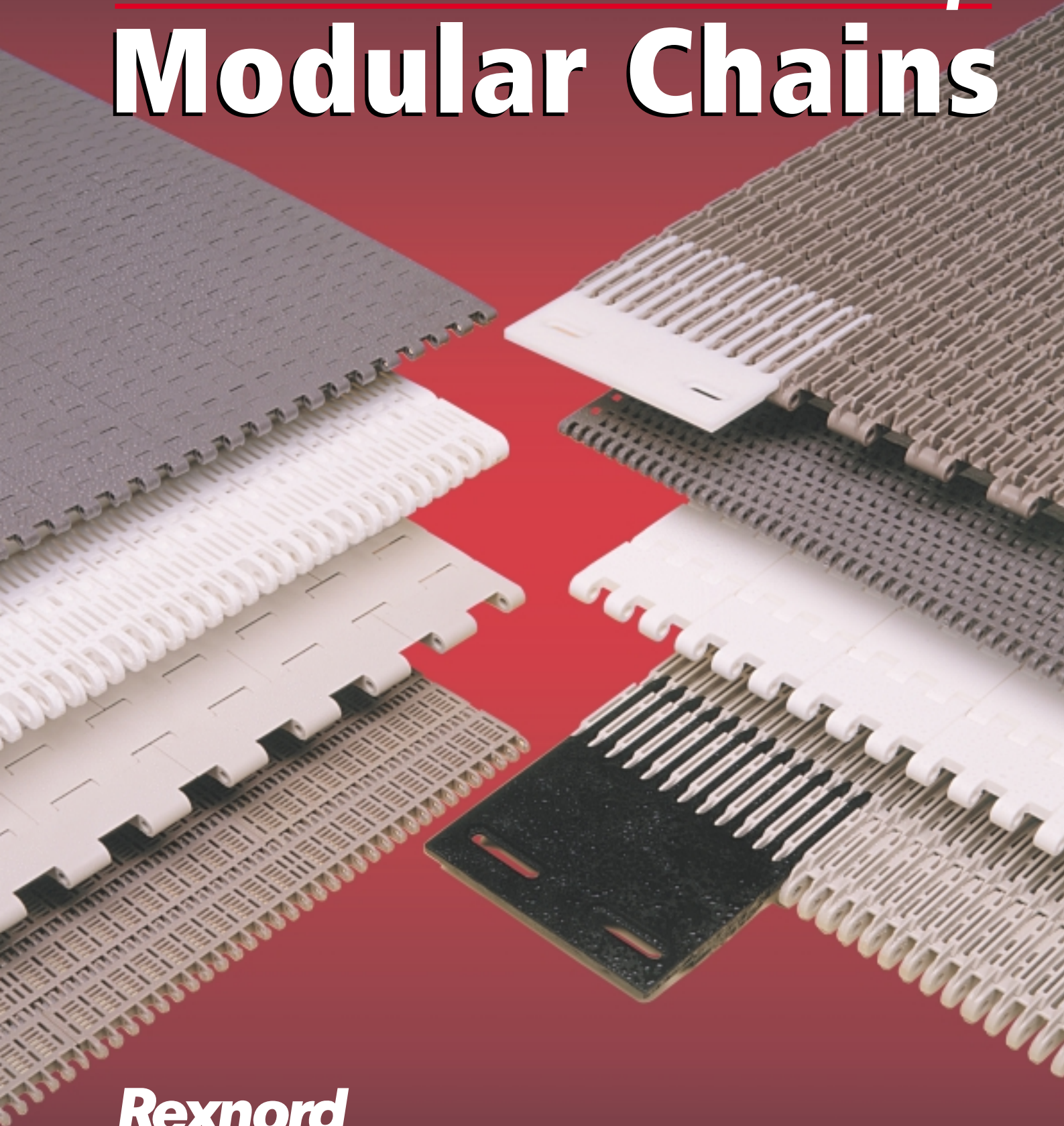


Rex[®]

MatTop[®]

Modular Chains



Rexnord
|||||

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Registered Trade marks :

Rex[®] **MatTop**[®] **Rex - HP**[™] **Rex - LF**[®] Dynamic Transfer System[™] Twist Lock[™]

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Rexnord is continually investigating methods of improving products and introducing new technology, we reserve the right to modify data and features shown in the catalogue.

For further technical information please apply to our Technical Dept.

Since 1936, when **Rexnord** had developed and introduced the first version of **TableTop**® conveyor chains, they have been responsible for most of the advances in the technology of conveyor chains and associated products. Special chains have been developed for conveying small pharmaceutical vials to heavy industrial parts.

The **Rexnord MatTop**® chains, today, are finding their way in all sorts of different industries, such as soft drinks, brewing, dairy, packaging, parts handling, food processing and container handling. **Rexnord** has established partnerships with the major original equipment manufacturers on a worldwide scale.

Rexnord products guarantee a worldwide service and availability. Products are being manufactured at different locations and distributed via numerous distribution centres throughout the world. Further several teams of engineers, strategically located are at our customer's disposal for application assistance.



Correggio (Italy)
Distribution



Sao Leopoldo
(Brasil)



Correggio (Italy)
Production



Betzdorf
(Germany)



- State of the art equipment and technology
 - Continuous quality improvement
- Widest range of products developed in close collaboration with leading original equipment manufacturers
 - Continuous training of employees in all sectors
 - High quality level
 - Dedicated application engineering
- Use of FDA approved materials and development of products, certified by the USDA
 - ISO 9001 Certification



WITH THESE ELEMENTS REXNORD HAS BECOME THE WORLDWIDE LEADER IN THE PRODUCTION AND DEVELOPMENT OF PRODUCTS FOR THE CONVEYOR INDUSTRY

Mat Top[®]

Rexnord

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Series	Pitch
7956	31,75
1505 1506	15
5935 5936 5935 vacuum 8505 8506	19,05
7705 7706 2100	25,4
4705 4706 4707 4705 vacuum 5705 5706 4812 4803	38,1
6390 6391 6392	50
4809 5996 5997 5998	57,15

BEVERAGE INDUSTRY

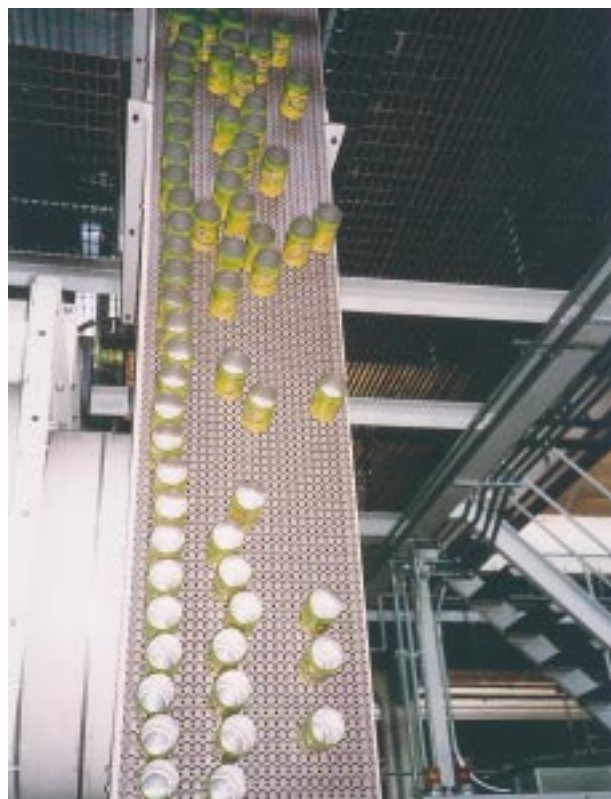
Rexnord has a long experience in the beverage industry. In collaboration with the major equipment manufacturers and producers a vast range of **MatTop®** chains have been developed. Wear resistant materials with a low coefficient of friction are standard.

The available chain range varies from extreme small pitch chains for can conveyors to large pitch chains for pasteurizers. For transfer between the various conveyors **Rexnord** has developed DTS™, Dynamic Transfer System, which prevents tipping over of containers and reduces backline pressure.



CAN MANUFACTURING

The manufacturers of cans have special requirements as chains are in operation under extreme conditions. **MatTop®** chains have a low coefficient of friction. The small pitch of the chains permits easy transfer between conveyors. The special nose-over transfer design prevents cans staying on transfer points. For vacuum elevators special chains are available with various hole patterns.



FOOD INDUSTRY

MatTop® chains are offering a wide variety of solutions especially for this industry. The modules are designed to prevent dirt trap and ensure easy cleanability. Special developed materials allow for applications under freezing conditions (down to -70°C) and high temperatures ($+130^{\circ}\text{C}$). Chains can be supplied with pushers and sideguards for the transport of bulk products on horizontal and inclined conveyors. **MatTop®** chains have FDA approvals.





MEAT, POULTRY AND FISH INDUSTRY

To meet the requirements of this industry the **MatTop®** range of chains is offering various solutions for these industries. Several chain types have been approved by the USDA for applications in the meat and poultry industry. These chains have specially designed modules to allow for easy cleaning.

MatTop® chains have FDA approvals.



BAKERY AND SNACK INDUSTRY

MatTop® chains are being used in various applications in the bakery industry. Chains are available with pushers and sideguards for the transport of product in bulk. The standard MatTop® chains in polypropylene are suitable for microwave applications.



Standard materials

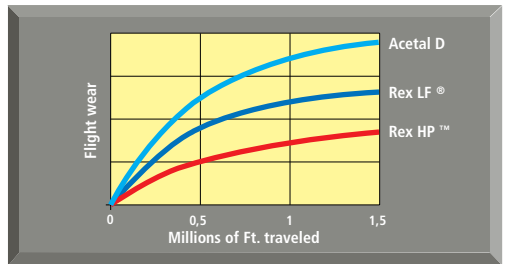
HP™

WHP™

HP RESIN (High Performance)

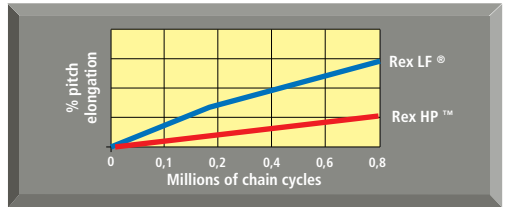
Longer sliding wear life, reduced chain elongation, lowest available friction. The continuous search of Rexnord for improvement of their product has resulted in the development of a new, patented, material: Rex HP™ High Performance. This new material has the lowest coefficient of friction, available on the market. This material is especially suitable for applications, where external lubrication is not possible. Operating temperature of Rex HP™ material:
in air (- 40 to + 80 °C)
in hot water (+ 65 °C)
Colour: HP (dark grey), WHP (white).

Longer sliding wear life *



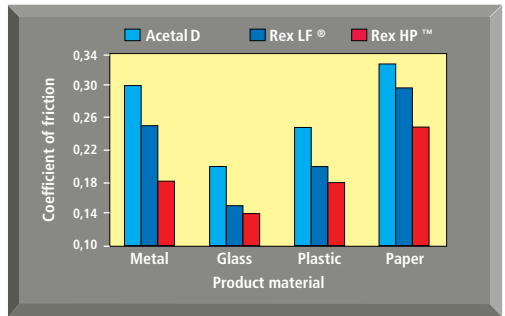
Rex HP™ high performance resin can increase wear life up to 40%. Extensive testing has proven that new HP material can reduce wear as much as 40% over acetal and 25% over Rex LF® acetal

Reduced chain elongation *



New technology virtually eliminates break-in stretch and reduces elongation due to wear. Through extensive testing, Rexnord has achieved the optimum design to minimize break-in wear while maximizing overall performance.

Lowest available friction *



* = Graph shows comparative results at high-speed, dry operation.

LF

ACETAL (low coefficient of friction)

Material with low coefficient of friction. Optimum strength. Recommended for applications with high loads, high speeds and long centre distances. High wear resistance. Operating temperatures:
in air (- 40 a + 80 °C)
in hot water (+ 65 °C)
Colour: brown

PRODUCT RANGE

HT

WHT

BHT

POLYPROPYLENE (high temperature resistant)

Suitable for applications at high temperatures (up to 105° C, under dry and humid conditions). High chemical resistance. Operating temperatures:
in air (+ 5 a + 105° C)
in hot water (+ 105° C)
Colour : HT (beige), WHT (white), BHT (blue).

YSM

YSM RESIN (high temperature resistant)

YSM resin has an improved temperature resistance compared with HT - WHT, (up to 130° C). Operating temperatures:
in air (+ 5 a + 130 °C)
in hot water (+ 130 °C)
Colour : yellow.

WLT

POLYETHYLENE (low temperature resistant)

Suitable for applications at low temperatures (down to - 70° C). High chemical resistance. Excellent resistance against superficial damage. Operating temperatures:
in air (- 70 a + 25° C)
Colour : white

Special materials

D

ACETAL

An economical alternative to our LF acetal material.
The mechanical properties are equal to acetal LF, however the coefficient of friction and wear resistance are inferior. Operating temperature:
in air (- 40 a + 80 °C)
in hot water (+ 65 °C)
Colour :grey.

WSM

WSM RESIN (wear resistant)

Material with a high wear resistance and resistance against superficial damage.
Recommended for abrasive applications and where superficial damage may occur. Strength is equal to LF acetal .
Operating temperatures:
in air (- 40 a + 80 °C)
in hot water (+ 65 °C)
Colour : white.

PRODUCT RANGE

AS

AS RESIN (static conductive)

To reduce the risk of accumulation of electrostatic loads.
High electrical conductivity.
Colour : black.
For every application please refer to our engineering department.

UV

UV RESIN (ultraviolet resistant)

Materials, stabilized to resist ultraviolet radiation.
Recommended for critical applications outdoors.
The following materials are available:
acetal (DUV)
polypropylene (HUV)
polyethylene (LUV)
Colour : black.

Certification FDA & USDA

FDA

American institute (Food and Drug Administration), responsible for the certification of materials to be in contact with food.
For direct contact with food the following materials have been approved:
HP, WHP, HT, WHT, WLT, WSM.

USDA

United States Department of Agriculture, responsible for the approval of components and machinery in the meat, poultry and dairy industries.
The following chains have been approved for the meat and poultry industry: 2100, 5996.

