12 1/2	12 1/2	12 1/2	12 1/2	13	13	13	13 1/2				
9	2 ■■	1														13	13	13	13	13	13	13 1/2	13 1/2	13 1/2	14	14			
9 1/2	2 1/2 ■■	1															13 1/2	13 1/2	13 1/2	13 1/2	13 1/2	14	14	14	14 1/2	14 1/2	15		
10	2 1/2 ■■	1																14 1/2	14 1/2	14 1/2	14 1/2	15	15	15	15 1/2	15 1/2	16	16	
Std. and Min.			→	→	→	→	→																						
Hub Length			1 1/4	1 1/2	1 3/4	2	2 1/2	2 3/4	3 1/4	3 1/2	4	4 1/4	4 1/2	5	5 1/4	5 1/2	6	6 1/2	7	7 3/4	8 1/2	9 1/2	10	10 1/2	11	11 1/2	12	12 1/2	

For hub diameter of loose or setscrewed wheels use smallest hub size shown for bore desired.
Hub length can be furnished longer for an additional charge.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Split Cast Iron Hubs

TABLE 6 - SPLIT CAST IRON HUBS

Bore	Size, Square Key	Size, Setscrew	Maximum Pitch Dia. Permitted Without Rim Lugs	Allowable Torque in Inch-Pounds																	
				500	1,000	2,000	3,500	5,600	8,500	12,500	17,000	23,000	30,000	38,000	47,000	60,000	70,000	100,000	140,000	190,000	245,000
				Hub Class																	
				A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R
				Number of Hub																	
15/16	1/4	3/8	15	L2-015	L2-015																
1 13/16	1/4	3/8	16	L2-103	L2-103	L2-103															
1 7/16	3/8	3/8	17	L2-107	L2-107	L2-107	L2-107														
1 11/16	3/8	3/8	18	L2-111	L2-111	L2-111	L2-111	L2-111													
1 15/16	1/2	1/2	20	L2-115	L2-115	L2-115	L2-115	L2-115	L2-115												
2 3/16	1/2	1/2	21	L2-203	L2-203	L2-203	L2-203	L2-203	L2-203	L2-203											
2 7/16	5/8	5/8	22	L2-207	L2-207	L2-207	L2-207	L2-207	L2-207	L2-207	H2-207										
2 11/16	5/8	5/8	23	L2-211	L2-211	L2-211	L2-211	L2-211	L2-211	L2-211	H2-211	H2-211									
2 15/16	3/4	5/8	24	L2-215	L2-215	L2-215	L2-215	L2-215	L2-215	L2-215	L2-215	H2-215	H2-215								
3 3/16	3/4	5/8	26	L2-303	L2-303	L2-303	L2-303	L2-303	L2-303	L2-303	L2-303	L2-303	H2-303	H2-303							
3 7/16	7/8	3/4	26		L2-307	L2-307	L2-307	L2-307	L2-307	L2-307	L2-307	L2-307	H2-307	H2-307	H2-307						
3 11/16	7/8	3/4	27			L2-311	L2-311	L2-311	L2-311	L2-311	L2-311	L2-311	L2-311	L2-311	H2-311	H2-311					
3 15/16	1	3/4	28				L2-315	L2-315	L2-315	L2-315	L2-315	L2-315	L2-315	L2-315	L2-315	H2-315	H2-315				
4 7/16	1	3/4	30					L2-407	L2-407	L2-407	L2-407	L2-407	L2-407	L2-407	L2-407	H2-407	H2-407	H2-407			
4 15/16	1 1/4	7/8	33						L2-415	L2-415	L2-415	L2-415	L2-415	L2-415	L2-415	L2-415	L2-415	H2-415	H2-415		
5 7/16	1 1/4	7/8	37							L2-507	L2-507	L2-507	L2-507	L2-507	L2-507	L2-507	L2-507	L2-507	H2-507	H2-507	
5 15/16	1 1/2	1	38								L2-515	L2-515	L2-515	L2-515	L2-515	L2-515	L2-515	L2-515	H2-515	H2-515	H2-515

TABLE 7 - SPLIT CAST IRON HUB DIMENSIONS

Hub No.	Bore	Diameter	Clearance	Projection	
	A	B	C	D	E
L2-015	15/16	2	4 1/4	1 5/16	Sprocket and Traction Wheel Center Thickness Varies According to Chain Used
L2-103	1 3/16	2 1/4	4 1/2	1 5/16	
L2-107	1 7/16	3	5 3/4	1 9/16	
L2-111	1 11/16	3 1/2	6	1 9/16	
L2-115	1 15/16	3 3/4	6 1/4	1 9/16	
L2-203	2 3/16	4 1/4	7	1 9/16	
L2-207	2 7/16	4 1/2	7 1/4	1 9/16	
H2-207	2 7/16	5	8 1/2	1 3/4	
L2-211	2 11/16	4 3/4	7 1/2	1 9/16	
H2-211	2 11/16	5 1/2	8 1/2	1 3/4	
L2-215	2 15/16	5 1/4	8 1/2	2	
H2-215	2 15/16	6	10	2 1/4	
L2-303	3 3/16	6	9 1/4	1 3/8	
H2-303	3 3/16	6 1/2	10 1/4	2 1/4	
L2-307	3 7/16	6 1/4	9 3/4	2 1/4	
H2-307	3 7/16	6 3/4	10 1/2	2 1/4	
L2-311	3 11/16	6 3/4	10	2 1/16	
H2-311	3 11/16	7	11	3	
L2-315	3 15/16	7 1/4	10 3/4	2 1/2	
H2-315	3 15/16	7 1/2	11 1/2	2 9/16	
L2-407	4 7/16	7 1/2	11	2 3/16	
H2-407	4 7/16	8	13	2 13/16	
L2-415	4 15/16	8 1/2	12 3/4	2 7/16	
H2-415	4 15/16	9	14	3 3/8	
L2-507	5 7/16	9 1/2	15 7/8	2 5/8	
H2-507	5 7/16	10	15 3/4	3 3/8	
L2-515	5 15/16	10	14 1/4	2 5/8	
H2-515	5 15/16	11	16 3/4	3 3/8	

Projection can be furnished longer for an additional charge.

Standard hubs are furnished central with clamps on each side, see Figure 2.

Hubs with clamps, all one side, and with a variable length on the opposite side can be furnished.

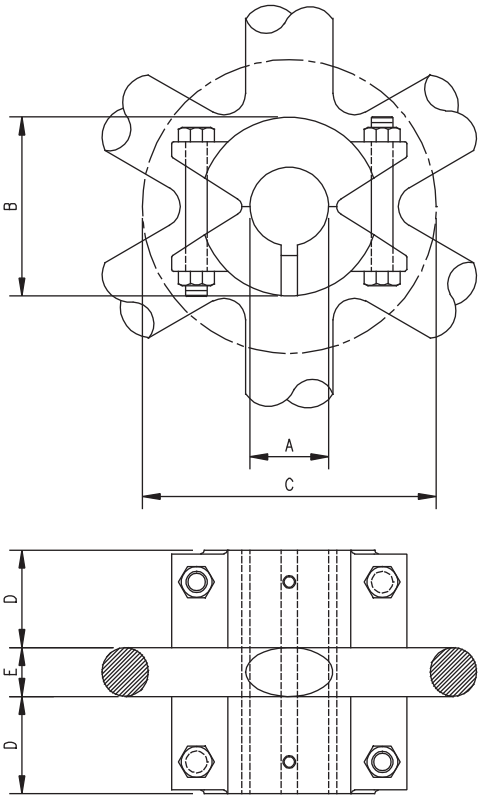


FIGURE 2 - SPLIT CAST IRON HUBS

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Sprocket Pitch Diameters

TABLE 8 - PITCH DIAMETERS

Pitch in Inches	Number of Sprocket Teeth									
	6	7	8	9	10	11	12	13	14	15
1.375	2.750	3.169	3.592	4.020	4.449	4.881	5.313	5.746	6.179	6.613
1.500	3.000	3.457	3.919	4.386	4.854	5.325	5.796	6.268	6.741	7.215
1.506	3.012	3.471	3.935	4.403	4.873	5.346	5.819	6.293	6.767	7.243
1.630	3.260	3.757	4.259	4.766	5.274	5.786	6.298	6.811	7.325	7.840
1.631	3.262	3.759	4.261	4.769	5.277	5.790	6.302	6.815	7.329	7.845
1.634	3.268	3.766	4.269	4.777	5.287	5.800	6.313	6.828	7.343	7.859
1.654	3.308	3.812	4.321	4.836	5.352	5.871	6.391	6.912	7.433	7.955
2.308	4.616	5.319	6.030	6.748	7.468	8.193	8.918	9.645	10.372	11.101
2.609	5.218	6.013	6.817	7.628	8.442	9.261	10.081	10.903	11.724	12.549
2.636	5.272	6.075	6.887	7.707	8.530	9.357	10.185	11.015	11.846	12.679
3.000	6.000	6.915	7.839	8.772	9.708	10.650	11.592	12.537	13.482	14.430
3.075	6.150	7.087	8.034	8.991	9.950	10.916	11.881	12.850	13.819	14.790
3.170	6.340	7.306	8.283	9.269	10.258	11.253	12.248	13.247	14.245	15.247
3.675	7.350	8.470	9.602	10.745	11.892	13.046	14.200	15.357	16.515	17.676
3.690	7.380	8.505	9.641	10.789	11.940	13.099	14.258	15.420	16.582	17.748
4.000	8.000	9.220	10.452	11.696	12.944	14.200	15.456	16.716	17.976	19.240
4.040	8.080	9.312	10.556	11.812	13.073	14.342	15.610	16.883	18.155	19.432
4.063	8.126	9.365	10.616	11.880	13.147	14.423	15.699	16.979	18.259	19.543
4.083	8.166	9.411	10.668	11.938	13.212	14.494	15.776	17.062	18.349	19.639
4.090	8.180	9.427	10.687	11.959	13.235	14.519	15.803	17.092	18.380	19.672
4.610	9.220	10.626	12.045	13.479	14.917	16.365	17.813	19.265	20.717	22.174
4.760	9.520	10.971	12.437	13.918	15.403	16.898	18.392	19.892	21.391	22.895
5.000	10.000	11.525	13.065	14.620	16.180	17.750	19.320	20.895	22.470	24.050
5.188	10.376	11.958	13.556	15.169	16.788	18.417	20.046	21.680	23.314	24.954
6.000	12.000	13.830	15.678	17.544	19.416	21.300	23.184	25.074	26.964	28.860
6.050	12.100	13.945	15.808	17.690	19.577	21.477	23.377	25.282	27.188	29.100
6.125	12.250	14.118	16.004	17.909	19.820	21.743	23.667	25.596	27.525	29.461
7.000	14.000	16.135	18.291	20.468	22.652	24.850	27.048	29.253	31.458	33.670
7.240	14.480	16.688	18.918	21.169	23.428	25.702	27.975	30.255	32.536	34.824
8.000	16.000	18.440	20.904	23.392	25.888	28.400	30.912	33.432	35.952	38.480
9.000	18.000	20.745	23.517	26.316	29.124	31.950	34.776	37.611	40.446	43.290
12.000	24.000	27.660	31.356	35.088	38.832	42.600	46.368	—	—	—
14.000	28.000	32.270	36.582	40.936	45.304	49.700	54.096	—	—	—
18.000	36.000	41.490	47.034	52.632	58.248	—	—	—	—	—
24.000	48.000	55.320	62.712	70.176	77.664	—	—	—	—	—

For cast sprocket hub dimensions, see Table 4.

For steel sprocket hub dimensions, see Table 5.

All of these sprockets are available in flame cut flame hardened fabricated steel. Contact Webster's customer service department for cast iron chilled rim availability.

Chain saver, minimum pitch line clearance and drag chain extended drum sprockets are available. Diameter and width must be specified for extended drum sprockets. Contact Webster's customer service department for availability.

Sprocket Pitch Diameters

TABLE 8 - PITCH DIAMETERS

Pitch in Inches	Number of Sprocket Teeth									
	16	17	18	19	20	21	22	23	24	25
1.375	7.048	7.482	7.918	8.354	8.789	9.226	9.662	10.098	10.533	10.971
1.500	7.689	8.163	8.638	9.114	9.588	10.065	10.540	11.016	11.491	11.968
1.506	7.719	8.195	8.673	9.150	9.626	10.105	10.582	11.060	11.537	12.016
1.630	8.355	8.870	9.387	9.903	10.418	10.937	11.454	11.970	12.487	13.005
1.631	8.360	8.875	9.392	9.909	10.425	10.944	11.461	11.978	12.495	13.013
1.634	8.375	8.892	9.410	9.928	10.444	10.964	11.482	12.000	12.518	13.037
1.654	8.478	9.001	9.525	10.049	10.572	11.098	11.622	12.146	12.671	13.197
2.308	11.830	12.560	13.291	14.023	14.752	15.486	16.218	16.949	17.681	18.415
2.609	13.373	14.198	15.025	15.852	16.676	17.506	18.333	19.160	19.987	20.817
2.636	13.512	14.345	15.180	16.016	16.849	17.687	18.523	19.358	20.194	21.032
3.000	15.378	16.326	17.277	18.228	19.176	20.130	21.081	22.032	22.983	23.937
3.075	15.762	16.734	17.708	18.683	19.655	20.633	21.608	22.582	23.557	24.535
3.170	16.249	17.251	18.256	19.260	20.262	21.270	22.275	23.280	24.285	25.293
3.675	18.838	19.999	21.164	22.329	23.490	24.659	25.824	26.989	28.154	29.322
3.690	18.914	20.080	21.250	22.420	23.586	24.759	25.929	27.099	28.269	29.442
4.000	20.504	21.768	23.036	24.304	25.568	26.840	28.108	29.376	30.644	—
4.040	20.709	21.985	23.266	24.547	25.823	27.108	28.389	29.669	30.950	—
4.063	20.826	22.110	23.398	24.686	25.970	27.262	28.550	29.838	31.126	—
4.083	20.929	22.219	23.513	24.808	26.098	27.396	28.691	29.985	31.279	—
4.090	20.965	22.257	23.554	24.850	26.143	27.443	28.740	30.036	31.333	—
4.610	23.630	25.087	26.548	28.010	29.467	30.933	32.394	33.855	35.317	—
4.760	24.399	25.903	27.412	28.921	30.425	31.939	33.448	34.957	36.466	—
5.000	25.630	27.210	28.795	30.380	31.960	33.550	35.135	36.720	38.305	—
5.188	26.593	28.233	29.877	31.522	33.161	34.811	36.456	38.100	39.745	—
6.000	30.756	32.625	34.554	36.456	38.352	—	—	—	—	—
6.050	31.012	32.924	34.841	36.759	38.671	—	—	—	—	—
6.125	31.396	33.332	35.273	37.215	39.151	—	—	—	—	—
7.000	35.882	38.094	40.313	42.532	44.744	—	—	—	—	—
7.240	37.112	39.400	41.695	43.990	46.278	—	—	—	—	—
8.000	—	—	—	—	—	—	—	—	—	—
9.000	—	—	—	—	—	—	—	—	—	—
12.000	—	—	—	—	—	—	—	—	—	—
14.000	—	—	—	—	—	—	—	—	—	—
18.000	—	—	—	—	—	—	—	—	—	—
24.000	—	—	—	—	—	—	—	—	—	—

TABLE 9 - HUNTING TOOTH PITCH DIAMETERS

Pitch in Inches	Number of Sprocket Teeth				
	13	17	19	21	23
6.000	12.912	16.608	18.480	20.358	22.242

Hunting tooth sprockets are cast iron chilled rim and are used with 720S and 720NCS chains.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Sprocket Pitch Diameters

TABLE 8 - PITCH DIAMETERS

Pitch in Inches	Number of Sprocket Teeth									
	26	27	28	29	30	31	32	33	34	35
1.375	11.407	11.844	12.280	12.717	13.154	13.590	14.027	14.465	14.902	15.339
1.500	12.444	12.921	13.396	13.873	14.350	14.826	15.303	15.780	16.257	16.734
1.506	12.493	12.972	13.450	13.928	14.407	14.885	15.364	15.843	16.322	16.800
1.630	13.522	14.040	14.557	15.075	15.594	16.110	16.629	17.147	17.665	18.184
1.631	13.530	14.049	14.566	15.085	15.603	16.120	16.639	17.158	17.676	18.195
1.634	13.555	14.075	14.593	15.112	15.632	16.150	16.670	17.189	17.709	18.228
1.654	13.721	14.247	14.771	15.297	15.823	16.348	16.874	17.400	17.926	18.452
2.308	19.147	19.881	20.612	21.346	22.080	22.812	23.546	24.280	25.014	25.748
2.609	21.644	22.473	23.300	24.130	24.960	25.787	26.617	27.446	28.276	29.106
2.636	21.868	22.706	23.542	24.380	25.218	26.054	26.892	27.730	28.568	29.407
3.000	24.888	25.842	26.793	27.747	28.701	29.652	30.606	31.560	32.514	33.468
3.075	25.510	26.488	27.462	28.440	29.418	30.393	31.371	32.349	33.326	34.304
3.170	26.298	27.306	28.311	29.319	30.327	31.332	32.340	33.348	34.356	35.364
3.675	30.487	31.656	32.821	33.990	35.158	36.323	37.492	38.661	39.829	40.998
3.690	30.612	31.785	32.955	34.128	35.302	36.471	37.645	38.818	39.992	41.165
4.000	—	—	—	—	—	—	—	—	—	—
4.040	—	—	—	—	—	—	—	—	—	—
4.063	—	—	—	—	—	—	—	—	—	—
4.083	—	—	—	—	—	—	—	—	—	—
4.090	—	—	—	—	—	—	—	—	—	—
4.610	—	—	—	—	—	—	—	—	—	—
4.760	—	—	—	—	—	—	—	—	—	—
5.000	—	—	—	—	—	—	—	—	—	—
5.188	—	—	—	—	—	—	—	—	—	—
6.000	—	—	—	—	—	—	—	—	—	—
6.050	—	—	—	—	—	—	—	—	—	—
6.125	—	—	—	—	—	—	—	—	—	—
7.000	—	—	—	—	—	—	—	—	—	—
7.240	—	—	—	—	—	—	—	—	—	—
8.000	—	—	—	—	—	—	—	—	—	—
9.000	—	—	—	—	—	—	—	—	—	—
12.000	—	—	—	—	—	—	—	—	—	—
14.000	—	—	—	—	—	—	—	—	—	—
18.000	—	—	—	—	—	—	—	—	—	—
24.000	—	—	—	—	—	—	—	—	—	—

For cast sprocket hub dimensions, see Table 4.

For steel sprocket hub dimensions, see Table 5.

All of these sprockets are available in flame cut flame hardened fabricated steel. Contact Webster's customer service department for cast iron chilled rim availability.

Chain saver, minimum pitch line clearance and drag chain extended drum sprockets are available. Diameter and width must be specified for extended drum sprockets. Contact Webster's customer service department for availability.

Sprocket Pitch Diameters

TABLE 8 - PITCH DIAMETERS

Pitch in Inches	Number of Sprocket Teeth									
	36	37	38	39	40	41	42	43	44	45
1.375	15.776	16.214	16.651	17.088	17.524	17.963	18.400	18.837	19.274	19.712
1.500	17.211	17.688	18.165	18.642	19.117	19.596	20.073	20.550	21.027	21.504
1.506	17.279	17.758	18.237	18.716	19.193	19.674	20.153	20.632	21.111	21.590
1.630	18.702	19.220	19.739	20.257	20.774	21.294	21.812	22.331	22.849	23.367
1.631	18.714	19.232	19.751	20.270	20.787	21.307	21.826	22.344	22.863	23.382
1.634	18.748	19.268	19.787	20.307	20.825	21.346	21.866	22.385	22.905	23.425
1.654	18.977	19.503	20.029	20.555	21.080	21.607	22.133	22.659	23.185	23.711
2.308	26.481	27.215	27.949	28.683	29.415	30.151	30.885	31.619	32.353	33.087
2.609	29.935	30.765	31.594	32.424	33.251	34.083	34.913	35.743	36.572	37.402
2.636	30.245	31.083	31.921	32.760	33.595	34.436	35.274	36.113	36.951	37.789
3.000	34.422	35.376	36.330	37.284	38.235	39.192	40.146	41.100	42.054	43.008
3.075	35.282	36.260	37.238	38.216	39.190	40.171	41.149	42.127	43.105	44.083
3.170	36.372	37.380	38.388	39.396	40.401	41.412	42.420	43.429	44.437	45.445
3.675	42.166	43.335	44.504	45.672	46.837	48.010	49.178	50.347	51.516	52.684
3.690	42.339	43.512	44.685	45.859	47.029	48.206	49.379	50.553	51.726	52.899
4.000	—	—	—	—	—	—	—	—	—	—
4.040	—	—	—	—	—	—	—	—	—	—
4.063	—	—	—	—	—	—	—	—	—	—
4.083	—	—	—	—	—	—	—	—	—	—
4.090	—	—	—	—	—	—	—	—	—	—
4.610	—	—	—	—	—	—	—	—	—	—
4.760	—	—	—	—	—	—	—	—	—	—
5.000	—	—	—	—	—	—	—	—	—	—
5.188	—	—	—	—	—	—	—	—	—	—
6.000	—	—	—	—	—	—	—	—	—	—
6.050	—	—	—	—	—	—	—	—	—	—
6.125	—	—	—	—	—	—	—	—	—	—
7.000	—	—	—	—	—	—	—	—	—	—
7.240	—	—	—	—	—	—	—	—	—	—
8.000	—	—	—	—	—	—	—	—	—	—
9.000	—	—	—	—	—	—	—	—	—	—
12.000	—	—	—	—	—	—	—	—	—	—
14.000	—	—	—	—	—	—	—	—	—	—
18.000	—	—	—	—	—	—	—	—	—	—
24.000	—	—	—	—	—	—	—	—	—	—

TABLE 9 - HUNTING TOOTH PITCH DIAMETERS

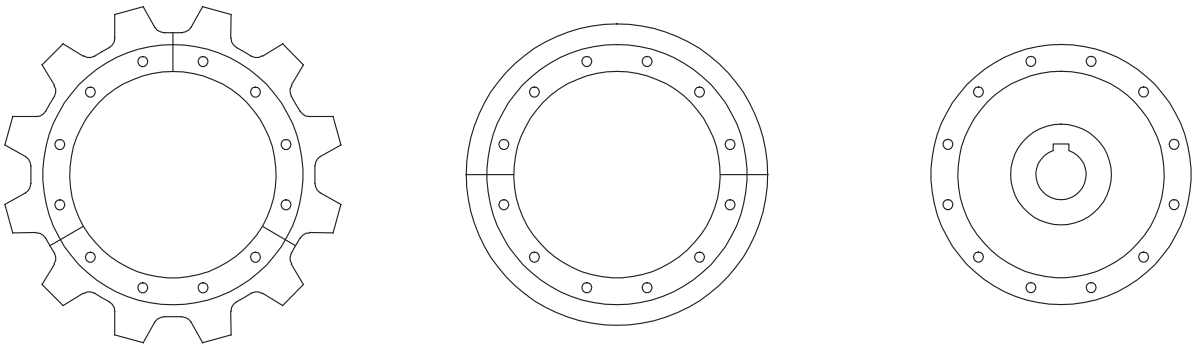
Pitch in Inches	Number of Sprocket Teeth				
	13	17	19	21	23
6.000	12.912	16.608	18.480	20.358	22.242

Hunting tooth sprockets are cast iron chilled rim and are used with 720S and 720NCS chains.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Segmental Sprockets and Traction Wheels

Hub and Body Selection Information



In selecting hubs and bodies for segmental sprockets and traction wheels the following procedure is recommended:

BODY SELECTION

MATERIAL

Hubs and bodies for segmental sprockets and traction wheels can be furnished in either cast iron or steel. All rims are furnished in flame cut flame hardened steel.