		PITCH	31,75	15	19,05	25,4			
SOLID TOP		MATERIAL APPROVAL OPEN AREA STRENGTH N/m ACCESSORIES	7956	1505	8505	5935	7705	4705	
			HP™WHP™	HP™WHT	HP™WHTWLT	LFHT	HP™WHP™	LFHT	
			FDA	FDA	FDA	FDA (HT)	FDA	FDA (HT)	
			2%	2%	2%	5%	3%	2%	
			4000 (Newton)	13200 HP - 7300 WHT	29000 HP - 16000 WHT - 10600 WLT	13100 LF - 7300 HT	43040	17500 LF - 8750 HT	
		Dynamic Transfer System™	Flights - Tab guide Dynamic Transfer System™	Flights - Side guards - Tab guide Dynamic Transfer System™	Dynamic Transfer System™	Flights - Side guards Transfer plates			
PERFORATED TOP		MATERIAL APPROVAL OPEN AREA STRENGTH N/m ACCESSORIES		1506	8506	5936	7706	2100	4706
				HP™WHT	HP™WHTWLT	LFHP™HT	HP™WHP™	LFWHT	LFHT
				FDA	FDA	FDA (HP™ - HT)	FDA	FDA - USDA (WHT)	FDA (HT)
				26%	22%	16%	8%	44%	22%
				13200 HP - 7300 WHT	29000 HP - 16000 WHT - 10600 WLT	13100 LF/HP - 7300 HT	43040	16100 LF - 7300 WHT	17500 LF - 8750 HT
		Dynamic Transfer System™	Flights - Tab guide Dynamic Transfer System™	Flights - Side guards - Tab guide Dynamic Transfer System™	Dynamic Transfer System™	Flights Transfer plates	Flights - Side guards Transfer plates		
RAISED TOP		MATERIAL APPROVAL OPEN AREA STRENGTH N/m ACCESSORIES							4707
									LFHT
									FDA (HT)
									23%
									17500 LF - 8750 HT Transfer combs
VACUUM		MATERIAL APPROVAL OPEN AREA STRENGTH N/m ACCESSORIES				5935 vacuum			4705 vacuum
						LFHT			LFHT
						FDA (HT)			FDA (HT)
						8%			5%
						13100 LF - 7300 HT Tab guide			17500 LF - 8750 HT Transfer plates
		PAGE	15	19	23	26	29	32	34



HP™	WHP™
FDA - USDA	
2%	
17500	
Transfer plates	



HP™	WHP™
FDA - USDA	
22%	
17500	
Transfer plates	



LF	HT
FDA (HT)	
33%	
14600 LF - 7300 HT	
Flights	
Transfer plates	



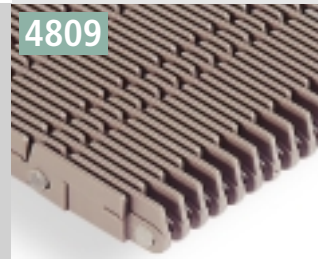
LF	HT
FDA (HT)	
44%	
21900 LF - 13000 HT	
Transfer combs	



WHT	BHT	YSM	WLT
FDA (WHT - BHT - WLT)			
2%			
-			
Flights - Side guards			



WHT	BHT	YSM	WLT
FDA (WHT - BHT - WLT)			
26% (6391) - 48% (6392)			
-			
Flights (6391) - Side guards			



LF	HT
FDA (HT)	
34%	
43800 LF - 29200 HT	
Transfer combs	



LF	WHT	WLT
FDA - USDA (WHT - WLT)		
21%		
51000 LF - 35000 WHT - 23300 WLT		
Flights - Side guards		
Transfer plates		



HT
FDA
22%
35000
Transfer comb



WHT	WLT
FDA - USDA	
45%	
35000 WHT - 23300 WLT	
Flights - Side guards	
Transfer plates	

MATERIAL
APPROVAL
OPEN AREA
STRENGTH N/m
ACCESSORIES

SOLID TOP

MATERIAL
APPROVAL
OPEN AREA
STRENGTH N/m
ACCESSORIES

PERFORATED TOP

MATERIAL
APPROVAL
OPEN AREA
STRENGTH N/m
ACCESSORIES

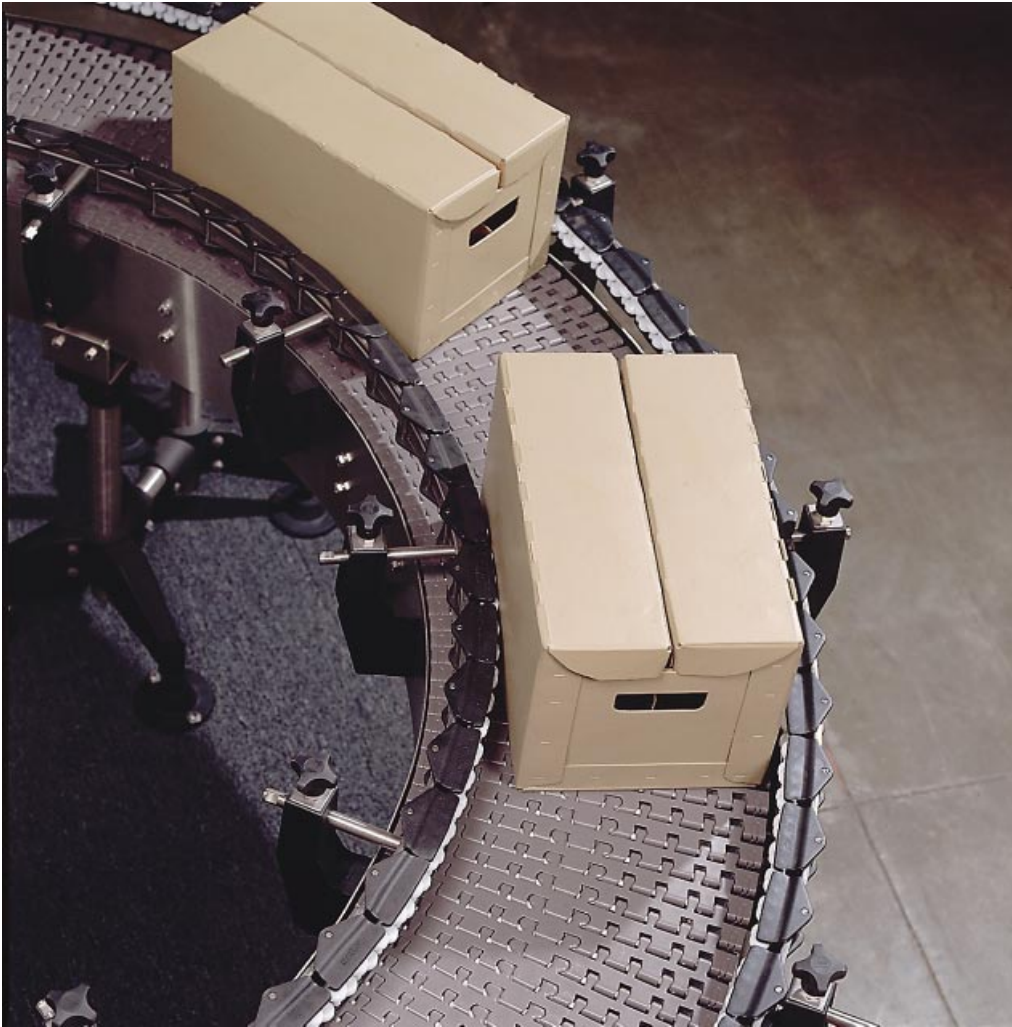
RAISED TOP

MATERIAL
APPROVAL
OPEN AREA
STRENGTH N/m
ACCESSORIES

VACUUM

RexFlex® 7956 Chain: Side Flexing and High Strength

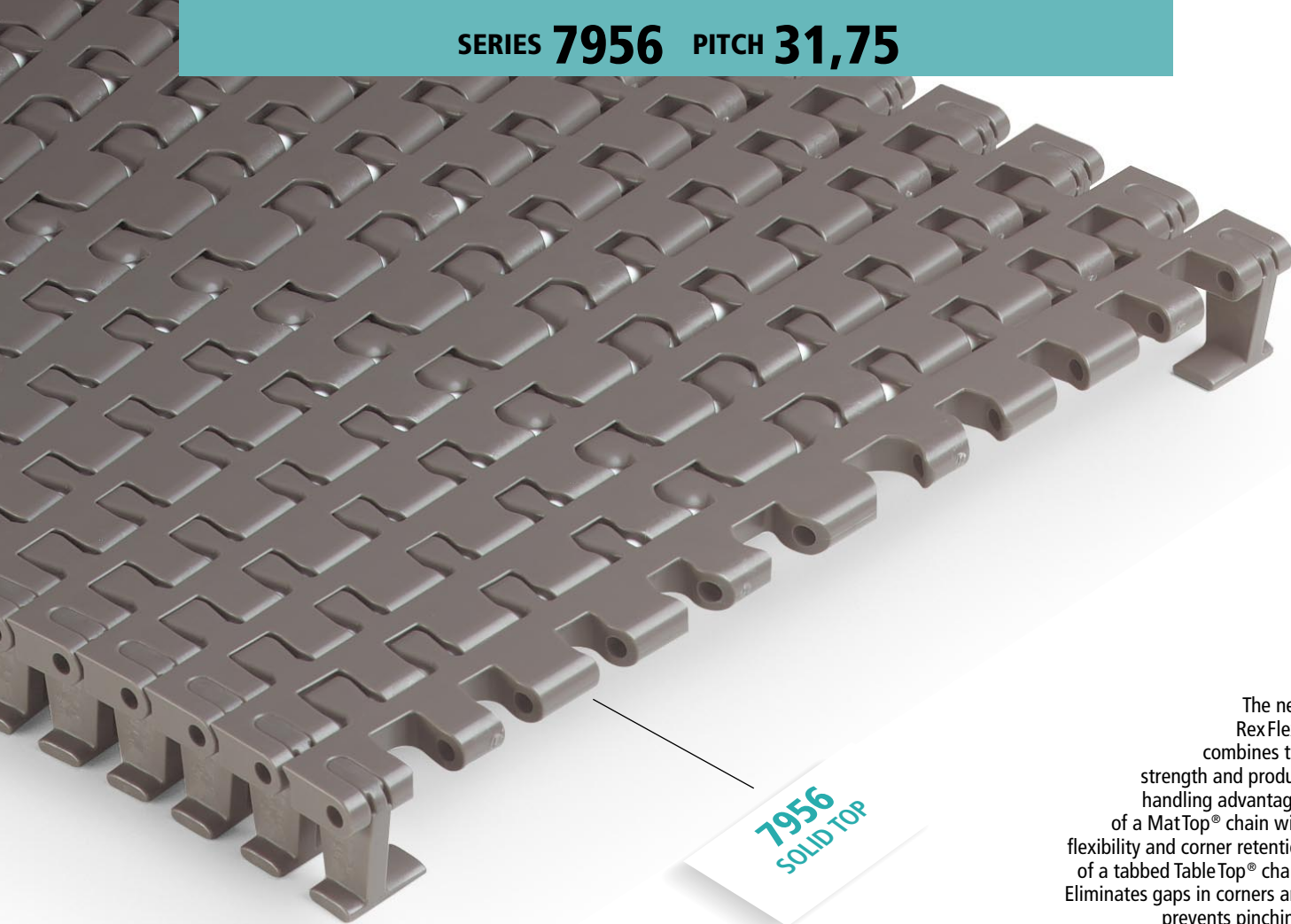
Mat Top®



- Unique and innovative design works off of the chain center point. This design allows the load limit to be unchanged for straight or sideflexing applications
- High strength, abrasion resistant and good chemical resistance
- Eliminates gaps in corners and prevents pinching
- Easy to clean and maintain
- HP™ material for minimum friction and wear against wear strips



- Available with hold-down tabs for sideflexing applications
- The tabs are mounted into the chain with a special click-in construction, that secures the pins at the same time



The new RexFlex® combines the strength and product handling advantages of a MatTop® chain with flexibility and corner retention of a tabbed TableTop® chain. Eliminates gaps in corners and prevents pinching.

CHAIN WIDTH
K = 379,2 mm

MATERIAL CHARACTERISTICS
see page 12.1 - 13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70
Guide rail and catenary: see page 73-76
Mounting instructions: see page 85
Chemical resistance: see page 86

Pitch 31,75 mm (1 1/4")

Open area 2%

FDA Material approved for direct contact with food products.

Applications

Presently available in 15" wide, the RexFlex® 7956 is perfect for case handling applications as a substitute for roller, skate wheel, powered roller, and line shaft conveyors. It is also a good substitute for dual-lane conveyors currently using 7 1/2 inch wide chains.

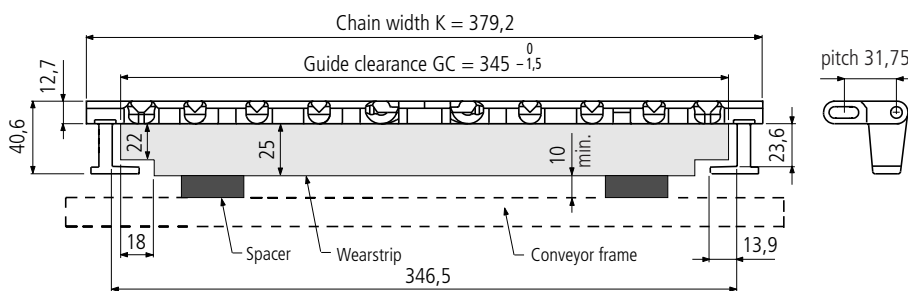
Standard materials	HP™	WHP™
	High performance	
Colour	Grey	White
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	- 40 to + 80
in hot water	+ 65	+ 65
Pin material	Polyester (white)	

Pin retention : with tab guide.

Available on request other materials and colours.

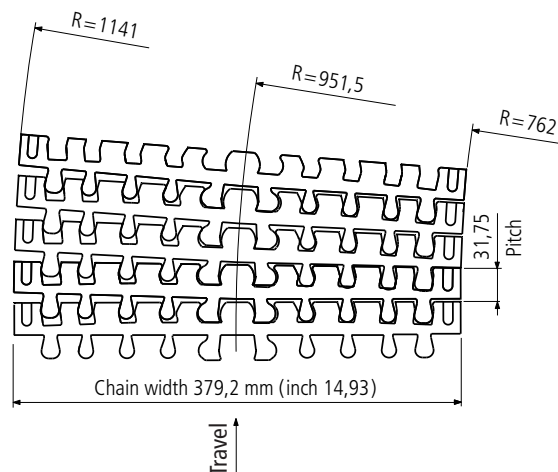
Specifications:

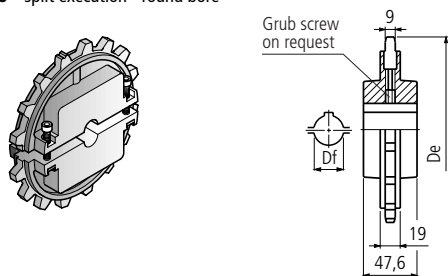
Chain width K		Working load N	Radius min. R mm	Guide clearance GC		Weight Kg/m
mm	inch			Straight mm	Curve mm	
379,2	14,93	4000	951,5	345	345	4,38



Note: guide clearance is the same for straight running as well as in curves

Radius min.



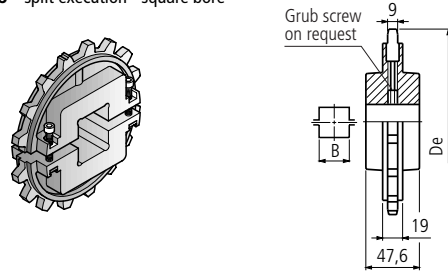
NS 7956 - split execution - round bore


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg	
NS 7956 T16 R...	16	16	162,74	163,2	25-30-35-40	0,46

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

Material characteristics / mounting instruction : see page 77 - 81

NS 7956 - split execution - square bore


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
NS 7956 T16 S...	16	16	162,74	163,2	40x40-50x50-60x60	0,43

Material : reinforced polyamid PA FV (black).

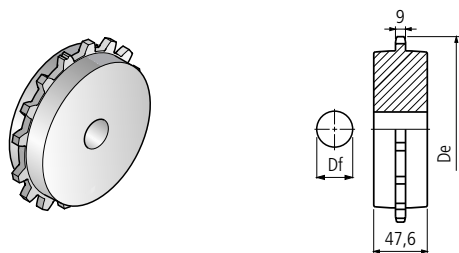
Material characteristics / mounting instruction : see page 77 - 81

**CHAINS AND
ACCESSORIES**

Series Pitch

7956

31,75

KU 7956


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg	
KU 7956 T16 R20	16	16	162,74	163,2	20 ^{H7}	0,89

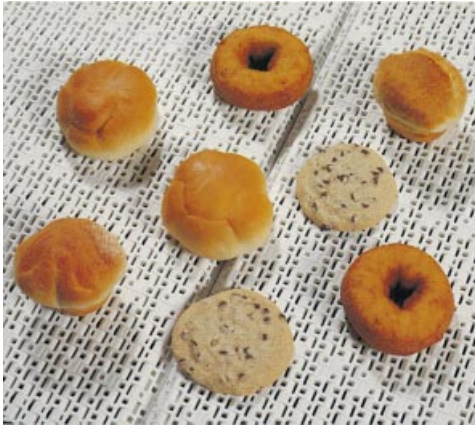
Material : polyamid PA (white).