BODY SIZE

The largest body which can be used should be selected. The limiting factor for body size is the chain clearance diameter, which must be greater than the outside diameter of the body. The recommended body sizes for several commonly used segmental sprockets and traction wheels are shown in Tables 11 and 12. Segmental sprockets and traction wheels for other chains and numbers of teeth can be furnished. Contact Webster's customer service department for the appropriate body size.

HUB SELECTION

The following procedure should be followed for hub selection for segmental sprockets and traction wheels.

1. The maximum allowable hub diameter must be determined. This is shown for various body sizes in Table 10.
2. For solid cast, solid steel and split cast hubs, follow the selection procedure outlined on page I-4, making sure that the hub diameter is not greater than the maximum allowable as listed in Table 10. For split cast hubs, the Clearance Dimension C shown in Table 7, page 1-9, must be smaller than the maximum allowable hub diameter listed in Table 10.
3. For split steel hubs or shear pin hubs, contact Webster's customer service department.

TABLE 10 - MAXIMUM HUB DIAMETER FOR VARIOUS BODIES

Steel Body Number	Max. Hub Dia. in Inches
8	7
10	9
12	11
14	13
16	15
18	17
20	19

Cast Iron Body Number	Max. Hub Dia. in Inches
8	4¾
10	6¾
12	7¾
14	10¾
16	11¾
20	15¾

Body Number is diameter of shoulder on hub.

Segmental Sprockets and Traction Wheels

Hub and Body Selection Information

TABLE 11 - SEGMENTAL SPROCKET RIMS

Chain No.	No. of Teeth	Pitch Dia.	Use Body Number
H74	20	16.676	10
H78	24	19.987	12
C188	28	23.300	16
N102B	16	20.504	10
HSB102B	19	24.304	16
N110	13	25.074	16
HSB110	16	30.756	20
N111	16	24.399	16
HSB111	20	30.425	20
N132	13	25.282	16
HSB150+	15	31.012	20
HSB844	11	21.300	14
HSB844	15	28.860	20
HSB850	15	28.860	20
HSB856B	10	19.416	10
HSB857A	11	21.300	12
HSB857A	13	25.074	16
HSB857A	15	28.860	20
HSB2858A	13	25.074	16
HSB2858A	15	28.860	20
HSB859B	13	25.074	16
HSB859B	15	28.860	20

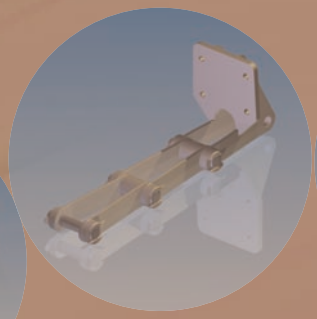
TABLE 12 - SEGMENTAL TRACTION WHEEL RIMS

Chain No.	Outside Dia.	Use Body Number
H74	20	14
H78	22	16
N102B	20	14
N110	24	16
HSB102B	30	20
N102½	20	14
HSB102½	24	16
HSB102½	30	20
N111	24	16
HSB111	30	20
N132	24	16
HSB150+	28	20
HSB150+	30	20
HSB844	20	12
HSB856B	20	12
HSB857A	24	16
HSB857A	28	20
HSB859B	24	16
HSB864B	28	20

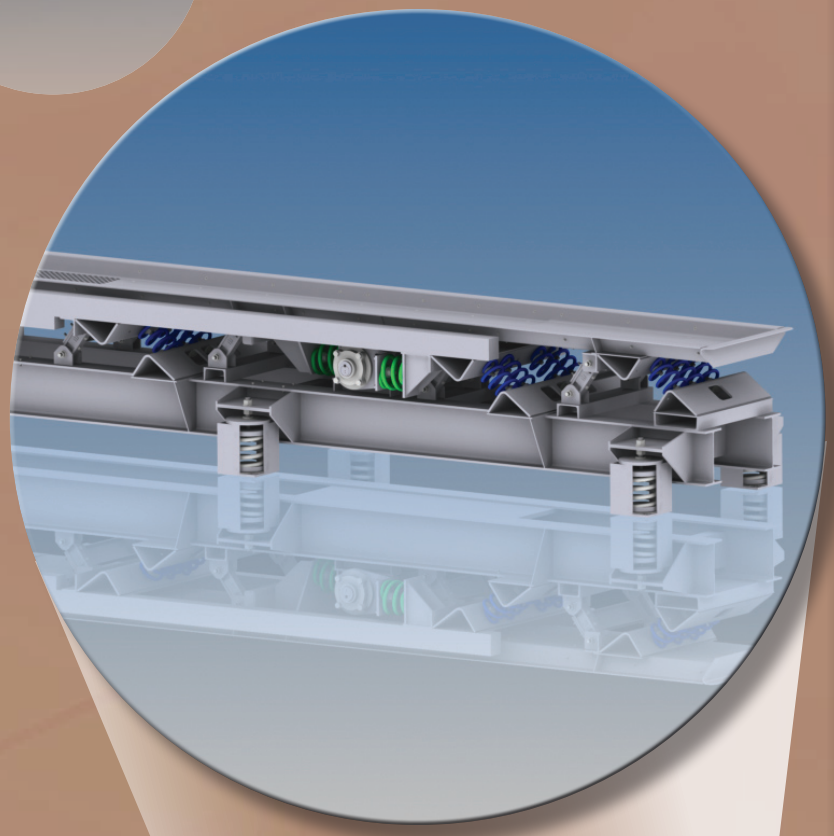
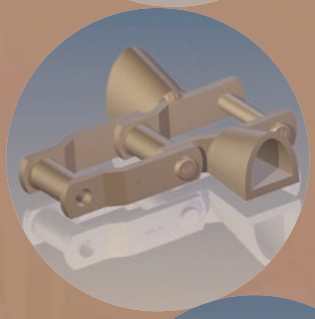
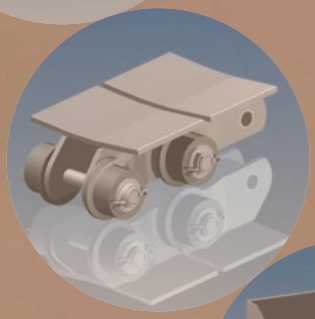
Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Notes

VIBRATING CONVEYORS

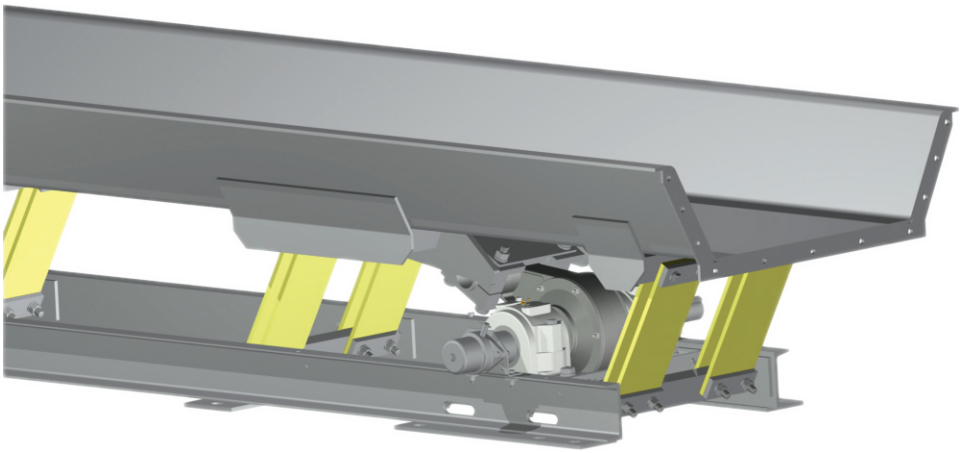





FS and CoilWeb® series vibrating conveyors are covered in this section, along with technical data. For further information, contact your nearest Webster distributor or call direct to Webster's customer service department.

FS Series Vibrating Conveyors



This series includes the FSL, a light-duty, low headroom conveyor for small particle, low capacity applications; the FSM, a medium-duty conveyor for small particle, higher capacity applications; and the FSH, a medium to heavy-duty conveyor for a larger particle size and increased capacity applications. All of these conveyors incorporate the natural frequency principle, controlled vibration, positive eccentric drive and standardized sectional construction. They provide a rugged and economical answer to many bulk material conveying and processing jobs throughout the industry.

FS series vibrating conveyors will convey granular or lump material ranging in size from minus 100 mesh to any lump size which will fit into the pan. These conveyors can handle weight from several pounds to several hundred pounds per cubic foot. They are particularly well suited for conveying hot, heavy, sharp or abrasive materials which are not readily handled on other types of conveyors. They also may be adapted to processing operations such as inspecting, sorting, screening, washing, dewatering, heating, cooling and drying.

The following pages detail the dimensions of our standard pan sizes. Other pan sizes and shapes are available. The FS series vibrating conveyors can be custom designed to best suit your application.

MATERIAL

The FS series vibrating conveyors incorporate fabricated steel pans, a natural frequency spring system, a positive eccentric drive powered by an electric motor and v-belts on a fabricated steel base.

ASSEMBLY

Standard drive and extension sections are delivered in preassembled sections. Jig fixtured, bolted pan flanges make field assembly easy.

APPLICATION

FS series vibrating conveyors are used where horizontal or shallow inclined conveying is required. They handle a wide variety of bulk materials from powders to solids. They are well suited to handle fragile, sharp and irregularly shaped materials. They are primarily used in the forest products, stamping, food, grain and chemical industries.

FS Series Components

FLAT SPRINGS

The springs used in the FS series vibrating conveyors are fabricated of a glass filament reinforced plastic which has extremely high flexural strength and excellent resistance to heat, moisture and chemical exposure. These springs are conservatively stressed and will have an extremely long life if the conveyor is properly installed and maintained.

POSITIVE ECCENTRIC DRIVE

Very little driving force is required when a vibrating conveyor is operating without load and at or close to its natural frequency. The material being conveyed or a buildup of material on the pan will cause significant increases in the driving force required. The positive eccentric drives used in the FS series vibrating conveyors will maintain constant amplitude under the variations in loading which occur in normal operation.

These drives are equipped with heavy-duty spherical roller bearings on the eccentric shaft and with a steel encased rubber bushing at the pan end of the connecting rod. This rubber bushing reduces drive forces when starting and stopping, eliminates the need for lubrication at this point and reduces the noise level of the machine.

The bearings used are designed so that they cannot be damaged by excessive lubrication.

STANDARDIZED SECTIONAL CONSTRUCTION

The FS series vibrating conveyors are standardized sectional conveyors. They are built in 10 foot long sections which are bolted together. Odd length sections are available for use at the ends of the conveyor when the length is not a multiple of 10 feet. The pans are fabricated of mild carbon steel. The thickness and cross-sectional dimensions of the pans for the various standard sections are shown on the following pages. Pans fabricated of other materials or having different dimensions are available.