Material characteristics / mounting instruction : see page 77 - 81

Example of codenumber: NS 7956 T16 R30 (including bore)

Rex® 1500 Chain: Offers Two Solutions to Product Transfers

Rexnord has introduced the unique 1500 Series MatTop® Chain to help eliminate container tipping and jam-ups at conveyor transfer points. The chain is designed to make in-line noseover transfers and 90° transfers stable, smooth and trouble-free.

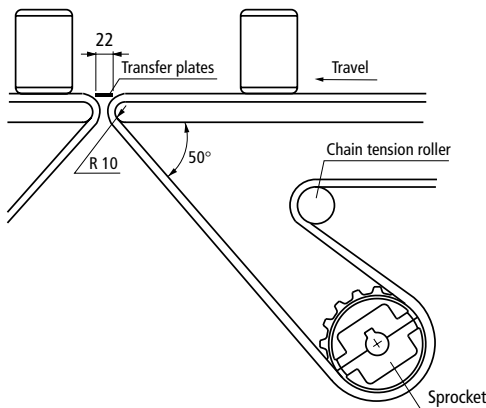


In line transfer with loose products



In line transfer with aluminium cans

Sprocket position



Solution 1:

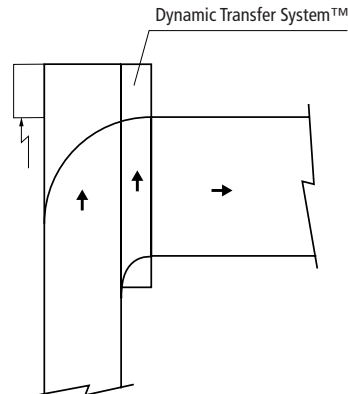
Typical chain and belt sprockets are approximately 130 to 150 mm diameter. For end-to-end transfers, long stationary dead plates are required. Upstream products need to push the containers across the deadplates and can cause tipping or even damage product. In addition, at the end of a shift or production run, containers must be cleared off manually. Rex® 1500 Series MatTop® Chain eliminates these long deadplates. With its small, 15 mm pitch and curved bottom contour, the deadplate between adjacent in-line 1500 chain conveyors, can be as short as 22 mm. This makes the 1500 series chain ideal for the newer, lighter, less stable containers, especially aluminum cans and PET bottles. Most 1500 Series food applications require no deadplates at all.

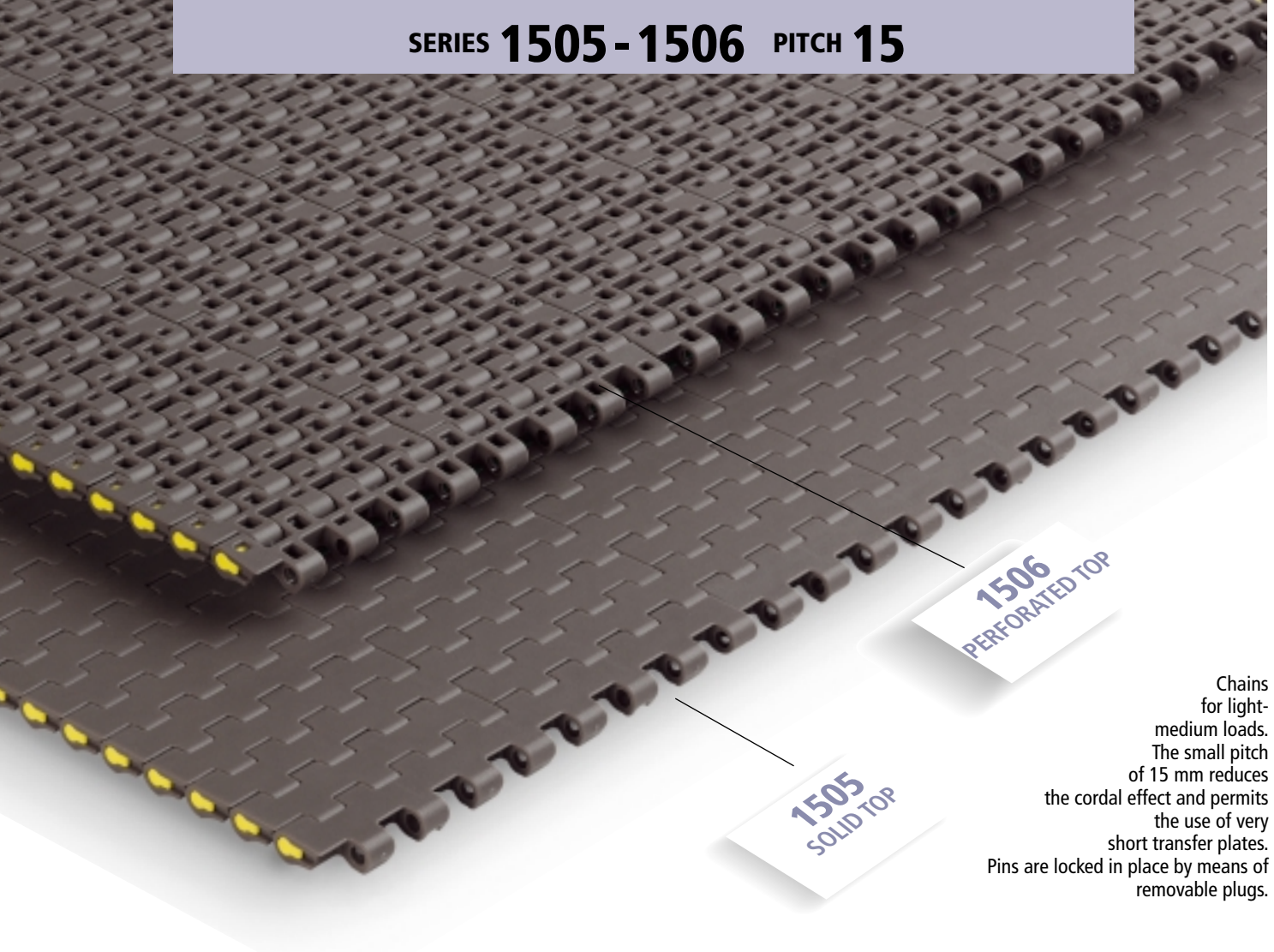
Solution 2:

The 1505 SingleModule DynamicTransfer System™ is for 90° transfers that eliminate deadplates and are completely self-clearing. For either conventional 90° brush transfers (side-to-tail) or 90° head end-to-side transfers, a short intermediate strand of 1505 DTS™ chain bridges the gap between conveyors for smooth, reliable transfers. Guide tabs on the bottom can be used with Marbett Part. 356 or 367. Rex® 1505 DTS™ is available in 133.4 mm width only; overall width 160 mm.



90° transfer with PET bottles





Chains for light-medium loads. The small pitch of 15 mm reduces the cordal effect and permits the use of very short transfer plates. Pins are locked in place by means of removable plugs.



CHAIN WIDTH

see page 56

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70
Guide rail and catenary: see page 73-76

Mounting instructions: see page 85

Chemical resistance: see page 86

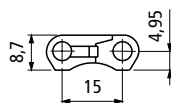
Pitch 15 mm (9/16")

Open area 1505 (2%)
1506 (26%)

FDA

Material approved for direct contact with food products.

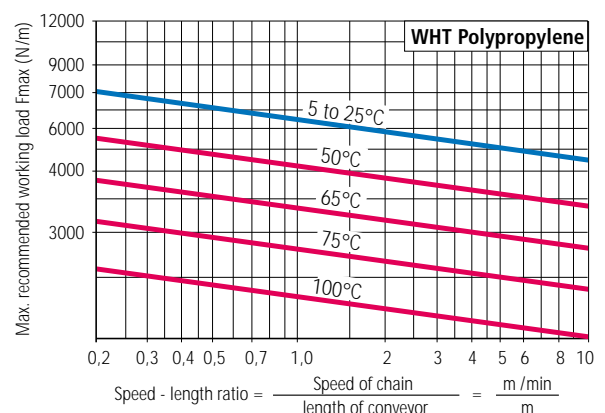
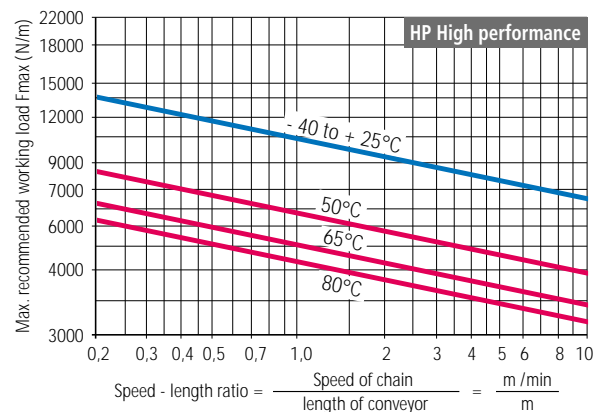
1505 - 1506



Applications

For retrofit application, Rex® 1500 chain has the same thickness as Rex® 5935, 5936 and 2100 chains. It can also replace similar size competitive belts.

Maximum recommended working load- Fmax

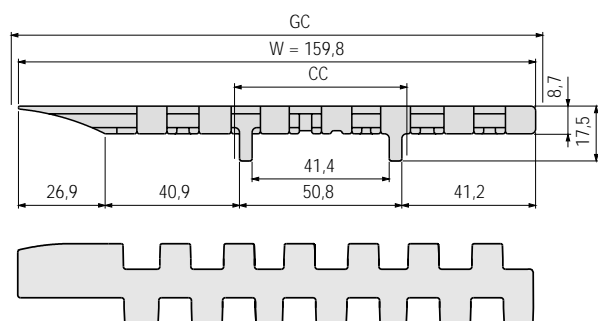


Standard materials	HP™	WHT
	High performance	Polypropylene
Colour	Grey	White
Nominal strength * (N/m)	13200	7300
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 105
WEIGHT (Kg/m²)		
1505	6,24	4,52
1506	5,35	3,87
Pin material	WHT polypropylene (white)	

* = Values for a belt width of 1 m, at +20°C.

Pin retention : with plugs.

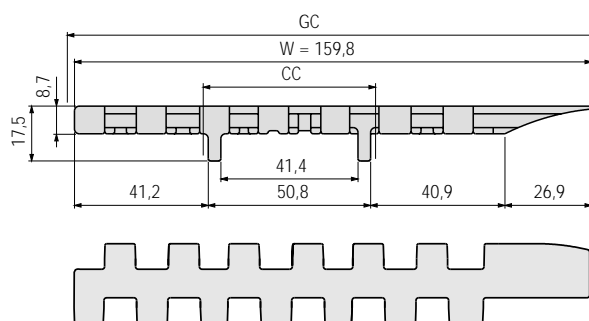
Available on request other materials and colours.

Single Module Dynamic Transfer System™ left for 1505 - 1506


Code Rexnord Nr.	W mm	Guide width GC mm	Guide width CC mm	Material
HP 1505 Single Module DTS SX	159,8	162,9	52,1	HP™ (grey)

Material characteristics : see page 12.1-13.1.

Mounting instruction : see page 83.

Single Module Dynamic Transfer System™ right for 1505 - 1506


Code Rexnord Nr.	W mm	Guide width GC mm	Guide width CC mm	Material
HP 1505 Single Module DTS DX	159,8	162,9	52,1	HP™ (grey)

Material characteristics : see page 12.1-13.1.

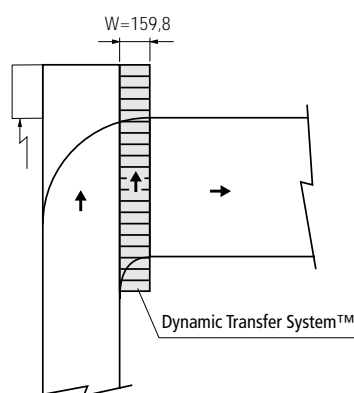
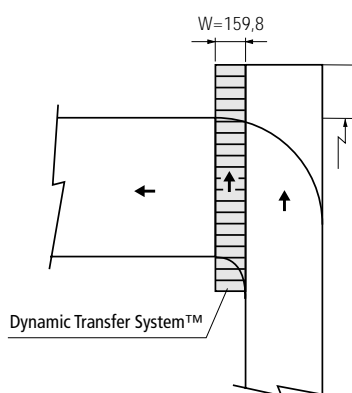
Mounting instruction : see page 83.

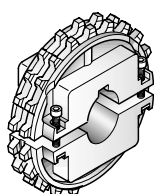
CHAINS AND
ACCESSORIES

Series Pitch

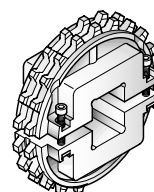
1505
1506

15

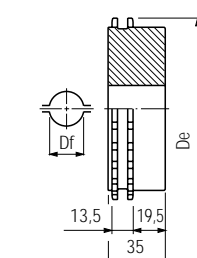
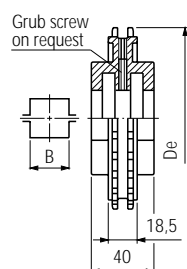
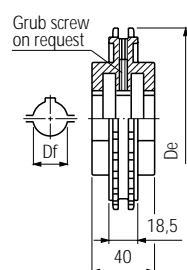
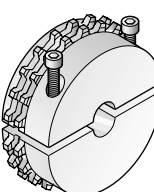

SPROCKETS for 1505 - 1506

NS 1500 - split execution - round bore


Not recommended for
chains K 4,5 (114,3 mm)

NS 1500 - split execution - square bore


Not recommended for
chains K 4,5 (114,3 mm)

KUS 1500 - split execution


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg
NS 1500 T24 R...	24	114,92	116	25-30-35-40	0,24
NS 1500 T32 R...	32	153,03	155	25-30-35-40	0,32

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

Material characteristics / mounting instruction : see page 77 - 81

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
NS 1500 T24 S...	24	114,92	116	40x40	0,24
NS 1500 T32 S...	32	153,03	155	40x40-60x60-90x90	0,32

Material : reinforced polyamid PA FV (black).

Material characteristics / mounting instruction : see page 77 - 81

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg
KUS 1500 T24 R...	24	114,92	116	20*-25-30-35-40	0,34

* = Plain bore without seat keyway.

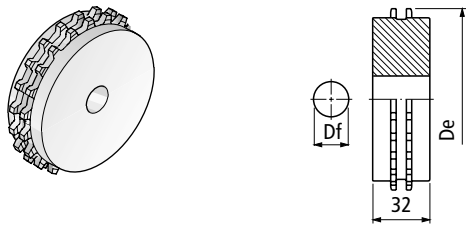
Material : polyamid PA (white).

Seat keyway : UNI 6604 - 69. See page 77.

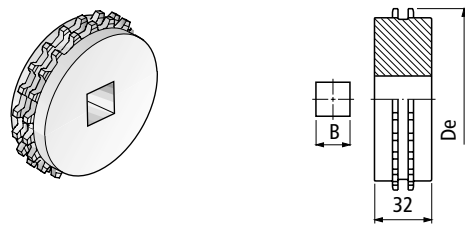
Material characteristics / mounting instruction : see page 77 - 81

Example of codenumber : NS 1500 T24 R30 (including bore)

KU 1500 - Round bore



KU 1500 - Square bore



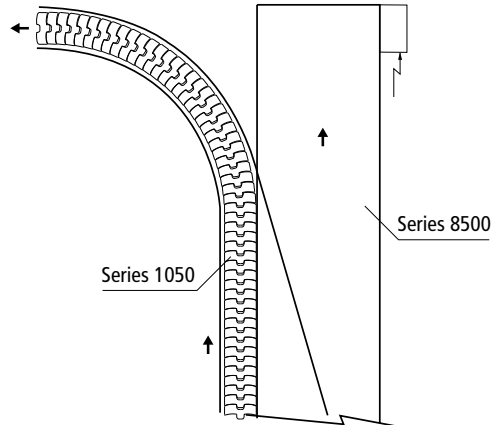
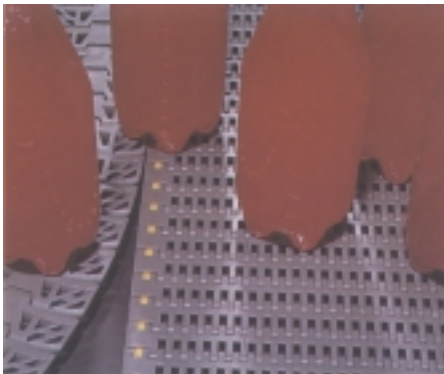
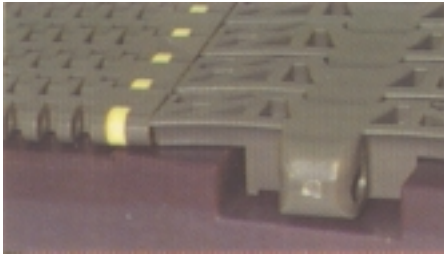
Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg
KU 1500 T12 R19	12	57,96	58,3	19 ^{H13}	—
KU 1500 T16 R19	16	76,89	77,7	19 ^{H13}	—

Material : polyamid PA (white).
Material characteristics / mounting instruction : see page 77 - 81.

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
KU 1500 T12 S25	12	57,96	58,3	25	—
KU 1500 T16 S40	16	76,89	77,7	40	—

Material : polyamid PA (white).
Material characteristics / mounting instruction : see page 77 - 81.

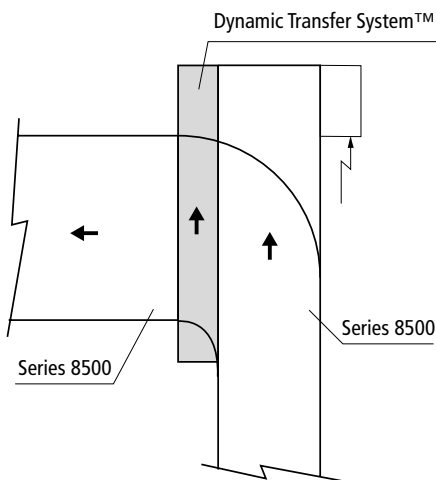
Product side transfer with chain Series 1050



Ideal for single line infeed or outfeed.

Rex® 8500 Series MatTop® Chains are the same thickness of Rex Magnetflex® 1050 Series Chains. This means that both 8500 MatTop® and 1050 Magnetflex® chains can be combined on the same bottle or can line for optimum performance. Both chains have small pitches (3/4" for 8500 chain and 1" for 1050 chain) and, along with the top plate design, allow for minimum gaps resulting in superior product handling with no tipping and smooth transfers.

90° turns with Single Module Dynamic Transfer System™

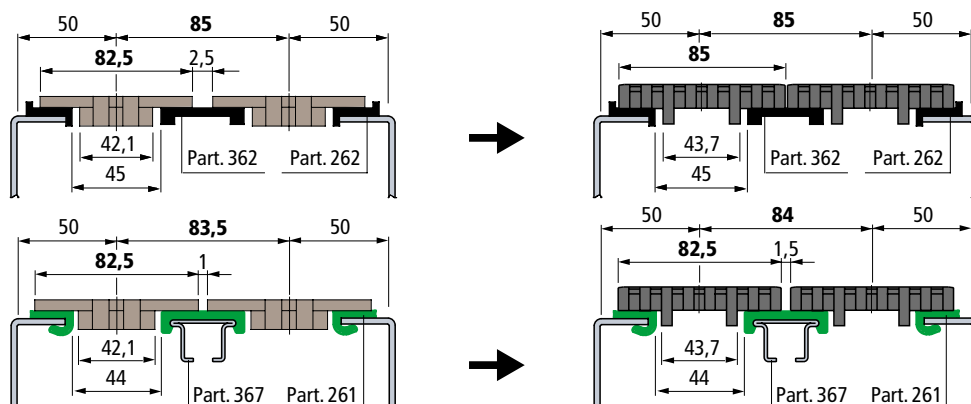


Ideal for mass conveying.

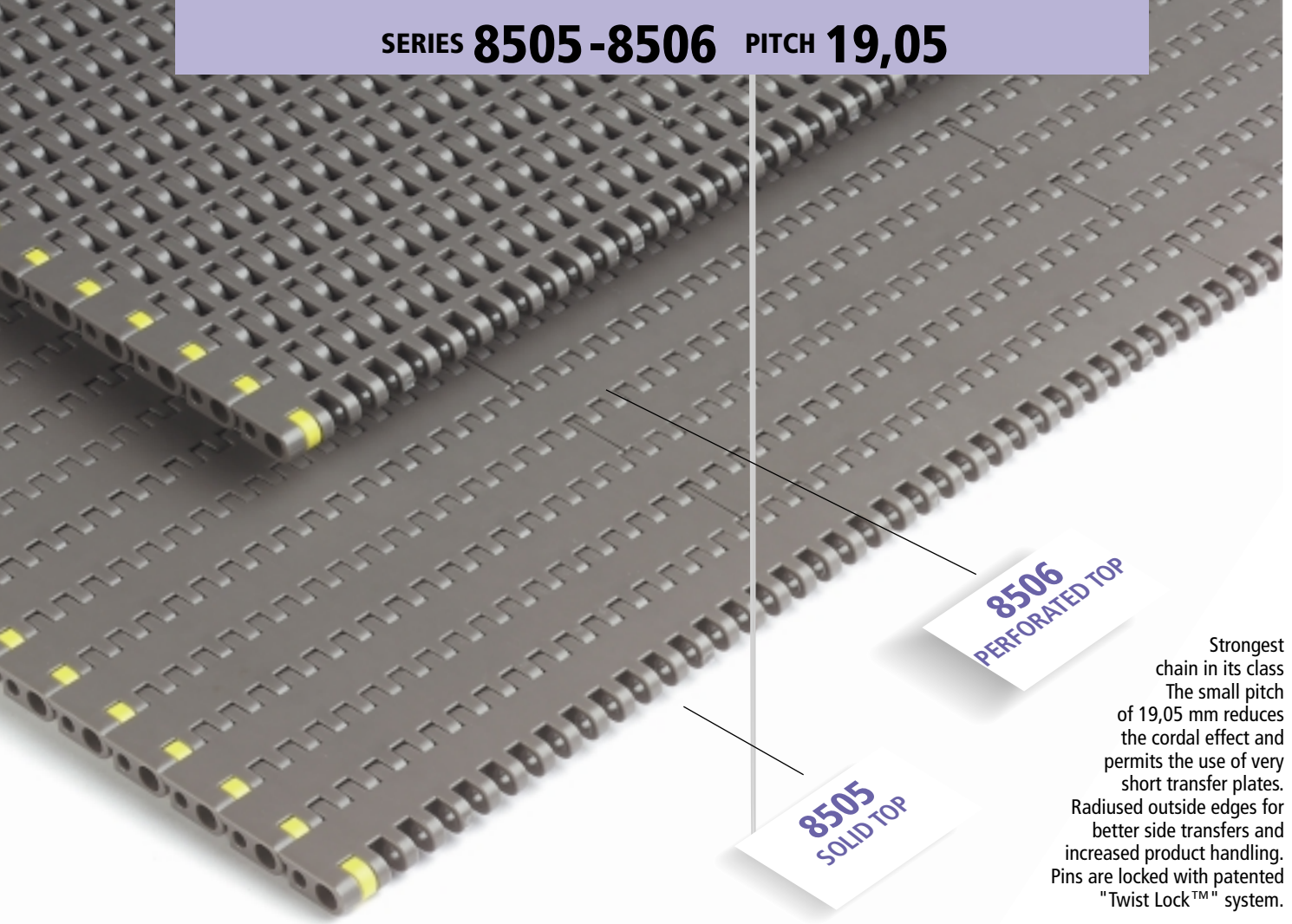
No deadplates, completely self-clearing. Rex Dynamic Transfer System™ offers a new way to make 90° turns and eliminates tipping, product hang-up and conveyor jams while protecting product against severe impact.

Retrofit from TableTop® to MatTop® conveyors

Moulded to width 8500 Series chains allow easy retrofit from TableTop® to MatTop® conveyors. Compared to traditional TableTop® the chains Series 8500 have better flatness, higher allowable pull (the hinge is wider), and shorter pitch (19,05 mm instead of 38,1 mm)



Note : carefully check all guide clearances before start up



Strongest chain in its class
The small pitch of 19,05 mm reduces the cordal effect and permits the use of very short transfer plates.
Radiused outside edges for better side transfers and increased product handling.
Pins are locked with patented "Twist Lock™" system.

CHAIN WIDTH
see page 66

MATERIAL CHARACTERISTICS
see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations:
see page 70
Guide rail and catenary:
see page 73-76

Mounting instructions:
see page 85

Chemical resistance :
see page 86

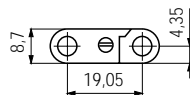
Pitch 19,05 mm (3/4")

Open area 8505 (2%)
8506 (22%)

FDA

Material approved for direct contact with food products.

8505 - 8506



New TwistLock™ hinged plug prevents plug loss, allows easy pin access.



Applications

For retrofit application, Rex® 8500 chain has the same thickness as Rex® 5935, 5936 and 2100 chains. Designed for retrofit of existing TableTop® conveyors with 85 mm chain centers. It can also replace similar size competitive belts.

Standard materials	HP	WHT	WLT
	High performance	Polypropylene	Polyethylene
Colour	Grey	White	White
Nominal strength * (N/m)	29000	16000	10600
TEMPERATURE OF OPERATION (°C)			
in air	- 40 to + 80	+ 5 to + 105	-70 to + 25
in hot water	+ 65	+ 105	-
WEIGHT (Kg/m ²)			
8505	9,04	-	-
8506	8,30	-	-
Pin material	Polyester (white)	WHT polypropylene (white)	WLT polyethylene (white)

* = Values for a belt width of 1 m, at +20°C.

Pin retention : "Twist Lock™" system.

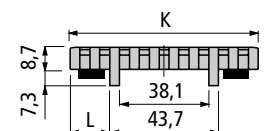
Available on request other materials and colours.

Moulded to width chains

Without TAB guide



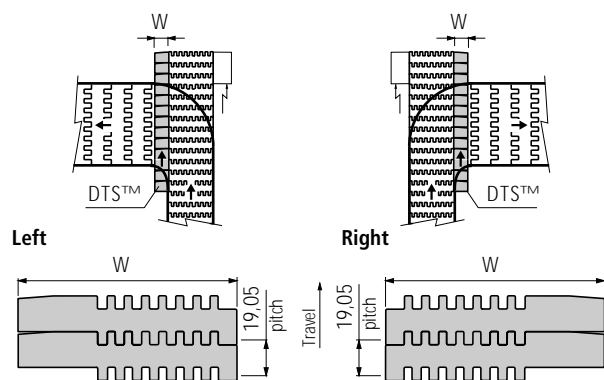
With TAB guide



8505 - 8506 without TAB	
Chain width K	
mm	inch
82,6	3 1/4
85	-
114,3	4 1/2
190,5	7 1/2

8505 - 8506 with TAB		
Chain width K		
mm	inch	L mm
82,6	3 1/4	19,4
85	-	20,7
114,3	4 1/2	35,3
190,5	7 1/2	73,4

Single Module Dynamic Transfer System™ for 8505 - 8506

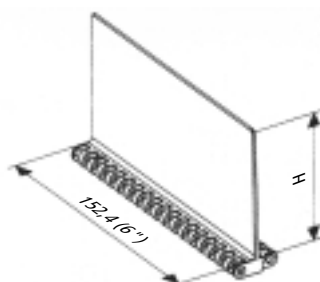


Available only with surface of Series 8505

Code Rexnord Nr.	Type	Width W mm
8505 Single Module DTS DX K 4,5	Right	160
8505 Single Module DTS SX K 4,5	Left	160

Material : HP™ High Performance (grey).
Material characteristics : see page 12.1-13.1.
Mounting instruction : see page 83.

Flights for 8505 - 8506



H mm	Material	Code Rexnord Nr.
76	HP high performance (grey) WHT polypropylene (white) WLT polyethylene (white)	HP 8505 F3 WHT 8505 F3 WLT 8505 F3

On request other heights can be supplied.
Material characteristics : see page 12.1-13.1.

TAB guide for 8505 - 8506

Material	Code Rexnord Nr.
HP high performance (grey) WHT polypropylene (white) WLT polyethylene (white)	HP 8505 TAB WHT 8505 TAB WLT 8505 TAB

Material characteristics : see page 12.1-13.1.