UNBALANCED OR ISOLATED CONSTRUCTION

Standard FS series vibrating conveyors are unbalanced machines and must be installed on a substantial foundation or supporting structure which is usually at or below ground level. If the conveyor is to be installed on an elevated structure, it is desirable to reduce the dynamic reaction transmitted to the supports, it may be equipped with a heavy inertia base and soft isolating springs. This type of construction will reduce the forces transmitted to the support by 85% to 95%.

STANDARD AND HIGH TEMPERATURE CONSTRUCTION

Webster FS series vibrating conveyors are available in two types and the selection of the proper type is dependent on the temperature of the material being conveyed. When material temperature is no higher than 150° to 200° F, standard or nonexpansion construction is used. For hotter materials high temperature or heat expansion construction can be used, or a switch to CoilWeb® series may be recommended. The high temperature type is designed so the pan is free to expand and contract and warpage is controlled. Air-oil mist type lubrication is available if required for hot, humid or very dirty environments.

Model	Standard Construction	Heat-Expansion Construction
FSL	150º F	CoilWeb®
FSM	150º F	CoilWeb®
FSH	150º F	CoilWeb®
CoilWeb®	200º F	800° F

ACCESSORIES

A wide range of optional features are available for use with FS series vibrating conveyors. Included are covers, side or bottom discharges, intermediate discharges with gates, pans with multiple compartments or channels, screen sections, nonmagnetic pan sections for use with magnetic separators, nonmetallic pan sections for use with metal detectors, steel pan liners for impact or abrasion resistance, rubber pan liners for wear resistance or noise reduction, special discharges for feeding process equipment and steel support structures.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Model FSL Conveyors

For Light-Duty, Low Headroom Applications

Webster FSL vibrating conveyors are light-duty, low headroom models for small particle size and low capacity applications. They can handle granular or lumpy materials, metal or plastic parts, scrap and food products economically and with minimum power.

In addition to the standard sections shown on the following pages other pan sizes and shapes, accessories and special features can be supplied.

DRIVE

Webster FSL vibrating conveyors are equipped with the P3000 positive eccentric drive. It is equipped with heavy-duty, self-aligning roller bearings.

SELECTION

See vibrating conveyors in Section A for further information on selection.

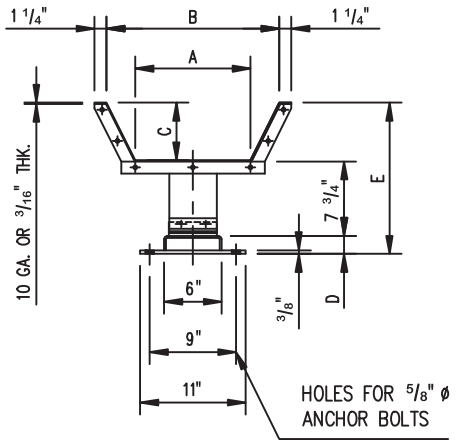
DETAILS OF CONSTRUCTION

Pans for standard FSL vibrating conveyors are made with the sides flared so the width is greater at the top than at the bottom. Standard pan bottom widths are 12" and 18". Standard pan thickness is No. 10 gauge for the 12" and 3⁄16" for the 18" wide.

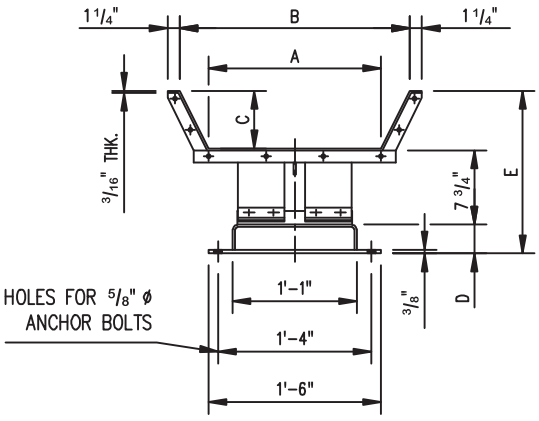
The base is a heavy formed steel channel with the web on top. This style of base has no pockets to catch and hold foreign material. The base has anchor bolt pads welded on its underside so it contacts the foundation only where it is attached.

FSL CROSS SECTION DIMENSIONS

Pan Size	A	B	C	D	E	Base
12/16	12"	16"	4"	1 7⁄8"	1'-1 3⁄4"	Narrow
12/18	12"	18"	6"	1 7⁄8"	1'-3 3⁄4"	Narrow
18/22	18"	22"	4"	3"	1'-2 15⁄16"	Wide
18/24	18"	24"	6"	3"	1'-4 15⁄16"	Wide

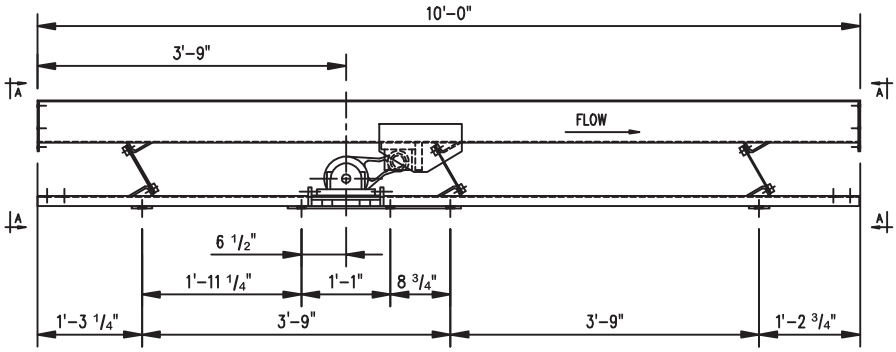


VIEW A-A
NARROW BASE
PAN BOTTOM 8" MIN. TO 15" MAX.

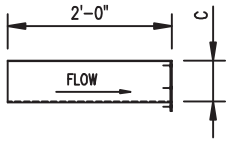


VIEW A-A
WIDE BASE
PAN BOTTOM 15" MIN. TO 18" MAX.

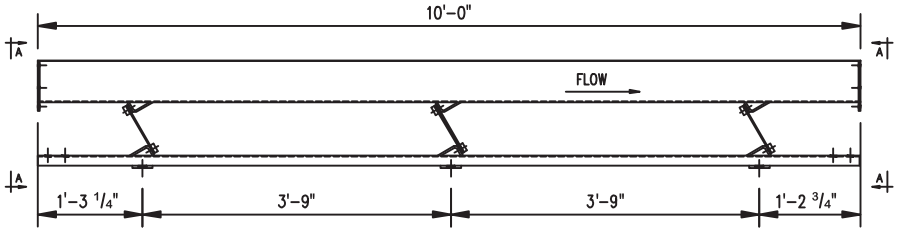
Model FSL Conveyors



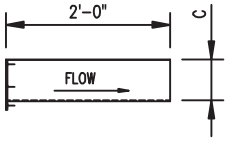
STANDARD DRIVE SECTION



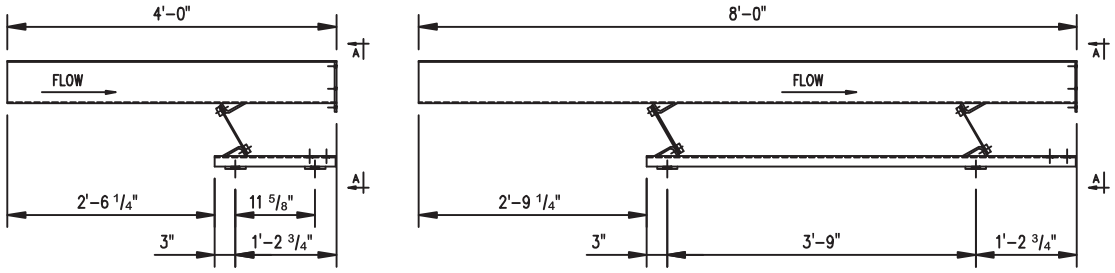
FEED END PAN ADDITION SECTION



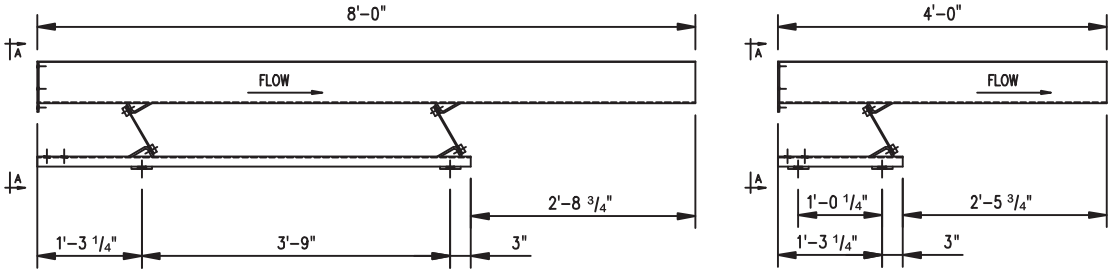
STANDARD EXTENSION SECTION



DISCHARGE END PAN ADDITION SECTION



FEED END EXTENSION SECTIONS



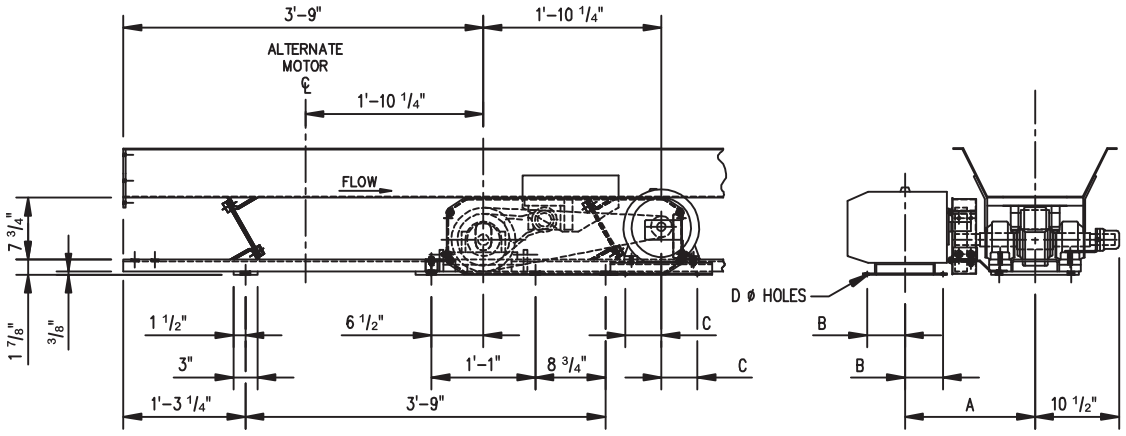
DISCHARGE END EXTENSION SECTIONS

VIBRATING CONVEYORS

J

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

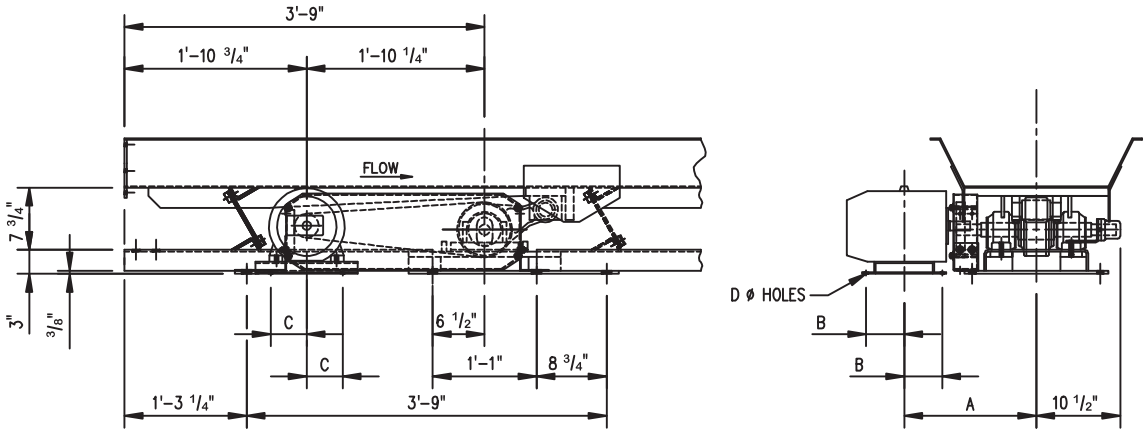
Model FSL Conveyors



DRIVE ARRANGEMENT NARROW BASE CONVEYOR

Motor Size 1200 RPM	Frame No.	A	B	C	D
1 HP	145T	15½"	3⅞"	3¾"	⅜"
2 HP	184T	16½"	4¾"	4½"	½"
3 HP	213T	17¾"	4¾"	5¼"	½"

Motor may be assembled on either side of conveyor.