CHAINS AND
ACCESSORIES

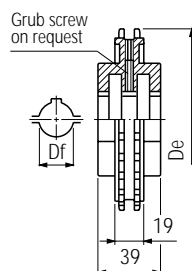
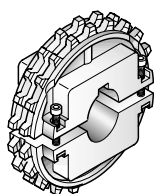
Series Pitch

8505
8506

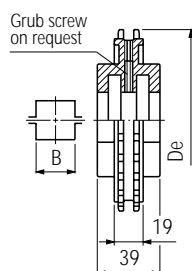
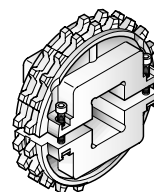
19,05

SPROCKETS for 8505 - 8506

NS 8500 - Spil execution - Round bore



NS 8500 - Spil execution - Square bore



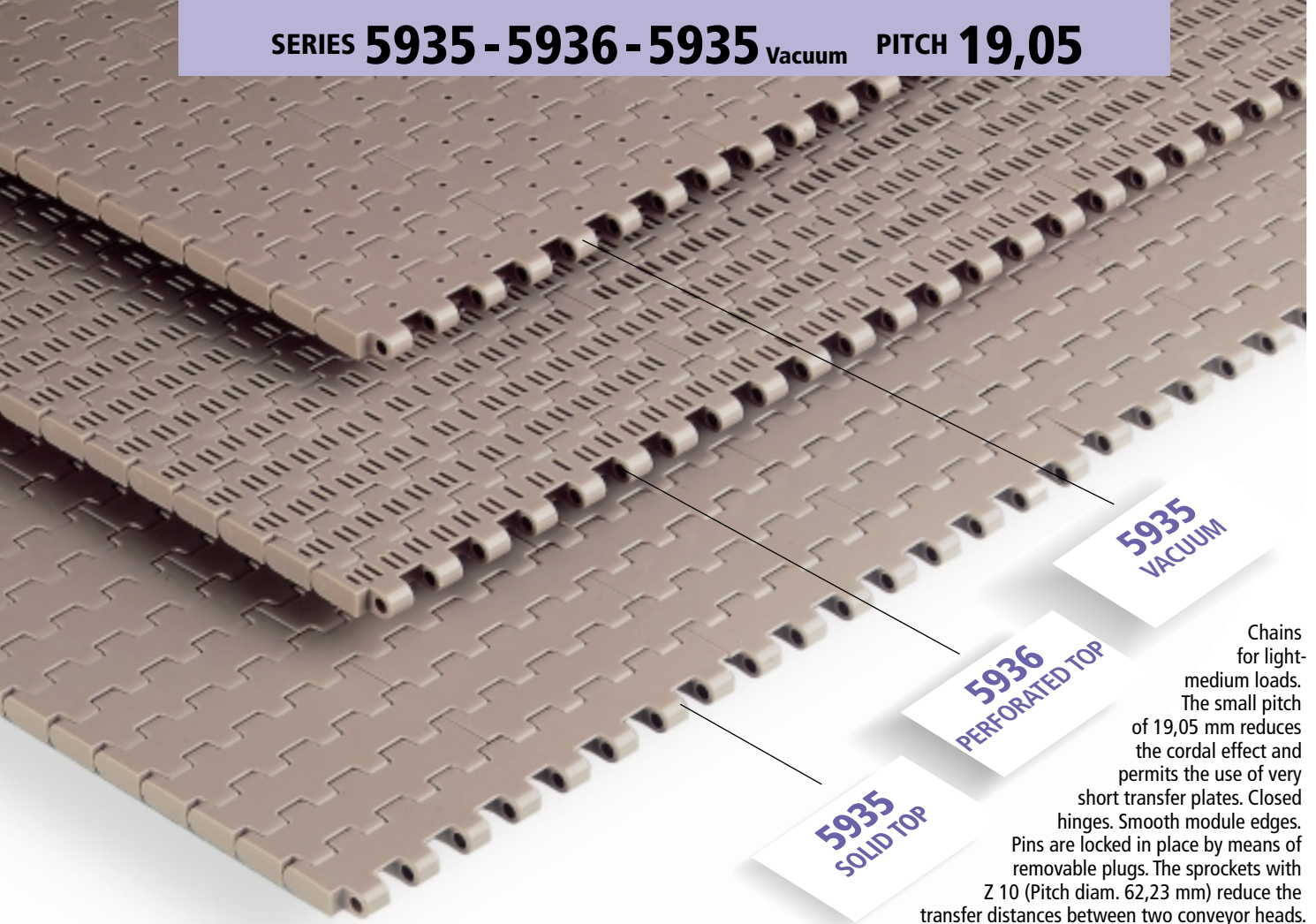
Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg
NS 8500 T17 R...	17	104,65	105,4	25-30-35	0,21
NS 8500 T21 R...	21	129,0	130,0	25-30-35-40	0,41
NS 8500 T24 R...	24	147,34	148,3	25-30-35	-
NS 8500 T25 R...	25	153,44	154,7	25-30-35	-

Material : reinforced polyamid PA FV (black).
Seat keyway : UNI 6604 - 69. See page 77.
Material characteristics / mounting instruction : see page 77 - 81.

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
NS 8500 T17 S...	17	104,65	105,4	25x25-30x30-35x35	0,21
NS 8500 T21 S...	21	129,0	130,0	25x25-40x40-60x60	0,41
NS 8500 T24 S...	24	147,34	148,3	25x25-30x30-35x35	-
NS 8500 T25 S...	25	153,44	154,7	25x25-30x30-35x35	-

Material : reinforced polyamid PA FV (black).
Material characteristics / mounting instruction : see page 77 - 81.

Example of codenumber : NS 8500 T24 R30 (including bore)



Chains for light-medium loads. The small pitch of 19,05 mm reduces the cordal effect and permits the use of very short transfer plates. Closed hinges. Smooth module edges. Pins are locked in place by means of removable plugs. The sprockets with Z 10 (Pitch diam. 62,23 mm) reduce the transfer distances between two conveyor heads.



CHAIN WIDTH

see page 61

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70

Guide rail and catenary: see page 73-76

Mounting instructions: see page 85

Chemical resistance: see page 86

Pitch 19,05 mm (3/4")

Open area 5935 (5%)
5936 (16%)
5935 Vacuum (8%)

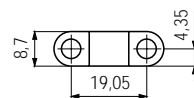
FDA

HP and HT materials approved for direct contact with food products.

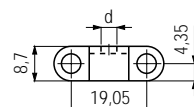
Applications

Conveyor and accumulation systems for PET bottles and cans. Vacuum type conveyor systems (5935 vacuum). Conveyors in the pharmaceutical and cosmetic industry. Conveyors in the packaging industry.

5935 - 5936

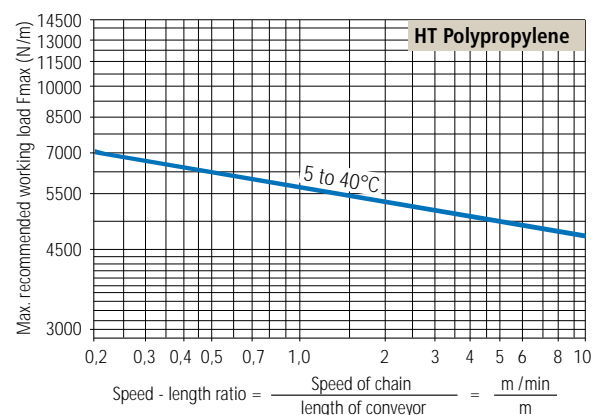
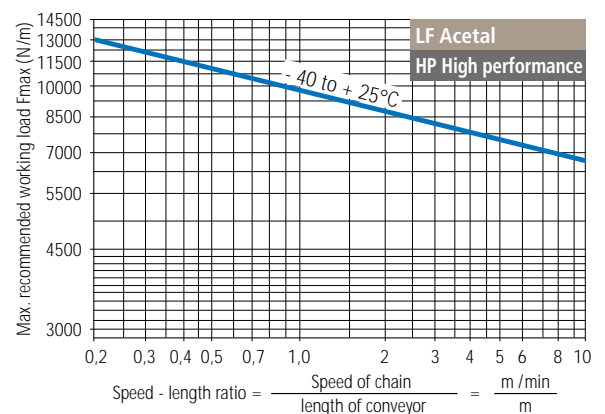


5935 Vacuum



$d = \varnothing 3,2 - 4 - 5,1$ mm. See page 84.

Maximum recommended working load- Fmax



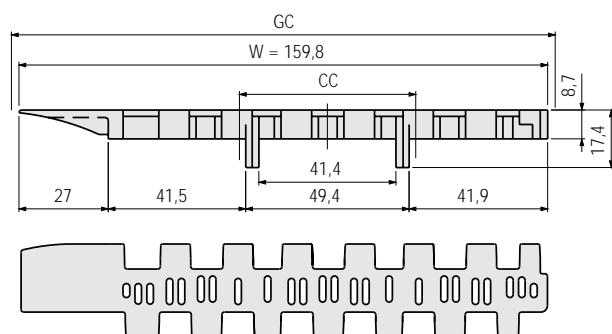
Standard materials	LF	HP™ **	HT
	Acetal	High performance	Polypropylene
Colour	Light brown	Grey	Beige
Nominal strength * (N/m)	13100	13100	7300
TEMPERATURE OF OPERATION (°C)			
in air	- 40 to + 80	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 65	+ 105
WEIGHT (Kg/m²)			
5935	6,40	—	4,92
5936	5,90	5,90	4,42
5935 Vacuum	6,40	—	4,92
Pin material	WHT polypropylene (white)		

* = Values for a belt width of 1 m, at +20°C.

** = Available only for series 5936.

Pin retention : with plugs or hotformed heads.

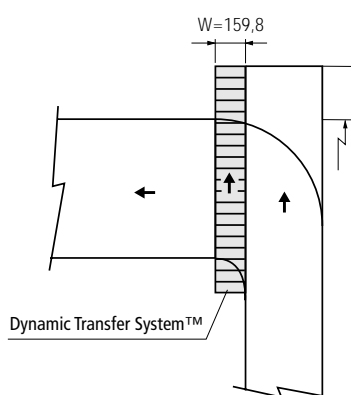
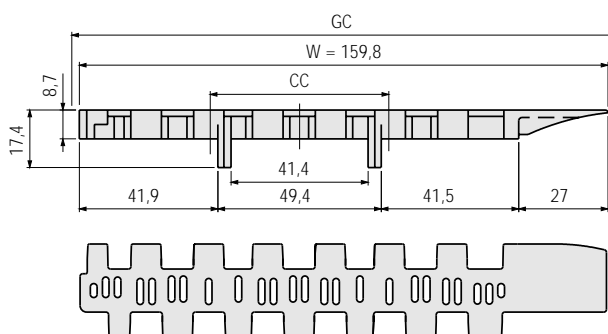
Available on request other materials and colours.

Single Module Dynamic Transfer System™ left for 5935 - 5936


Code Rexnord Nr.	Guide width W mm	Guide width GC mm	Guide width CC mm	Material
LF 5936 Single Module DTS SX HP 5936 Single Module DTS SX	159,8	162,9	50,7	LF (light brown) HP™ (grey)

Material characteristics : see page 12.1-13.1.

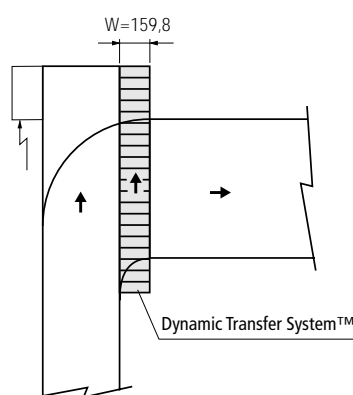
Mounting instruction : see page 83.


Single Module Dynamic Transfer System™ right for 5935 - 5936


Code Rexnord Nr.	Guide width W mm	Guide width GC mm	Guide width CC mm	Material
LF 5936 Single Module DTS DX HP 5936 Single Module DTS DX	159,8	162,9	50,7	LF (light brown) HP™ (grey)

Material characteristics : see page 12.1-13.1.

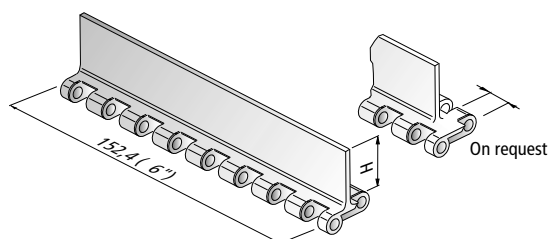
Mounting instruction : see page 83.



CHAINS AND
ACCESSORIES

Series Pitch

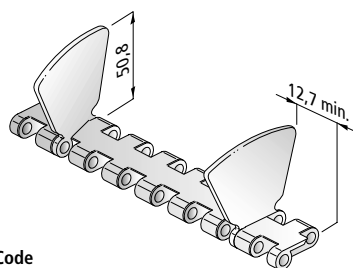
5935
5936
5935
vacuum
19,05

Flights for 5935 - 5936


Code Rexnord Nr.	H mm	Material
LF 5935 F1 HT 5935 F1	25	LF acetal (light brown) HT polypropylene (beige)

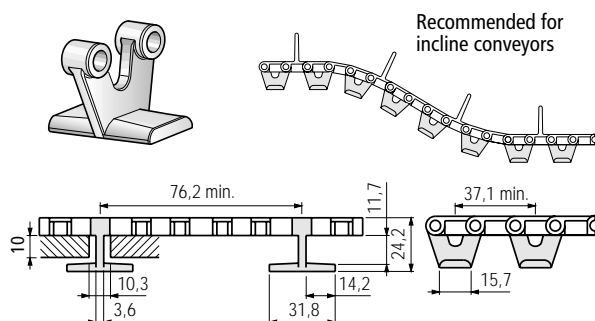
On request other heights can be supplied.

Material characteristics : see page 12.1-13.1.

Side guards for 5935 - 5936


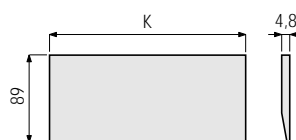
Code Rexnord Nr.	Execution	Material
Side guard 5935 DX Side guard 5935 SX	Right Left	WHT polypropylene (white)

Material characteristics : see page 12.1-13.1.

TAB guide for 5935 - 5936 - 5935 vacuum


Code Rexnord Nr.	Material
LF 5935 TAB HT 5935 TAB	LF acetal (light brown) HT polypropylene (beige)

Material characteristics : see page 12.1-13.1.

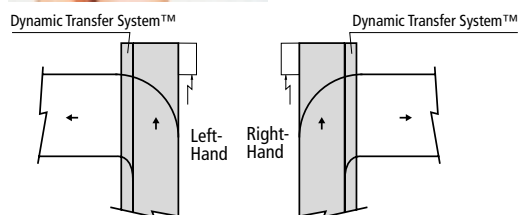
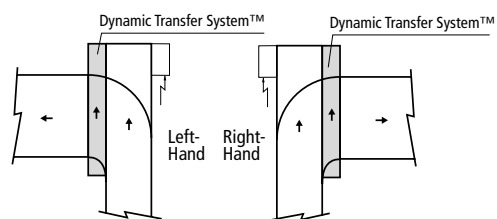
Transfer plates for 5935 - 5936


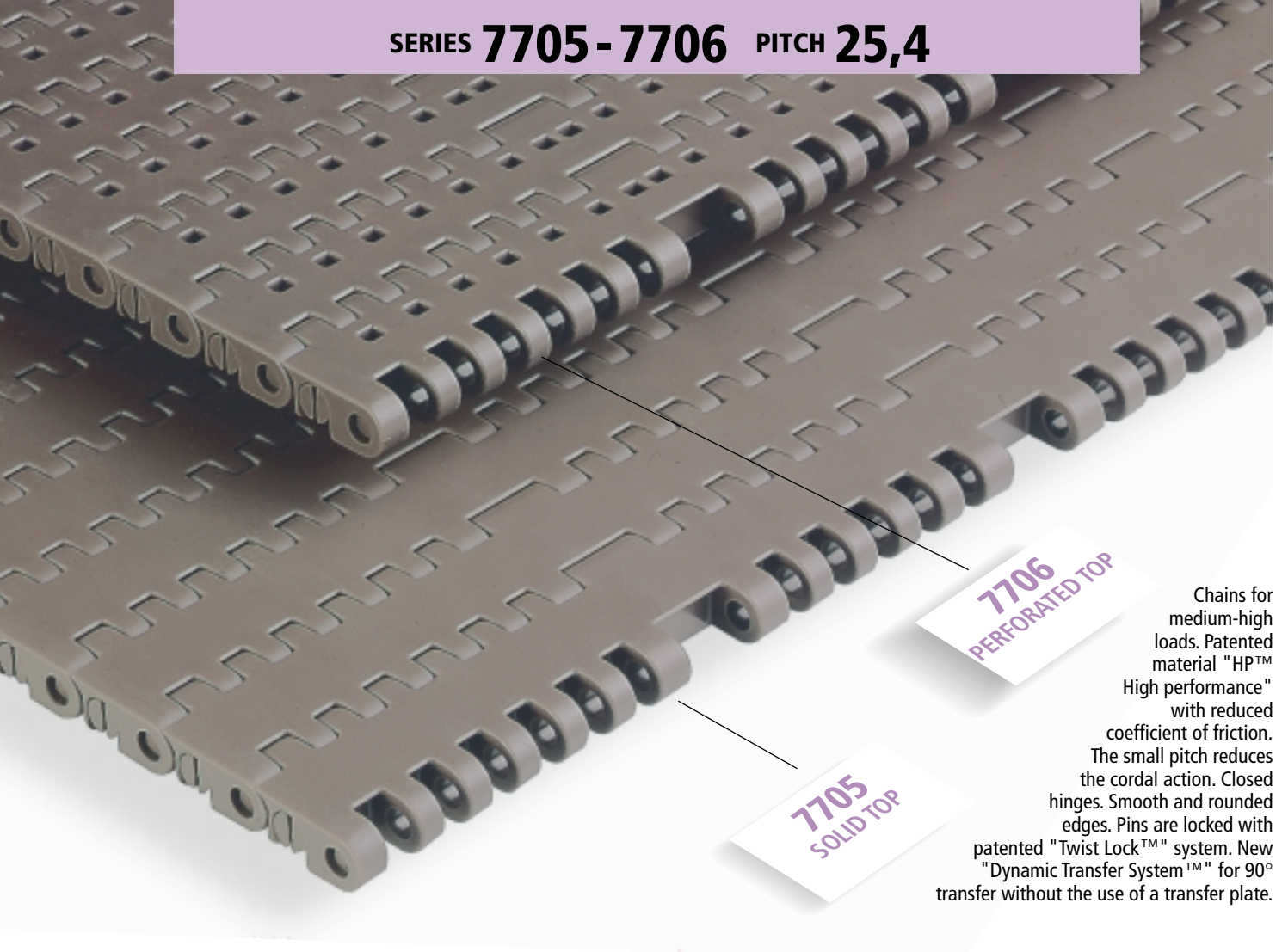
Code Rexnord Nr.	K mm inch	Material
Transfer plate K 06 Transfer plate K 12	152,4 6 304,8 12	LF acetal (white)

Material characteristics : see page 12.1-13.1.

Sprockets ➡







Chains for medium-high loads. Patented material "HP™" with reduced coefficient of friction. The small pitch reduces the cordal action. Closed hinges. Smooth and rounded edges. Pins are locked with patented "Twist Lock™" system. New "Dynamic Transfer System™" for 90° transfer without the use of a transfer plate.

CHAIN WIDTH
see page 65

MATERIAL CHARACTERISTICS
see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations:
see page 70
Guide rail and catenary:
see page 73-76
Mounting instructions:
see page 85
Chemical resistance :
see page 86

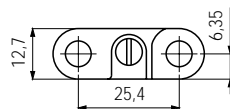
Pitch 25,4 mm (1")

Open area 7705 (3%)
7706 (8%)

FDA

Material approved for direct contact with food products.

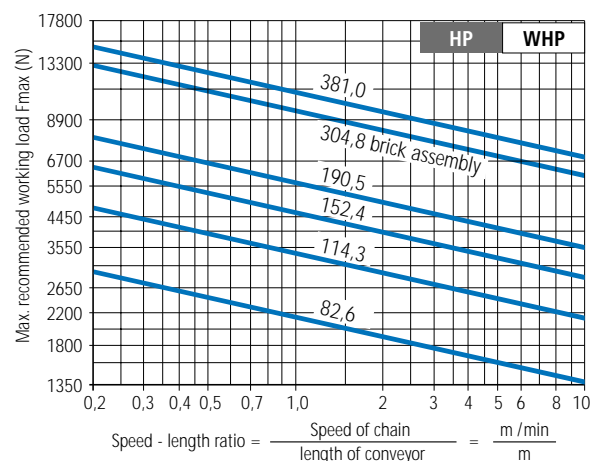
7705 - 7706



Applications

High speed conveyors.
Low product pressure conveyors.
Conveyor for glass (cold).
Conveyors and accumulation tables for aluminium cans.
Conveyors, where forced lubrication is not permitted.

Maximum recommended working load - Fmax



Chainwidth assembled with multi modules (brick assembly)

Series	Weight Kg/m ²	Ave strength* N/m
7705 HP - WHP	13,56	43040
7706 HP - WHP	13,27	43040

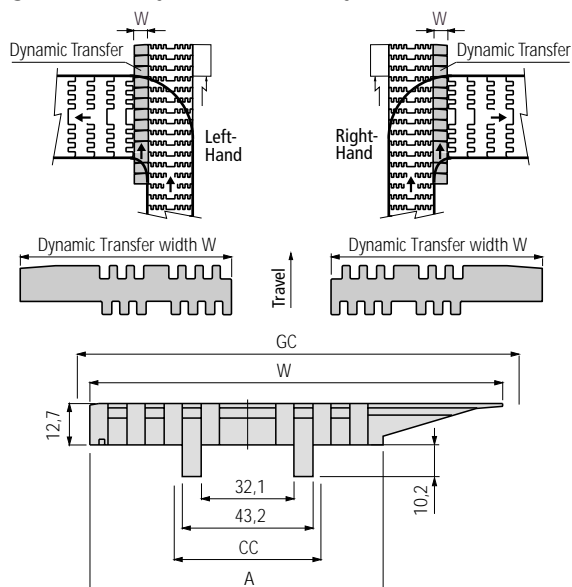
* = Values for a belt width of 1 m, at + 20°C.

Chains with modules moulded to width

		7705 HP - WHP		7706 HP - WHP	
Width		Weight	Ave strength	Weight	Ave strength
mm	inch	Kg/m	N	Kg/m	N
82,6	3 1/4	1,03	3050	1,00	3050
114,3	4 1/2	1,42	4560	1,39	4560
152,4	6	1,90	6560	1,85	6560
190,5	7 1/2	2,58	7785	2,52	7785
381,0	15	5,15	15120	5,05	15120

Standard materials	HP™	WHP™
	High performance	
Colour	Grey	White
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	- 40 to + 80
in hot water	+ 65	+ 65
Pin material	WHT polypropylene (white)	

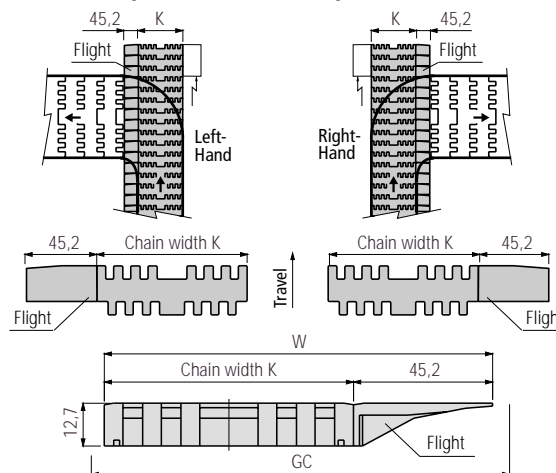
Pin retention : "Twist Lock™" system.
Available on request other materials and colours.

Single Module Dynamic Transfer System™ for 7705 - 7706


Code Rextord Nr.	Type	W mm	A mm	Guide width GC mm	Guide width CC mm	Material
7705 Single Module DTS DX K 4,5	Right	160,1	108,7	163,2	44,5	HP™ (grey)
7705 Single Module DTS SX K 4,5	Left					
7705 Single Module DTS DX K 7,5	Right	236,3	184,6	239,4	44,5	HP™ (grey)
7705 Single Module DTS SX K 7,5	Left					

Material characteristics : see page 12.1-13.1.

Mounting instruction : see page 83.

Two-Piece Dynamic Transfer System™ for 7705 - 7706


Code Rextord Nr.	Chain width K mm	inch	W mm	Guide width GC mm	Material
Chains with modules moulded to width					
DTS HP K 3,25	82,6	3 1/4	127,8	130,9	HP™ (grey)
DTS WHP K 3,25					WHP™ (white)
DTS HP K 4,5	114,3	4 1/2	159,5	162,7	HP™ (grey)
DTS WHP K 4,5					WHP™ (white)
DTS HP K 6	152,4	6	197,6	200,8	HP™ (grey)
DTS WHP K 6					WHP™ (white)
DTS HP K 7,5	190,5	7 1/2	235,7	238,9	HP™ (grey)
DTS WHP K 7,5					WHP™ (white)
DTS HP K 15	381,0	15	426,2	429,4	HP™ (grey)
DTS WHP K 15					WHP™ (white)
Chainwidth assembled with multi modules (brick assembly)					
DTS HP K	See page 66		K+45,2	K+48,4	HP™ (grey)
DTS WHP K					WHP™ (white)

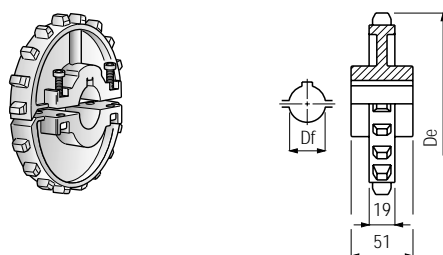
Material characteristics : see page 12.1-13.1.

Mounting instruction : see page 83.

CHAINS AND ACCESSORIES

Series Pitch

SPROCKETS for 7705 - 7706

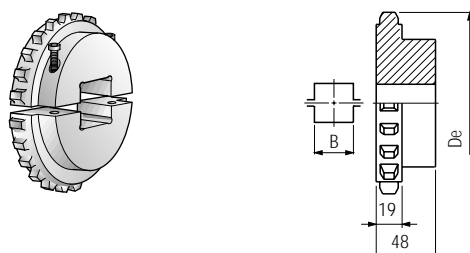
NS 7700 - split execution


Code Rextord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg
NS 7700 T16 R...	16	130,20	130,6	25-30-35-40	0,33
NS 7700 T18 R...	18	146,28	146,9	25-30-35-40	0,38
NS 7700 T21 R...	21	170,43	170,7	25-30-35-40	0,44

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

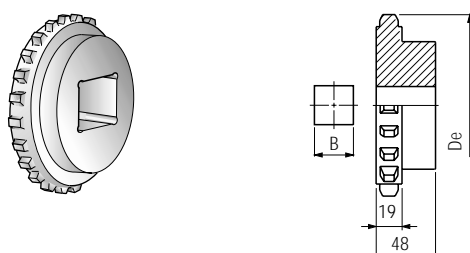
Material characteristics / mounting instruction : see page 77-81

KUS 7700 ML - split execution


Code Rextord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
KUS 7700 T16 S40 16	16	130,20	130,6	40x40	-
KUS 7700 T18 S... 18	18	146,28	146,9	40x40-50x50	-
KUS 7700 T21 S... 21	21	170,43	170,7	40x40-50x50-60x60	-

Material : polyamid PA (white).

Material characteristics / mounting instruction : see page 77-81

KU 7700 ML


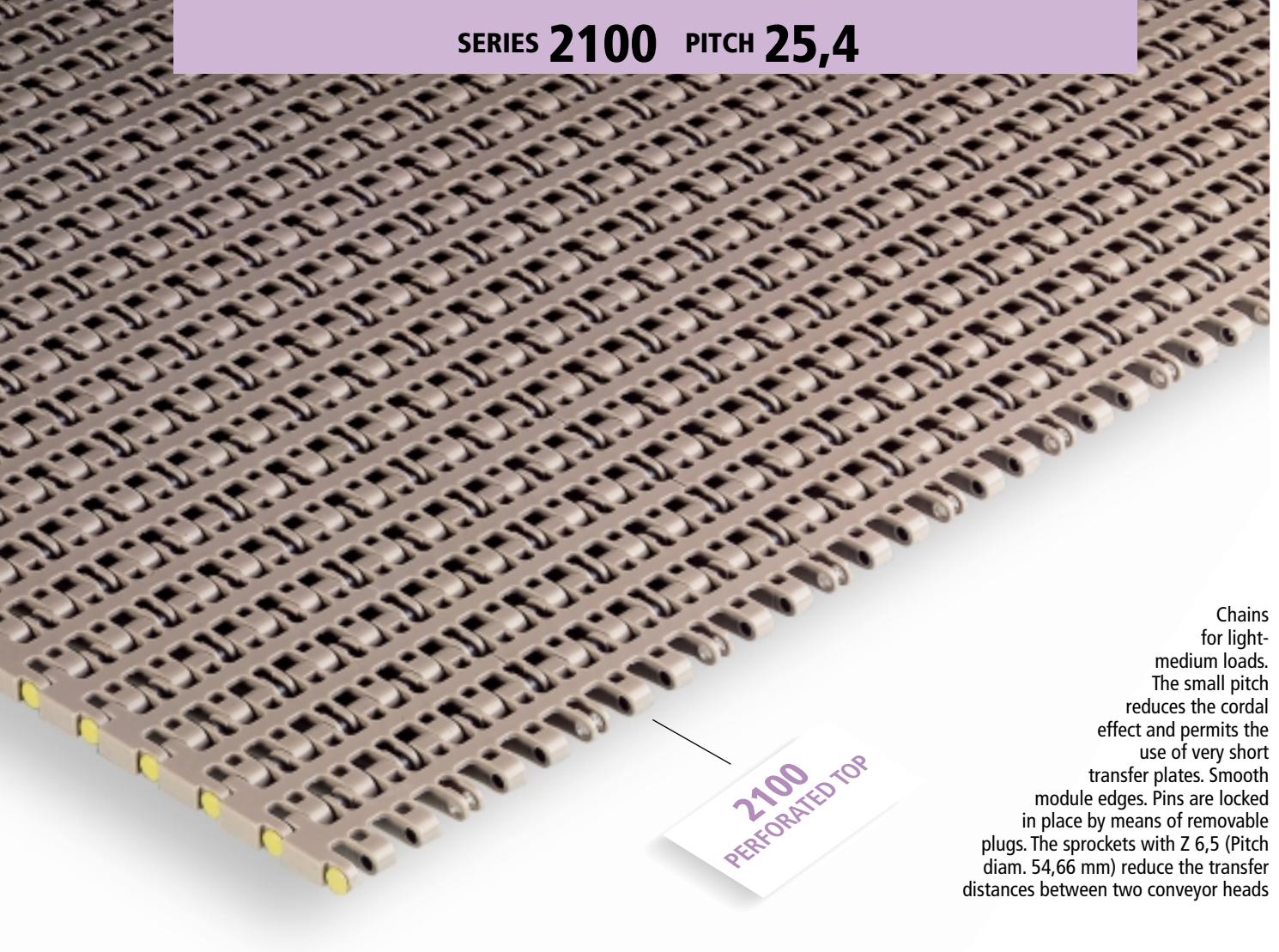
Code Rextord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
KU 7700 T16 S50 16	16	130,20	130,6	50x50	-
KU 7700 T18 S... 18	18	146,28	146,9	50x50-60x60	-
KU 7700 T21 S... 21	21	170,43	170,7	50x50-60x60-65x65	-
KU 7700 T25 S50 25	25	202,66	204,2	50x50	-

Material : polyamid PA (white).

Material characteristics / mounting instruction : see page 77-81

Example of codenumber: NS 7700 T18 R30 (including bore)

**7705
7706**
25,4



Chains for light-medium loads. The small pitch reduces the cordal effect and permits the use of very short transfer plates. Smooth module edges. Pins are locked in place by means of removable plugs. The sprockets with Z 6,5 (Pitch diam. 54,66 mm) reduce the transfer distances between two conveyor heads



CHAIN WIDTH

see page 56

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70

Guide rail and catenary: see page 73-76

Mounting instructions: see page 85

Chemical resistance: see page 86

Pitch 25,4 mm (1")

Open area 44%

FDA

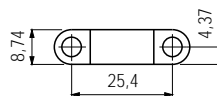
WHT material approved for direct contact with food products.