DRIVE ARRANGEMENT WIDE BASE CONVEYOR

Motor Size 1200 RPM	Frame No.	A	B	C	D
1 HP	145T	15½"	3⅞"	3¾"	⅜"
2 HP	184T	16½"	4¾"	4½"	½"
3 HP	213T	17¾"	4¾"	5¼"	½"
5 HP	215T	18½"	5½"	5¼"	½"

Motor may be assembled on either side of conveyor.

Model FSM Conveyors
For Medium-Duty Applications

Webster FSM vibrating conveyors are rugged, medium-duty models for small particle size material. Granular materials as fine as minus 100 mesh and lump materials up to any size that fits the pan can be conveyed. Their simplicity of design means little maintenance and low power requirements.

In addition to the standard sections shown on the following pages other pan sizes and shapes, accessories and special features can be supplied.

DRIVE
Webster FSM vibrating conveyors are equipped with the P5000 positive eccentric drive. It is equipped with heavy-duty, self-aligning roller bearings.

SELECTION
See vibrating conveyors in Section A for further information on selection.

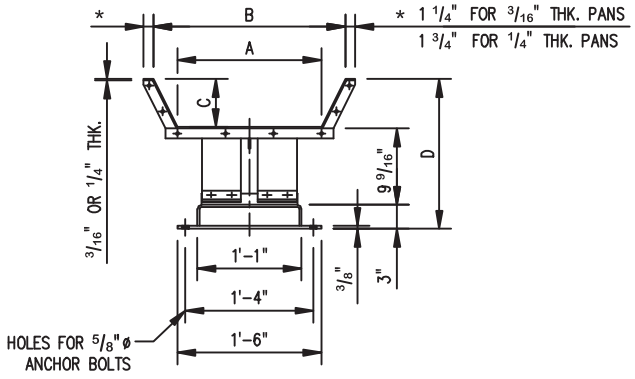
DETAILS OF CONSTRUCTION
Pans for standard FSM vibrating conveyors are made with the sides flared so the width is greater at the top than at the bottom. Standard pan bottom widths are 18" and 24". Standard pan thicknesses are 3⁄16" and 1⁄4".

The base is a heavy formed steel channel with the web on top. This style of base has no pockets to catch and hold foreign material. The base has anchor bolt pads welded on its underside so it contacts the foundation only where it is attached.

FSM CROSS SECTION DIMENSIONS

Pan Size	A	B	C	D
18/24	18"	24"	6"	1'-6¾"
18/27	18"	27"	9"	1'-9¾"
24/30	24"	30"	6"	1'-6¾"
24/33	24"	33"	9"	1'-9¾"

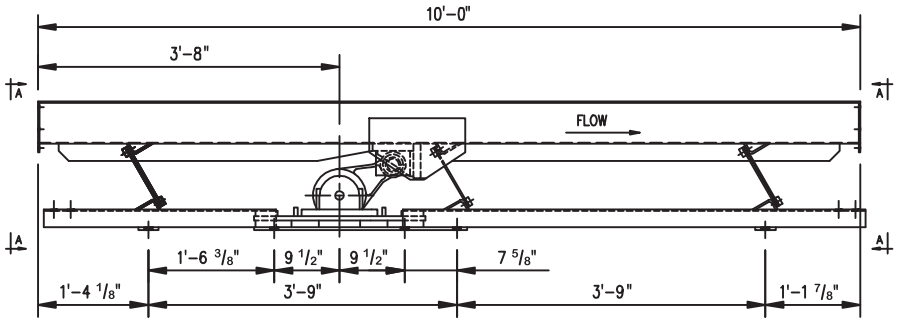
D Dimension - Add 1⁄16" for 1⁄4" thick pans.



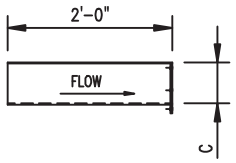
VIEW A-A

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

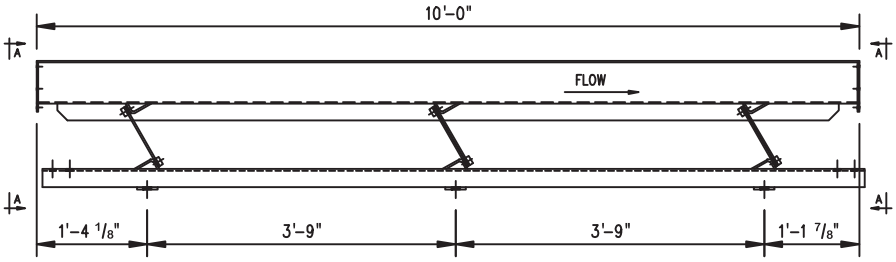
Model FSM Conveyors



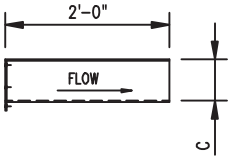
STANDARD DRIVE SECTION



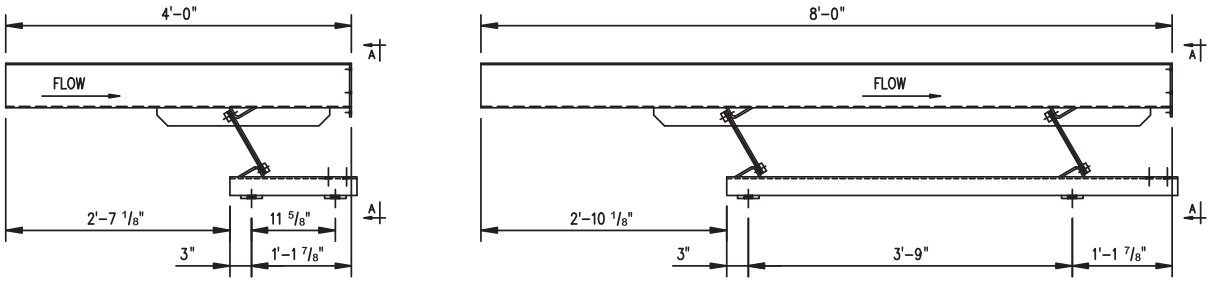
FEED END PAN ADDITION SECTION



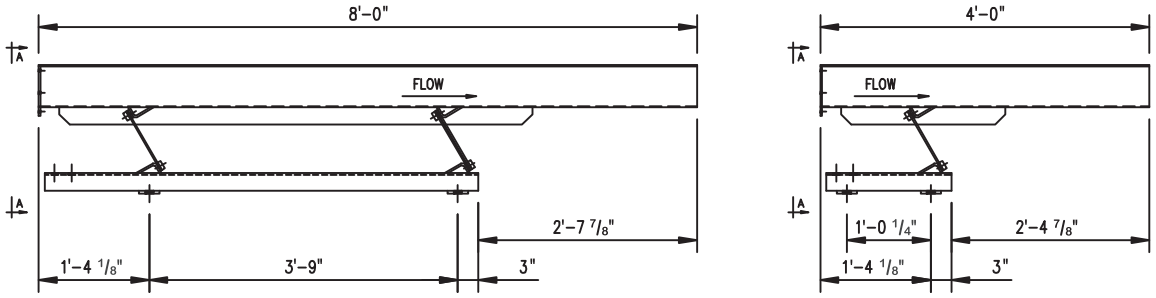
STANDARD EXTENSION SECTION



DISCHARGE END PAN ADDITION SECTION

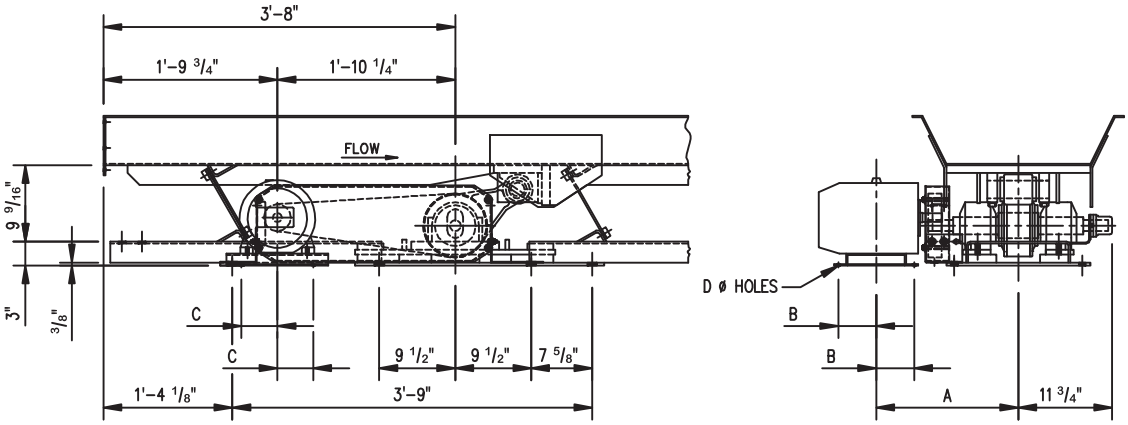


FEED END EXTENSION SECTIONS



DISCHARGE END EXTENSION SECTIONS

Model FSM Conveyors



DRIVE ARRANGEMENT

Motor Size 1200 RPM	Frame No.	A	B	C	D
2 HP	184T	17¾"	4¾"	4½"	½"
3 HP	213T	19"	4¾"	5¼"	½"
5 HP	215T	19¾"	5½"	5¼"	½"
7½ HP	254T	23"	6⅝"	6¼"	⅝"
10 HP	256T	23⅞"	7½"	6¼"	⅝"

Motor may be assembled on either side of conveyor.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Model FSH Conveyors

For Heavy-Duty Applications

Webster FSH vibrating conveyors are heavy-duty models for applications with larger particle size and increased capacities. They can handle large amounts of heavy, abrasive materials such as sand, castings and scrap.

In addition to the standard sections shown on the following pages other pan sizes, accessories and special features can be supplied.

DRIVE

Webster FSH vibrating conveyors are equipped with the P8000 positive eccentric drive. It is equipped with heavy-duty, self-aligning roller bearings.

SELECTION

See vibrating conveyors in Section A for further information on selection.

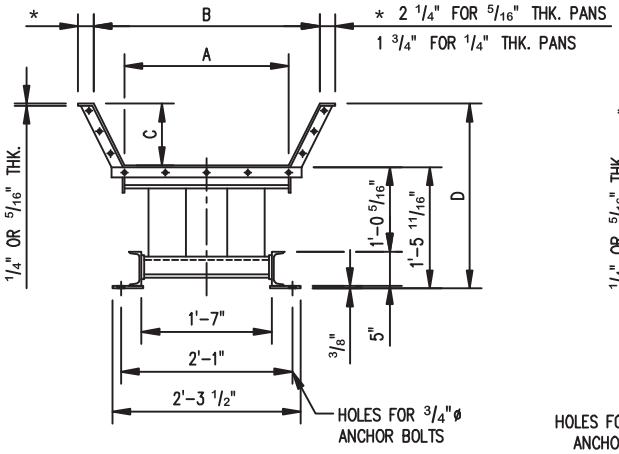
DETAILS OF CONSTRUCTION

Pans for standard FSH vibrating conveyors are made with the sides flared so the width is greater at the top than at the bottom. Standard pan bottom widths are 18", 24", 30" and 36". Standard pan thickness is ¼" for the 18" nonexpansion type and 5⁄16" for all others.

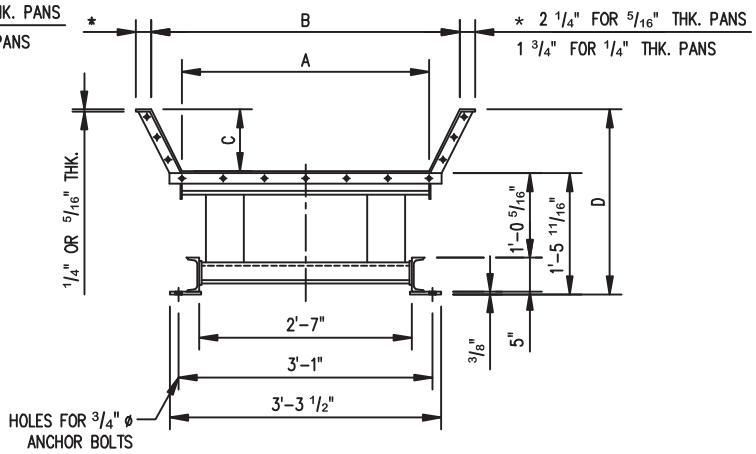
The base is a pair of rolled steel channels. Anchor bolt pads are welded on its underside so it contacts the foundation only where it is attached.

FSH CROSS SECTION DIMENSIONS

Pan Size	A	B	C	D	Base
18/24	18"	24"	6"	1'-11 15⁄16"	Narrow
18/27	18"	27"	9"	2'-2 15⁄16"	Narrow
18/30	18"	30"	12"	2'-5 15⁄16"	Narrow
24/30	24"	30"	6"	2'-0"	Narrow
24/33	24"	33"	9"	2'-3"	Narrow
24/36	24"	36"	12"	2'-6"	Narrow
30/36	30"	36"	6"	2'-0"	Wide
30/39	30"	39"	9"	2'-3"	Wide
30/42	30"	42"	12"	2'-6"	Wide
36/42	36"	42"	6"	2'-0"	Wide
36/45	36"	45"	9"	2'-3"	Wide
36/48	36"	48"	12"	2'-6"	Wide

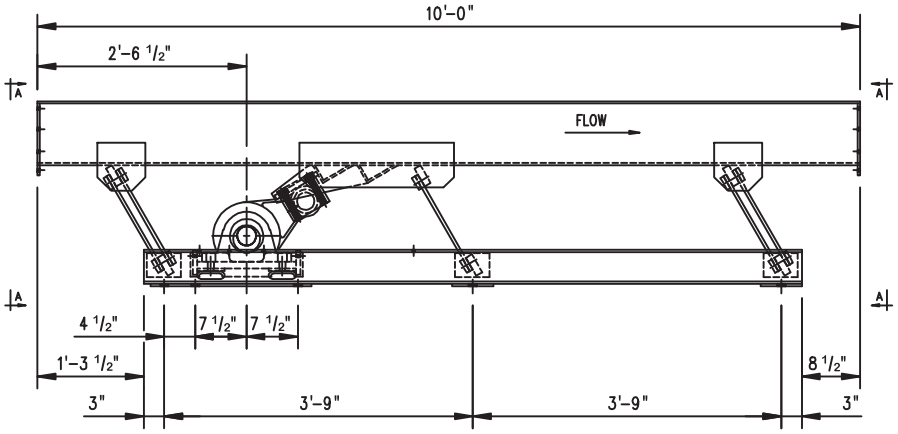


VIEW A-A
NARROW BASE
PAN BOTTOM 18" MIN. TO 24" MAX.

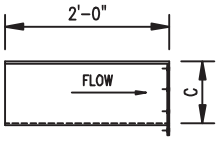


VIEW A-A
WIDE BASE
PAN BOTTOM 30" MIN. TO 36" MAX.

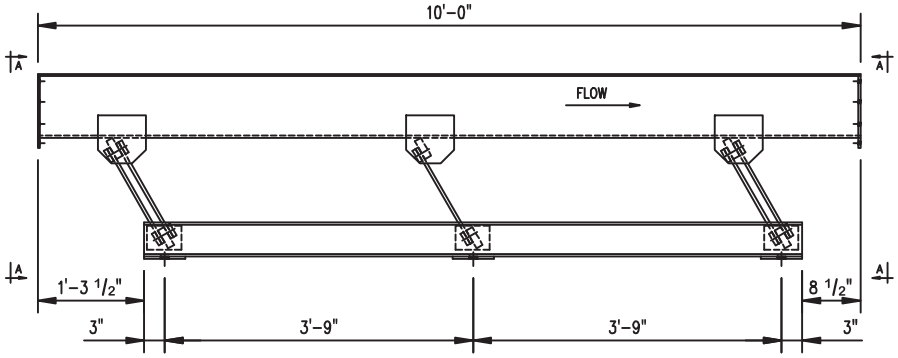
Model FSH Conveyors



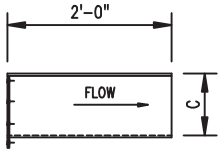
STANDARD DRIVE SECTION



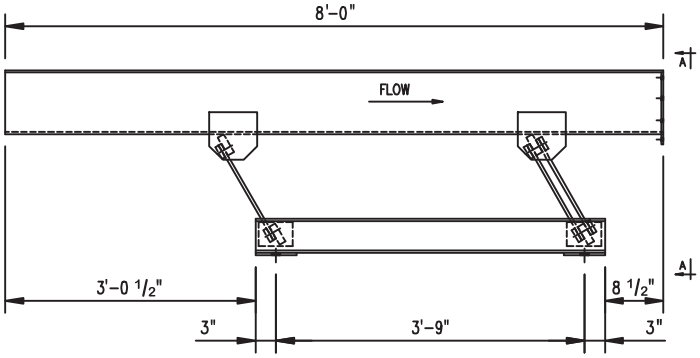
FEED END PAN ADDITION SECTION

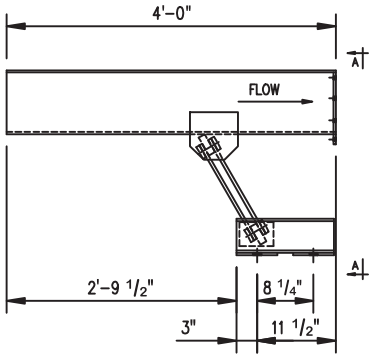


STANDARD EXTENSION SECTION

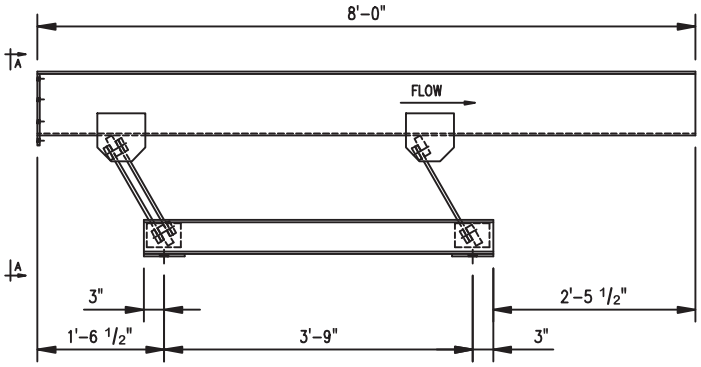


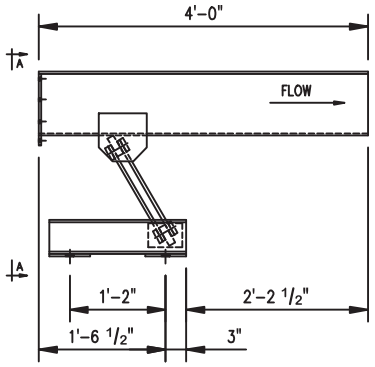
DISCHARGE END PAN ADDITION SECTION





FEED END EXTENSION SECTIONS

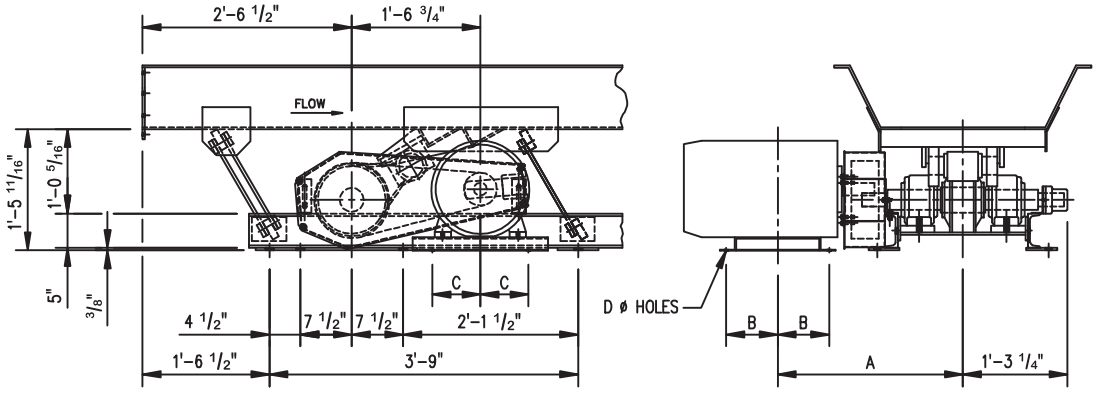




DISCHARGE END EXTENSION SECTIONS

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

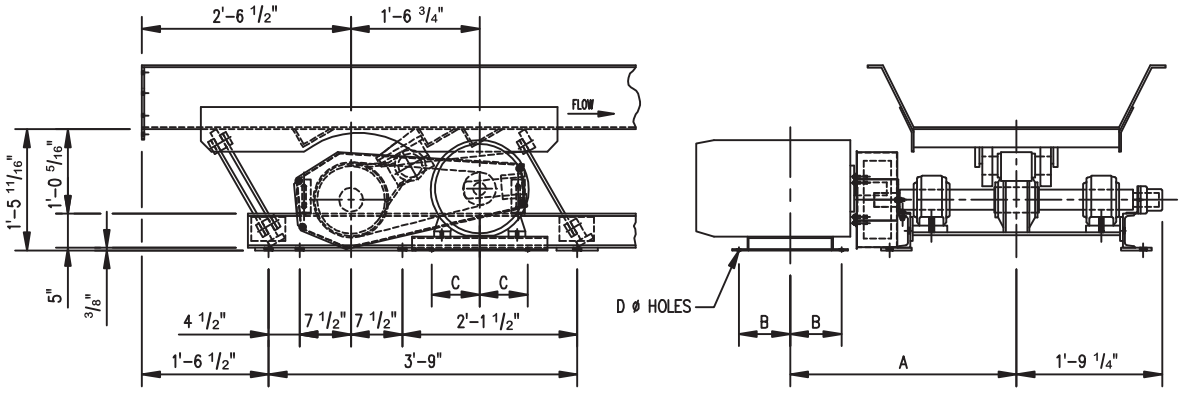
Model FSH Conveyors



DRIVE ARRANGEMENT NARROW BASE CONVEYOR

Motor Size 1200 RPM	Frame No.	A	B	C	D
3 HP	213T	22⅛"	4¾"	5¼"	½"
5 HP	215T	22⅞"	5½"	5¼"	½"
7½ HP	254T	24⅜"	6⅝"	6¼"	⅝"
10 HP	256T	25¼"	7½"	6¼"	⅝"
15 HP	284T	27"	7½"	7"	⅝"
20 HP	286T	28"	8¼"	7"	⅝"

Motor may be assembled on either side of conveyor.