USDA

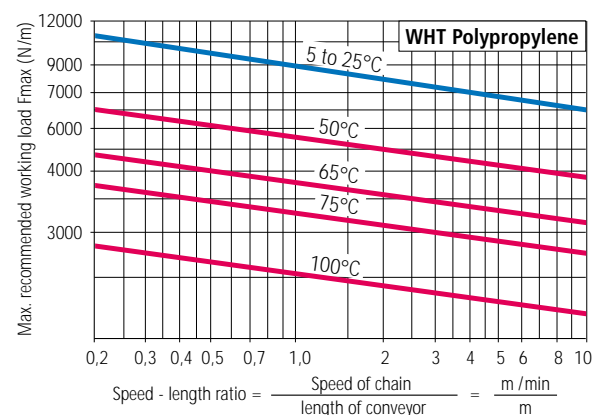
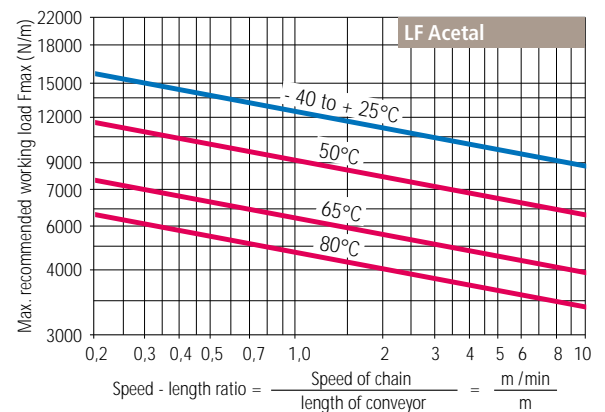
Chains approved for direct contact with meat and poultry.

Applications

Conveyors with empty cans.
Accumulation systems for cardboard and packaging.
Conveyors for dryers in the food industry.



Maximum recommended working load- Fmax



Standard materials	LF	WHT
	Acetal	Polypropylene
Colour	Light brown	White
Nominal strength * (N/m)	16100	7300
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 105
Weight (Kg/m ²)	4,84	3,70
Pin material	WHT polypropylene (white)	

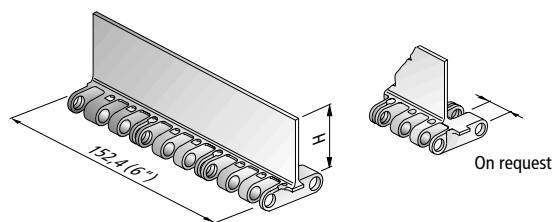
* = Values for a belt width of 1 m, at +20°C.

Pin retention : with plugs (LF 2100), hotformed heads (WHT 2100).

Available on request other materials and colours.

Flights

CHAINS AND ACCESSORIES



Code Rexnord Nr.	H mm	Material
LF 2100 F1	25	LF acetal (light brown)
WHT 2100 F1		WHT polypropylene (white)

On request other heights can be supplied.
Material characteristics : see page 12.1-13.1.

Transfer plates

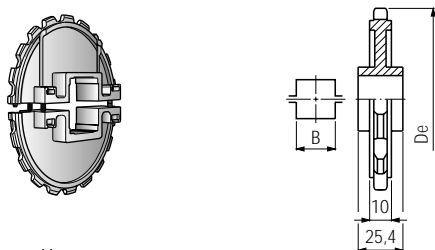


Code Rexnord Nr.	mm	K inch	Material
Transfer plate K 06	152,4	6	LF acetal (white)
Transfer plate K 12	304,8	12	

Material characteristics / mounting instruction : see page 82.

SPROCKETS for 2100

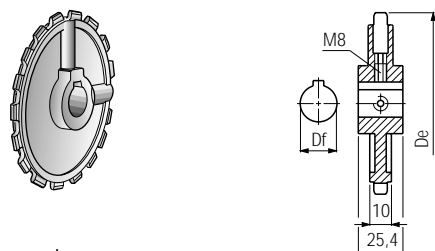
NS 2100 - split execution



Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
	actual	effective				
N 2100 T19 S40	19	19	154,33	154,9	40x40	0,18

Material : reinforced polyamid PA FV (black).
Material characteristics / mounting instruction : see page 77-81

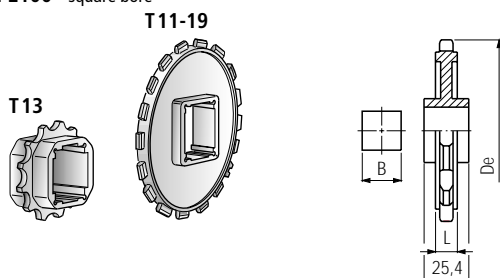
N 2100 - round bore



Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg	
N 2100 T19 R...	19	19	154,33	154,9	25-30-35-40	0,21

Material : acetal (black).
Seat keyway : UNI 6604 - 69. See page 77.
Material characteristics / mounting instruction : see page 77-81

N 2100 - square bore



Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
N 2100 T13 S25	13	6,5	54,66	53,2	25x25	0,01
N 2100 T11 S...	11	11	90,17	88,9	25x25-40x40	0,07
N 2100 T19 S...	19	19	154,33	154,9	40x40-65x65	0,18

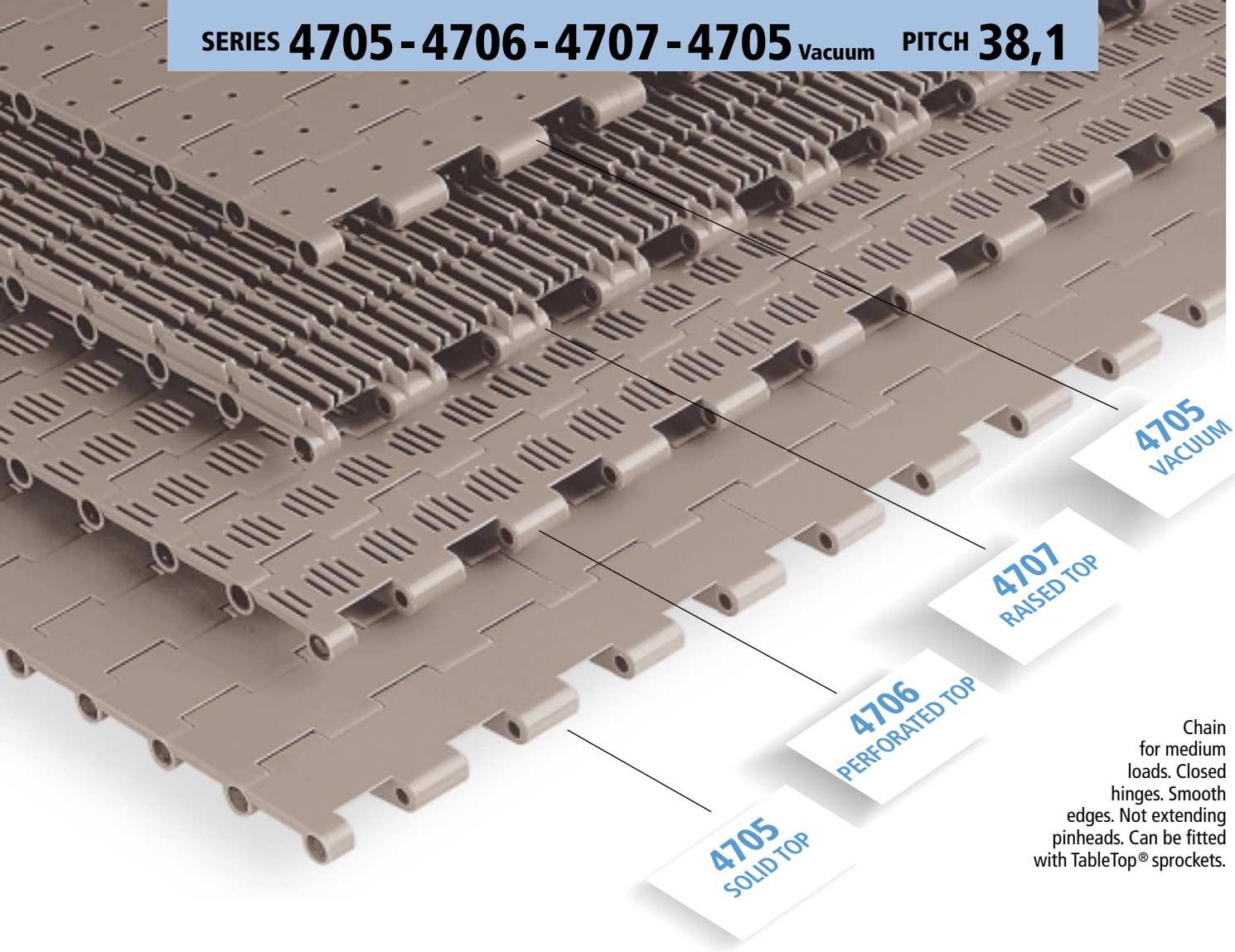
Material : acetal (black).
Material characteristics / mounting instruction : see page 77-81

Example of codenumber: N 2100 T19 R30 (including bore)

2100

25,4

SERIES 4705 - 4706 - 4707 - 4705 Vacuum PITCH 38,1



Chain for medium loads. Closed hinges. Smooth edges. Not extending pinheads. Can be fitted with TableTop® sprockets.



CHAIN WIDTH

see page 57

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70

Guide rail and catenary: see page 73-76

Mounting instructions: see page 85

Chemical resistance: see page 86

Pitch 38,1 mm (1 1/2")

Open area 4705 (2%)
4706 (22%)
4707 (23%)
4705 Vacuum (5%)

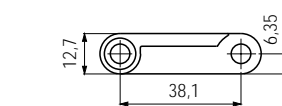
FDA

HT material approved for direct contact with food products.

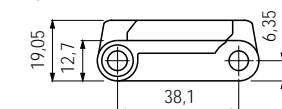
Applications

Replacement and/or conversion of multi-lane chain conveyors equipped with Table Top® conveyor chains. Accumulation tables. Elevators. Small and medium pasteurizers. (HT 4707). Vacuum invertors.

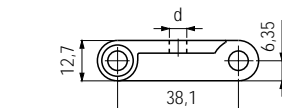
4705 - 4706



4707



4705 Vacuum



$d = \varnothing 3,2 - 4 - 5,6 - 6,4 - 7,1 - 7,9 \text{ mm}$
(see page 84)

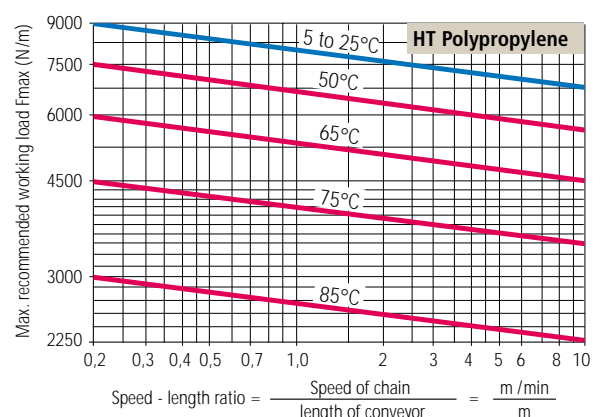
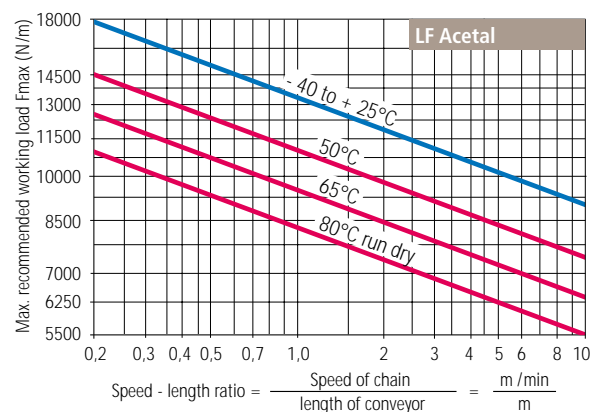
Standard materials	LF	HT
	Acetal	Polypropylene
Colour	Light brown	Beige
Nominal strength * (N/m)	17500	8750
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 105
WEIGHT (Kg/m ²)		
4705	9,14	6,19
4706	7,96	5,50
4707	10,45	6,93
4705 Vacuum	9,14	6,19
Pin material	Acetal (black)	

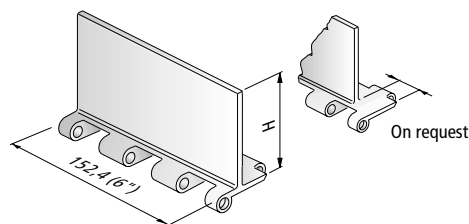
* = Values for a belt width of 1 m, at +20°C.

Pin retention : hotformed heads (4705-4706-4705 Vacuum); with plugs (4707).

Available on request other materials and colours.

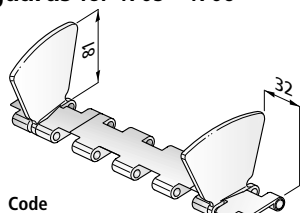
Maximum recommended working load- Fmax



Flights for 4705 - 4706


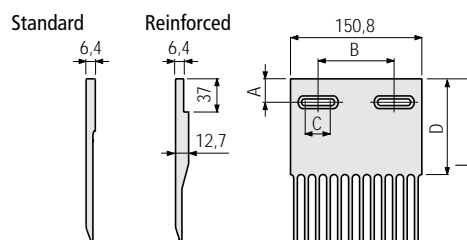
Code Rexnord Nr.	H mm	Material
LF 4700 F2 HT 4700 F2	51	LF acetal (light brown) HT polypropylene (beige)
LF 4700 F3 HT 4700 F3	76	LF acetal (light brown) HT polypropylene (beige)

On request other heights can be supplied.
Material characteristics : see page 12.1-13.1.

Side guards for 4705 - 4706


Code Rexnord Nr.	Execution	Material
Side guard 4700 DX Side guard 4700 SX	Right Left	WHT polypropylene (white)

Material characteristics : see page 12.1-13.1.

Transfer combs for 4707


Code Rexnord Nr.	Execution	L mm	B mm	C mm	A mm	D mm
Comb 4707 146 Comb 4707 190 Comb 4707 216	Standard	146 190 216	101,6 82,6 82,6	18 38 38	25,4 25,4 50,8	50,8 64,1 89,5
Comb 4707 157 R Comb 4707 187 R	Reinforced	157 187	82,6	37	25,4	111,3

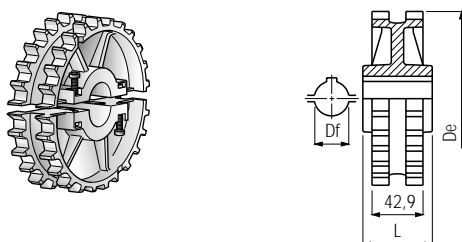
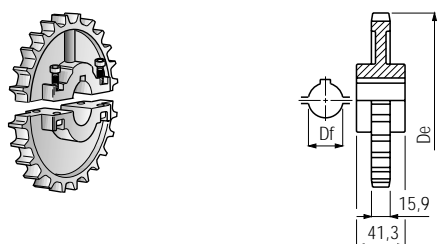
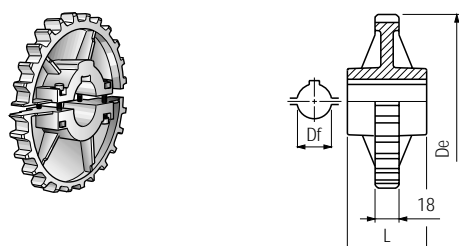
Material : reinforced polyamid PA FV (black). For L 146 : white acetal.
Supplied with screws M6 in stainless steel and plugs (clip-in) for the slotted holes.
Material characteristics / mounting instruction : see page 82.