DRIVE ARRANGEMENT WIDE BASE CONVEYOR

Motor Size 1200 RPM	Frame No.	A	B	C	D
3 HP	213T	28⅛"	4¾"	5¼"	½"
5 HP	215T	28⅞"	5½"	5¼"	½"
7½ HP	254T	30⅜"	6⅝"	6¼"	⅝"
10 HP	256T	31¼"	7½"	6¼"	⅝"
15 HP	284T	33"	7½"	7"	⅝"
20 HP	286T	34"	8¼"	7"	⅝"

Motor may be assembled on either side of conveyor.

CoilWeb® Series Vibrating Conveyors



This series of heavy-duty service conveyors includes the models CoilWeb® and CoilWeb® LS, both with a broad range of capabilities for your tough conveying applications. The CoilWeb® series features include the use of the natural frequency principle utilizing coil springs, controlled vibration, semipositive coil spring drive and standardized spring and rocker arm components. They provide a heavy-duty solution for your severe bulk material handling and processing jobs.

CoilWeb® vibrating conveyors will convey granular or lump materials ranging in size from minus 100 mesh to any lump size which will fit into the pan. These conveyors can handle density ranging from several pounds to several hundred pounds per cubic foot. The CoilWeb® in particular is better suited for heavily loaded hot or abrasive material applications which are not readily handled by other conveyors. The CoilWeb® conveyors may also be adapted to do processing operations such as screening, sorting, washing, dewatering, cooling or drying.

The following pages detail standard pan size and capacity information. Other pan sizes and shapes are available. The CoilWeb® series vibrating conveyors can be custom designed to suit your application.

MATERIAL

The CoilWeb® series vibrating conveyors incorporate fabricated steel pans, a natural frequency spring system, a semipositive eccentric drive powered by an electric motor and v-belts on a fabricated steel base.

ASSEMBLY

Standard drive and extension sections are delivered in preassembled sections. Standard welded pan joints or jig fixtured, bolted pan flanges are available for joining the sections together.

APPLICATION

CoilWeb® series vibrating conveyors are used where horizontal or shallow inclined conveying is required. They handle a wide variety of bulk materials from powders to solids. They are well suited to handle fragile, sharp and irregularly shaped materials. They are primarily used in the forest products, stamping, food, grain, foundry and die cast industries.

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

CoilWeb® Series Components

SPRING ASSEMBLIES

The coil springs used in the CoilWeb® series vibrating conveyors are fabricated of alloy steel. Each spring assembly location includes rocker arms to control the direction of vibration. Rubber bushings are located at both ends of a malleable iron rocker arm for a nonlubricated joint. This super-duty design of coil spring assemblies, along with the heavy-duty pan construction, is built to operate in harsh environments and heavy material loading, providing long service life without maintenance.

COIL SPRING DRIVE

CoilWeb® series vibrating conveyors feature a semipositive drive. These drives are equipped with heavy-duty, self-aligning roller bearing pillow blocks, heavy-duty flange mount connecting rod bearings and a coil drive spring pan connection. The incorporation of the drive springs substantially lowers the starting and full load torque requirements resulting in dramatic horsepower reduction over a positive connected drive.

Once a conveyor reaches its operating speed, very little drive force is required because the pan spring system's resonant frequency. This results in very little relative deflection between the connecting rod and the drive-spring system. This design will substantially reduce torque and horsepower requirements.

UNBALANCED OR BALANCED CONSTRUCTION

The standard unbalanced CoilWeb® series vibrating conveyors develop a dynamic reaction and must be installed on an appropriate foundation or support structure, which is usually at or below ground level. For installations requiring a minimum transmission of the dynamic reaction to supports, a selection of balanced, isolated or balanced/isolated construction is available.

In the balanced construction, a balancer is driven 180º out of phase to the pan. This balancer is equal in mass to the pan and has a duplicate reactor spring assembly system. Being 180º out of phase results in two equal and opposite dynamic reactions that cancel out 80% to 95% of the dynamic reaction to the supports.

In the isolated construction a relatively short length CoilWeb® vibrating conveyor is equipped with a heavy moving inertia base and is mounted to the support structure on soft isolation springs. This type of construction, less complex than balancing, reduces the reaction forces by 85% to 95%.

A combination balanced/isolated construction can be utilized to provide the maximum dampening of the dynamic reaction.

STANDARD AND HIGH TEMPERATURE HEAVY-DUTY CONSTRUCTION

Webster CoilWeb® series vibrating conveyors are also available in two construction types depending on the temperature of the material being conveyed. The standard type of construction is used when material temperature is no higher than 150º to 200º F. For hotter materials, heat expansion construction is used. The heat expansion type is designed so that the pan is free to expand or contract independently from the reactor spring and drive systems. This heat expansion pan is also designed to reduce heat conduction to the spring and drive systems.

Model	Standard Construction	Heat-Expansion Construction
FSL	150º F	CoilWeb®
FSM	150º F	CoilWeb®
FSH	150º F	CoilWeb®
CoilWeb®	200º F	800° F

ACCESSORIES

A wide range of optional features are available for use with CoilWeb® series vibrating conveyors. Included are covers, side or bottom discharges, intermediate discharges with gates, pans with multiple compartments or channels, screen sections, nonmagnetic pan sections for use with magnetic separators, nonmetallic pan sections for use with metal detectors, steel pan liners for impact or abrasion resistance, rubber pan liners for wear resistance or noise reduction, special discharges for feeding process equipment and steel support structures.

Models CoilWeb® and CoilWeb® LS Conveyors

For Heavy-Duty Applications

SELECTION

See vibrating conveyors in Section A for further information on selection.

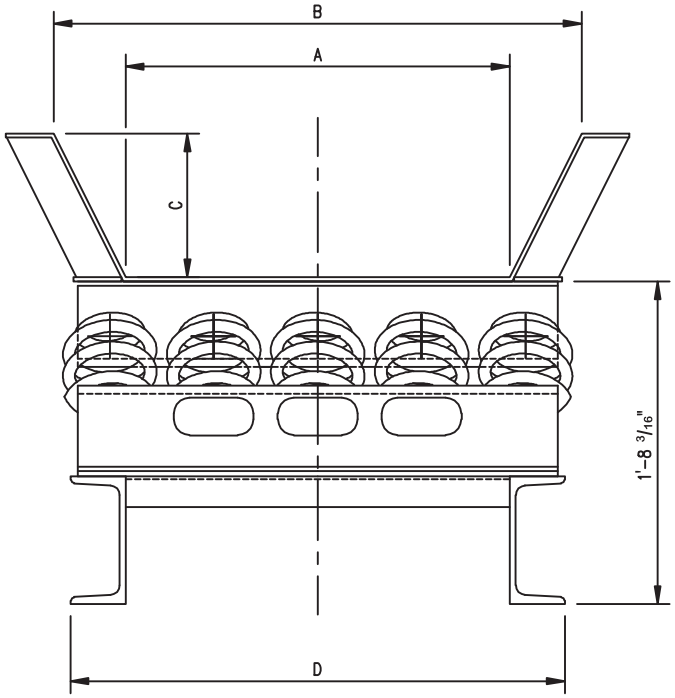
DETAILS OF CONSTRUCTION

Pans for the standard CoilWeb® and CoilWeb® LS vibrating conveyors are made with the sides flared so the width at the top is greater than at the bottom. Standard pan bottom widths are in 6" increments from 18" to 48" wide. Standard pan thicknesses are ¼", 5/16" and ⅜" depending on the application. The spring pads are a heavy fabricated angle weldment. Other sizes including wider pans are available.

The standard base is made of heavy rolled structural channel with cross members welded in place at the spring pads and rocker arms. Anchor pads may be welded under the base channel by the customer. This raises the base so it contacts an uneven foundation only where the base is to be attached.

COILWEB® UNBALANCED CROSS SECTION DIMENSIONS

Pan Size	A	B	C	D
18/24	18"	24"	6"	2'-1"
18/27	18"	27"	9"	2'-1"
18/30	18"	30"	12"	2'-1"
24/30	24"	30"	9"	2'-7"
24/33	24"	33"	9"	2'-7"
24/36	24"	36"	12"	2'-7"



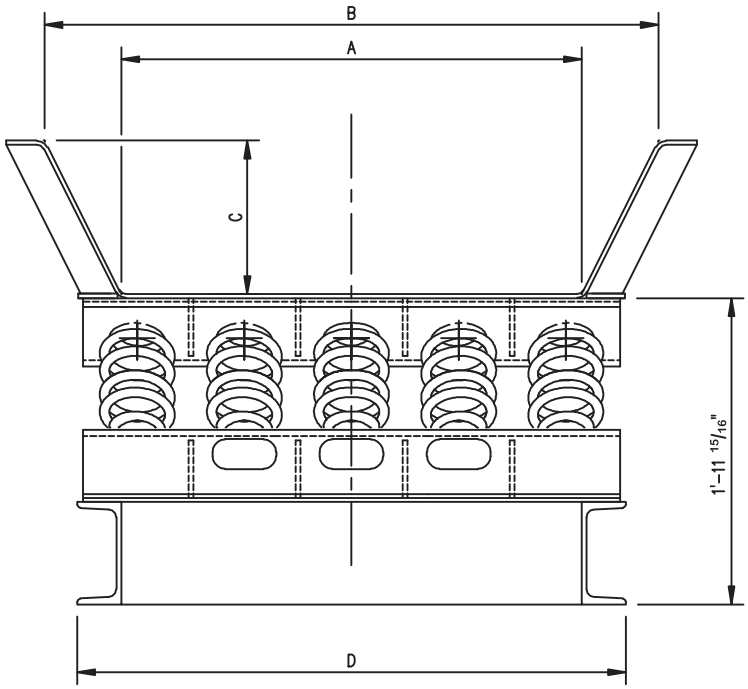
COILWEB® UNBALANCED

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

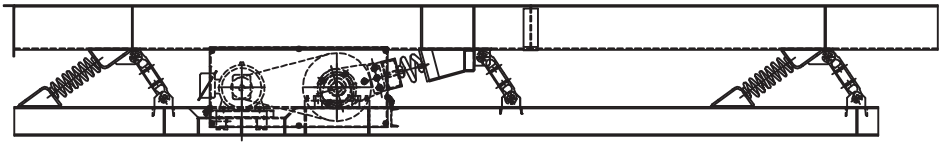
Model CoilWeb® LS Conveyors

COILWEB® LS UNBALANCED CROSS SECTION DIMENSIONS

Pan Size	A	B	C	D
24/30	24"	30"	6"	2'-7"
24/33	24"	33"	9"	2'-7"
24/36	24"	36"	12"	2'-7"
30/36	30"	36"	6"	3'-1"
30/39	30"	39"	9"	3'-1"
30/42	30"	42"	12"	3'-1"
36/42	36"	42"	6"	3'-7"
36/45	36"	45"	9"	3'-7"
36/48	36"	48"	12"	3'-7"



COILWEB® LS UNBALANCED

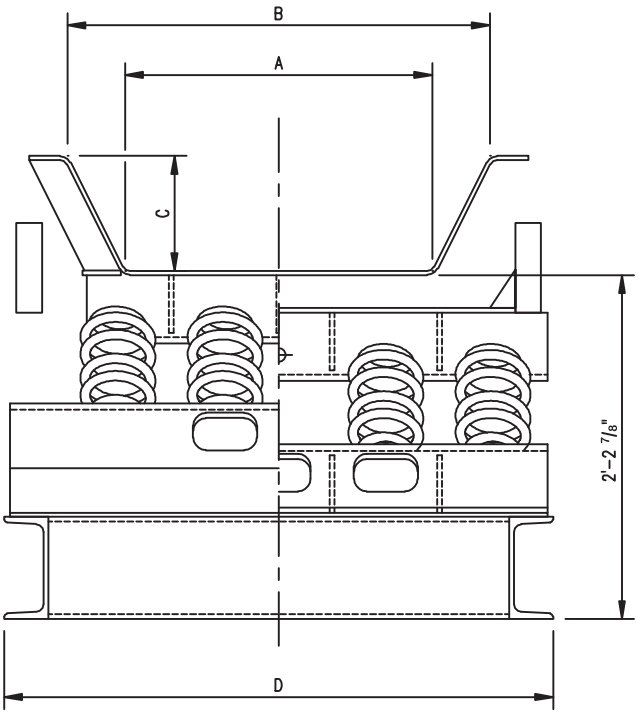


TYPICAL COILWEB® LS ELEVATION

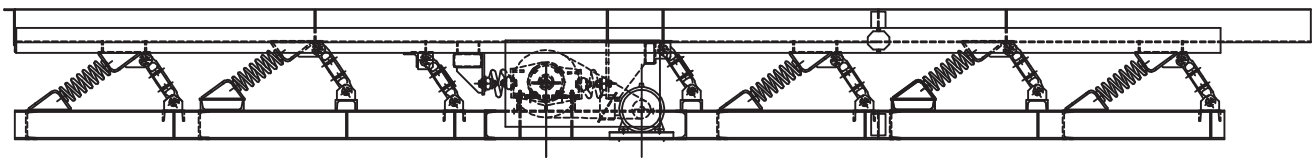
Model CoilWeb® LS Conveyors

COILWEB® LS BALANCED CROSS SECTION DIMENSIONS

Pan Size	A	B	C	D
24/30	24"	30"	6"	3'-7"
24/33	24"	33"	9"	3'-7"
24/36	24"	36"	12"	3'-7"
30/36	30"	36"	6"	4'-1"
30/39	30"	39"	9"	4'-1"
30/42	30"	42"	12"	4'-1"
36/42	36"	42"	6"	4'-7"
36/45	36"	45"	9"	4'-7"
36/48	36"	48"	12"	4'-7"



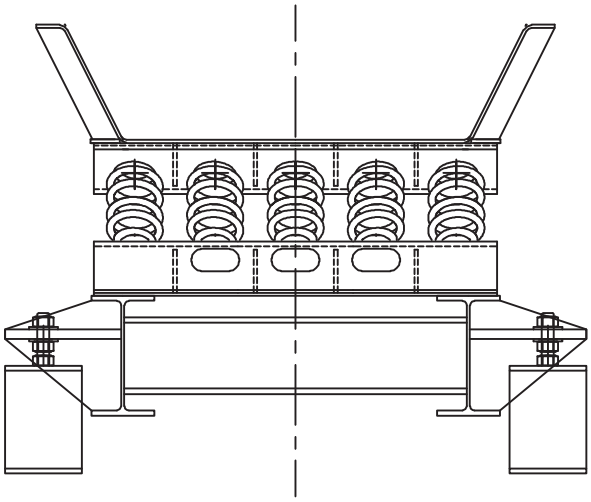
COILWEB® LS BALANCED



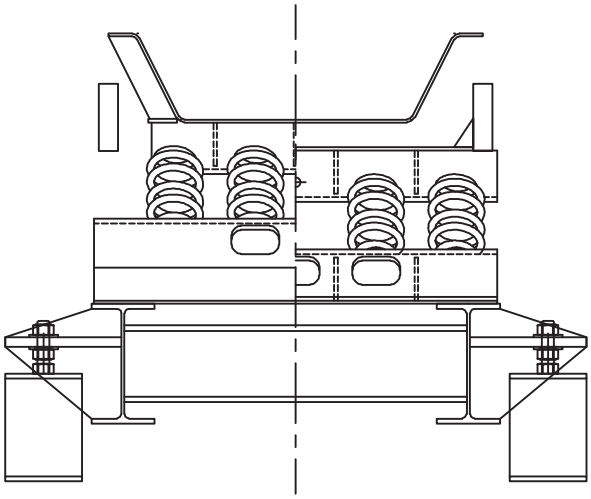
COILWEB® LS BALANCED ELEVATION

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
See Symbol Definitions in the Index Section.

Model CoilWeb® LS Conveyors



TYPICAL COILWEB® LS ISOLATED CROSS SECTION



TYPICAL COILWEB® LS BALANCED/ISOLATED CROSS SECTION

Notes

Have dimensions verified for installation purposes.
All dimensions in inches unless otherwise noted.
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S2847	SBR	E-12
HSB2858A	HSB	D-4
HSB2866	HSB	D-6
WHX3012	WSM	F-4
S3433	SBR	E-8
S3433SPC	SBR	E-8
DF3498	DF	G-24
DF3500	DF	G-24
S3600+	SBR	E-14
SS3888	SBR	E-14
3939	SBR	E-16
S3940	SBR	E-14
S3945	SBR	E-8
S3945SPC	SBR	E-8
S3952	SBR	E-8
S3968	SBR	E-8
S4001	SBR	E-4
S4002	SBR	E-6
S4003	SBR	E-10
S4004	SBR	E-20
S4009	SBR	E-20
S4019	SBR	E-6
S4065A	SBR	E-20
4103	400CP	B-2
4124	400CP	B-2
S4830	SBR	E-8
HSB4933	HSB	D-2
WHX5121HF	WSC	F-19
HSB5131	HSB	D-2
WHX5157HF	WSC	F-19
WHX6067HF	WSC	F-19
HSB6102½	HSB	D-6
6104	CTD	B-16
6110	CTD	B-16
WHX6121HF	WSC	F-19
HSB6124	HSB	D-6
HSB6322	HSB	D-6
HSB6472	HSB	D-2
S6910	SBR	E-14
8116	CTD	B-16
8480	CTD	B-16
SS9061	SBR	E-14
S9063	SBR	E-16
S9111A	SBR	E-8
HSB9124	HSB	D-6
HSB9150	HSB	D-6
ZA9184	SBR	E-16
S9833A	SBR	E-14
S9856B	SBR	E-16
S11524	TWS	G-26
S13917	TWS	G-26
S15030	TWS	G-26
S15041A	TWS	G-26

Numerical Chain Index Abbreviations

400CP	400 Class Pintle Chain
700CP	700 Class Pintle Chain
C	Combination Chain
COR	Combination Outboard Roller Chain
CRT	Combination Rooftop Transfer Chain
CTD	Combination Type Drag Chain
CWS	Combination Wear Shoe Chain
DBR	Delrin Bushed Roller Chain
DF	Double Flex Chain
EF	ENDURO-FLITE®
HCM	H Class Mill Chain
HSB	Hardened Steel Bushed Chain
HSBTS	Hardened Steel Bushed Turbo Series Chain
HTD	H Type Drag Chain
IC	Intermediate Carrier Chain
RT	Rooftop Transfer Chain
SBR	Steel Bushed Roller Chain
TWS	Traveling Water Screen Chain
WS7200	Welded Steel 720 Offset Chain
WSC	Welded Steel Clinker Chain
WSD	Welded Steel Drag Chain
WSHDD	Welded Steel Heavy-Duty Drag Chain
WSM	Welded Steel Mill Chain
WSSM	Welded Stainless Steel Mill Chain

Symbol Definitions

★	Subject to Service Factor Table 9 and Speed Factor Table 10, Section A.
★★	For buckets filled to line X-X. Actual capacities depend on inclination of elevator and angle of repose of material.
☆	Subject to Service Factor Table 9 and Speed Factor Table 11, Section A.
↔	Can be furnished right-hand or left-hand.
→	Hubs one side only.
→→	Attachments which are on one side of the chain only will be on the pinhead side unless otherwise specified. Normally furnished right-hand and left-hand.
→→→	A or K attachments will be located on the outer links if the attachment spacing is for an even number of pitches. An A attachment is same as a K attachment but on one side of chain only. Attachments which are on one side of the chain only will be on the pinhead side unless otherwise specified. Normally furnished right-hand and left-hand.
Δ	Weights of attachments coupled every pitch.
ΔΔ	Weights of attachments coupled every other pitch. Cannot be coupled consecutively.
▲	Weights of block link attachments every other pitch. Contact Webster's customer service department if attachments are desired coupled consecutively.
▲▲	Weights of sidebar attachments every other pitch. Contact Webster's customer service department if attachments are desired coupled consecutively.
▼	Can be furnished on inner sidebars, dimensions given for outer sidebars.
▼▼	Outer sidebars 2½", inner sidebars 3¼". Can be furnished with both inside and outside sidebars of 3¼".
▼▼▼	Outer sidebars 2½", inner sidebars 3". Can be furnished with both inside and outside sidebars of 3".
∇	Outer sidebars 2¾", inner sidebars 4". Can be furnished with both inside and outside sidebars of 4".
∇∇	Outer sidebars 3", inner sidebars 3½". Can be furnished with both inside and outside sidebars of 3½".
∇∇∇	Outside sidebars 3", inner sidebars 4". Can be furnished with both inside and outside sidebars of 4".
●	Round countersunk hole.
●●	Fabricated steel wing.
□	Square straight hole.
□□	Antifriction bearing in roller.
□□□	Plain face roller.
■	Square countersunk hole.
■■	Flat key standard for this bore size (width shown).
*	Furnished with outside-top and inside-bottom wear shoes.
**	Furnished with inside wear shoes on bottom.
***	Furnished with inside wear shoes on complete height of sidebar.
#	Cast offset coupler links can be furnished.
##	Has alternate long (7.240") sidebar pitch and regular (4.760") block link pitch.
###	Has alternate long (7.240") outer sidebar pitch and regular (4.760") inner sidebar pitch.
Λ	Block link attachment dimensions.
ΛΛ	Sidebar attachment dimensions.
✚	Attachments on outer sidebars only. Offset links must be used if attachment spacing is odd number of pitches.
◗	A or K attachments will be located on the block links if the attachment spacing is for an even number of pitches.
◗◗	A or K attachments will be located on the outer links if the attachment spacing is for an even number of pitches except for HSB111SPC which is furnished on the inside links only. A attachment is same as K attachment but on one side of chain only.
◗◗◗	A2M or K2M attachments will be located on the outer links if the attachment spacing is for an even number of pitches. Offset links must be used if attachment spacing is odd number of pitches. A2M attachment is same as K2M attachment but on one side of chain only.

Notes

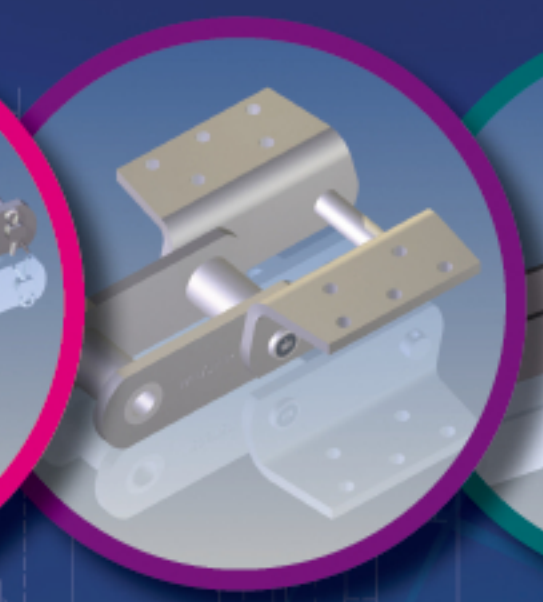
Notes















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