Transfer plates for 4705 - 4706 - 4705 vacuum


Code Rexnord Nr.	K mm inch	Material
Transfer plate K 06 Transfer plate K 12	152,4 304,8	6 12 LF acetal (white)

Material characteristics : see page 12.1-13.1.

SPROCKETS for 4705 - 4706 - 4707 - 4705 vacuum

NS 4700 - split execution

NS 5700 - split execution

NS 5700 - split execution


Code Rexnord Nr.	No. of teeth Z actual effective	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Weight kg
NS 4700 T21 R...	21	10,5	129,26	129,5	25-30-35-40-45	51 0,46
NS 4700 T23 R...	23	11,5	141,22	142	25-30-35-40-45	51 0,54
NS 4700 T25 R...	25	12,5	153,21	154,2	25-30-35-40-45	58,5 0,63

Material : reinforced polyamid PA FV (black).
Seat keyway : UNI 6604 - 69. See page 77.
Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp	Outside dia. De	Bore dia. Df	Weight kg
	actual	effective	mm	mm	
NS 5700 T24 R...	24	12	147,22	148,1	25-30-35
					0,46

Material : reinforced polyamid PA FV (black).
Seat keyway : UNI 6604 - 69. See page 77.
Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z actual effective	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Weight kg
NS 5700 T21 R...	21	10,5	129,26	129,5	25-30-35-40-45	51 0,46
NS 5700 T23 R...	23	11,5	141,22	142	25-30-35-40-45	51 0,54
NS 5700 T25 R...	25	12,5	153,21	154,2	25-30-35-40-45	58,5 0,63

Material : reinforced polyamid PA FV (black).
Seat keyway : UNI 6604 - 69. See page 77.
Material characteristics / mounting instruction : see page 77-81

Example of codenumber: NS 4700 T23 R30 (including bore)

**CHAINS AND
ACCESSORIES**

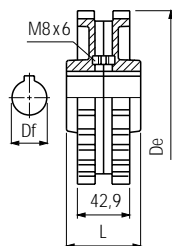
Series Pitch

**4705
4706
4707
4705
vacuum**
38,1

CHAINS AND
ACCESSORIES

Pitch Series

N 4700 - round bore



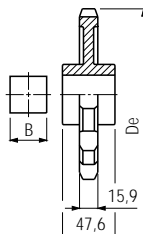
Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Dr mm	L mm	Weight kg
	actual	effective					
N 4700 T17 R...	17	8,5	105,48	104,7	25-30	48	0,22
N 4700 T19 R...	19	9,5	117,35	117,1	25-30	50	0,35

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

Material characteristics / mounting instruction : see page 77-81

N 4700 - square bore

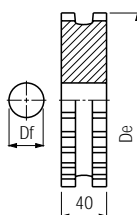
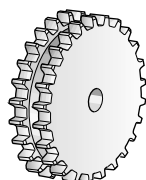


Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
	actual	effective				
N 4700 T12 S...	12	12	147,22	146	40x40-50x50-65x65	0,22
N 4700 T21 S65	21	21	255,62	256	65x65	0,35

Material : acetal (black).

Material characteristics / mounting instruction : see page 77-81

KU 4700 - with centre groove

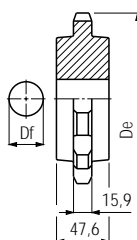
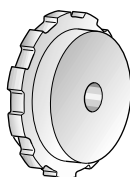


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg
KU 4700 T25 R20 25	12,5	153,21	153,5	20H ⁷	80	0,74

Material : polyamid PA (black).

Material characteristics / mounting instruction : see page 77-81

KU 4700

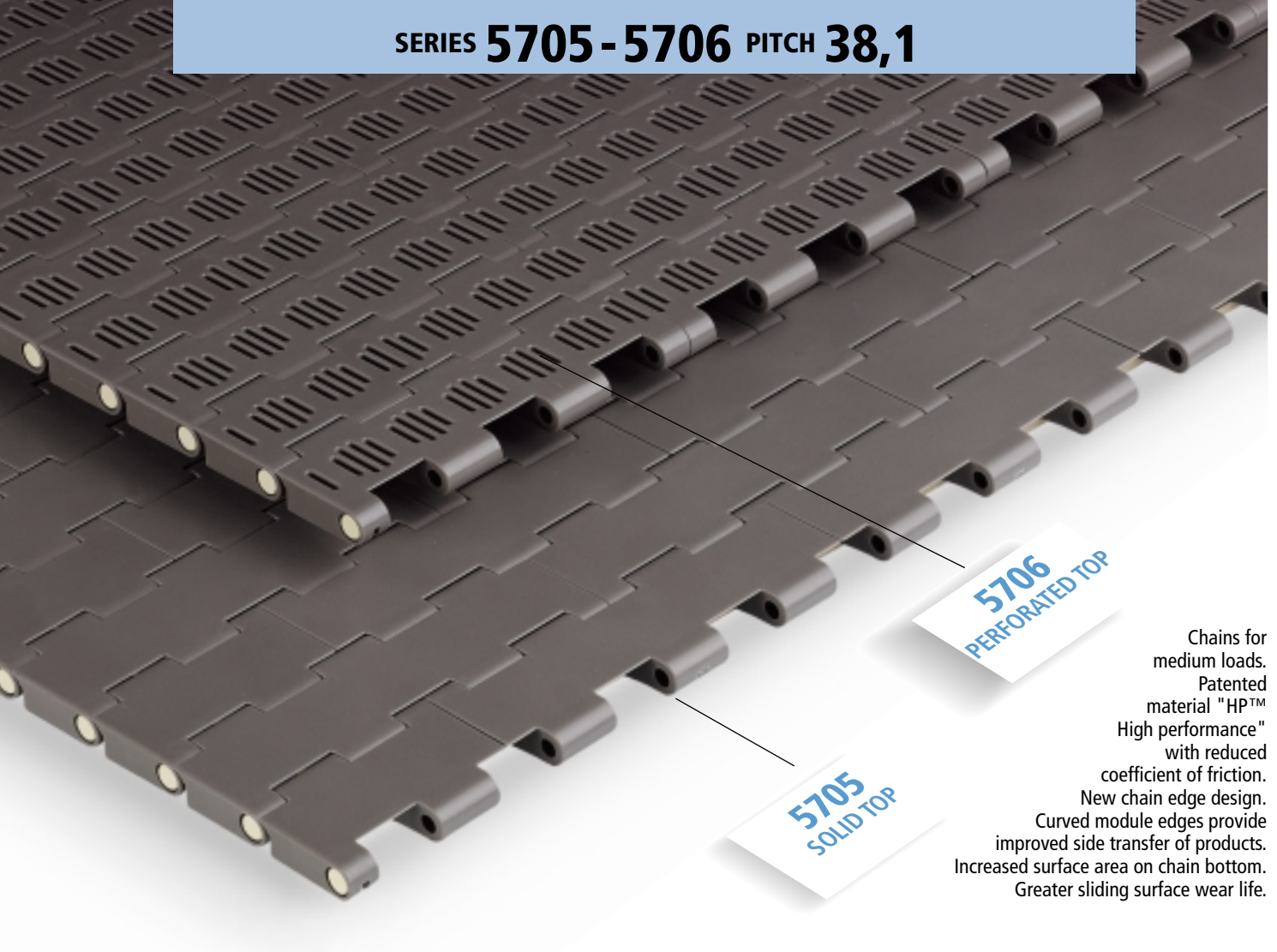


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg
	actual	effective				
KU 4700 T12 R20 12	12	147,22	146	20H ⁷	70	–

Material : polyamid PA (black).

Material characteristics / mounting instruction : see page 77-81

SERIES 5705 - 5706 PITCH 38,1



Chains for medium loads.
Patented material "HP™"
High performance" with reduced coefficient of friction.
New chain edge design.
Curved module edges provide improved side transfer of products.
Increased surface area on chain bottom.
Greater sliding surface wear life.

CHAIN WIDTH
see page 61

MATERIAL CHARACTERISTICS
see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations:
see page 70
Guide rail and catenary:
see page 73-76
Mounting instructions:
see page 85
Chemical resistance :
see page 86

Pitch 38,1 mm (1 1/2")

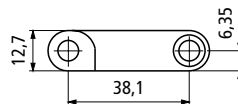
Open area 5705 (2%)
5706 (22%)

FDA Material approved for direct contact with food products.

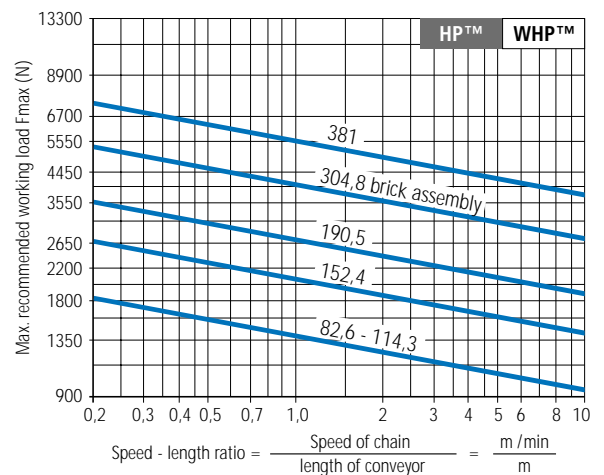
USDA Chains approved for direct contact with meat and poultry.

Applications
Brewing and soft drinks industries.

5705 - 5706



Maximum recommended working load - Fmax



Chainwidth assembled with multi modules (brick assembly)

Series	Weight Kg/m ²	Ave strength* N/m
5705 HP - WHP	9,14	17500
5706 HP - WHP	7,96	17500

* = Values for a belt width of 1 m, at + 20°C.

Chains with modules moulded to width

		5705 HP - WHP		5706 HP - WHP	
Width		Weight	Ave strength	Weight	Ave strength
mm	inch	Kg/m	N	Kg/m	N
82,6	3 1/4	0,79	1870	0,75	1870
114,3	4 1/2	1,09	1870	1,03	1870
152,4	6	1,46	2670	1,37	2670
190,5	7 1/2	1,82	3560	1,71	3560
381,0	15	3,67	7100	3,46	7100

Standard materials	HP™	WHP™
	High performance	
Colour	Grey	White
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	- 40 to + 80
in hot water	+ 65	+ 65
Pin material	WHT polypropylene (white)	

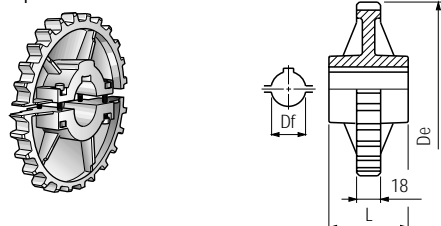
Pin retention : with plugs.
Available on request other materials and colours.

Transfer plates for 5705 - 5706


Code Rexnord Nr.	K mm	inch	Material
Transfer plate K 06	152,4	6	LF acetal (white)
Transfer plate K 12	304,8	12	

Material characteristics : see page 12.1-13.1.

**CHAINS AND
ACCESSORIES**
SPROCKETS for 5705 - 5706

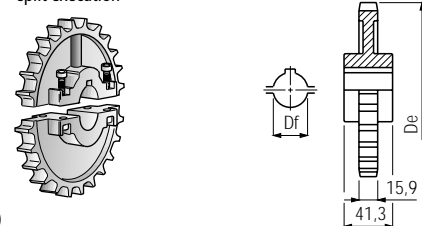
NS 5700 - split execution


Code Rexnord Nr.		No. of teeth Z	Pitch dia. Dp	Outside dia. De	Bore dia. Df	L mm	Weight kg
		actual	effective	mm	mm		
NS 5700 T21 R...	21	10,5	129,26	129,5	25-30-35-40-45	51	0,46
NS 5700 T23 R...	23	11,5	141,22	142	25-30-35-40-45	51	0,54
NS 5700 T25 R...	25	12,5	153,21	154,2	25-30-35-40-45	58,5	0,63

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

Material characteristics / mounting instruction : see page 77-81

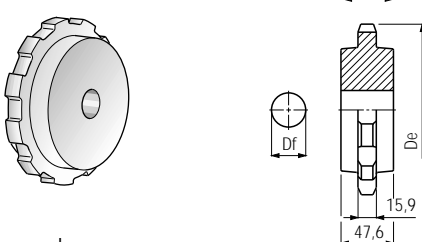
NS 5700 - split execution


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Weight kg
NS 5700 T24 R...	24	12	147,22	148,1	25-30-35
					0,46

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

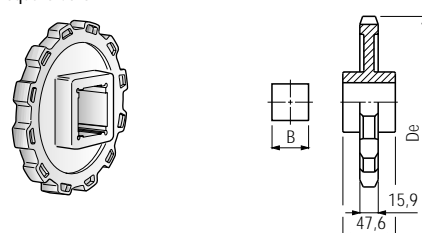
Material characteristics / mounting instruction : see page 77-81

KU 4700


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg
KU 4700 T12 R20 12	12	147.22	146	20 ^{H7}	70	—

Material : polyamid PA (black).

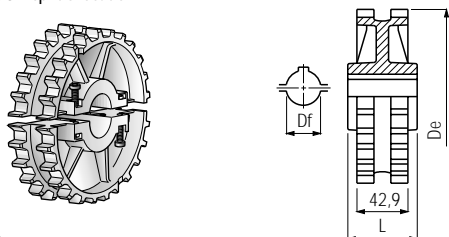
Material characteristics / mounting instruction : see page 77-81

N 4700 - square bore


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
N 4700 T12 S...	12	12	147,22	146	40x40-50x50-65x65	0,22
N 4700 T21 S65	21	21	255,62	256	65x65	0,35

Material : acetal (black).

Material characteristics / mounting instruction : see page 77-81

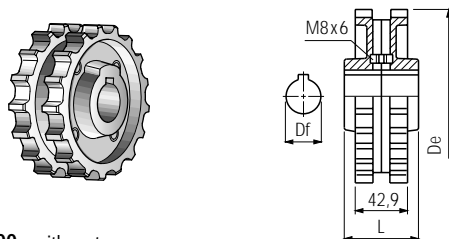
Sprockets with centre groove - Not recommended for chains with modules moulded to width K3,25 (82,6 mm) - K4,5 (114,3 mm) - K7,5 (190,5 mm)
NS 4700 - split execution


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Weight kg	
NS 4700 T21 R...	21	10,5	129,26	129,5	25-30-35-40-45	51	0,46
NS 4700 T23 R...	23	11,5	141,22	142	25-30-35-40-45	51	0,54
NS 4700 T25 R...	25	12,5	153,21	154,2	25-30-35-40-45	58,5	0,63

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

Material characteristics / mounting instruction : see page 77-81

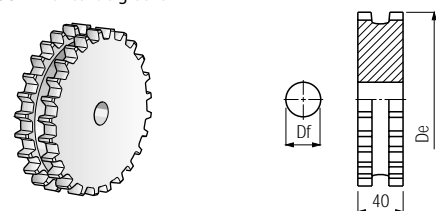
N 4700 - round bore


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Weight kg	
	actual	effective					
N 4700 T17 R...	17	8,5	105,48	104,7	25-30	48	0,22
N 4700 T19 R...	19	9,5	117,35	117,1	25-30	50	0,35

Material : reinforced polyamid PA FV (black).

Seat keyway : UNI 6604 - 69. See page 77.

Material characteristics / mounting instruction : see page 77-81

KU 4700 - with centre groove


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg	
	actual	effective					
KU 4700 T25 R20	25	12.5	153.21	153.5	20 ^{H7}	80	0.74

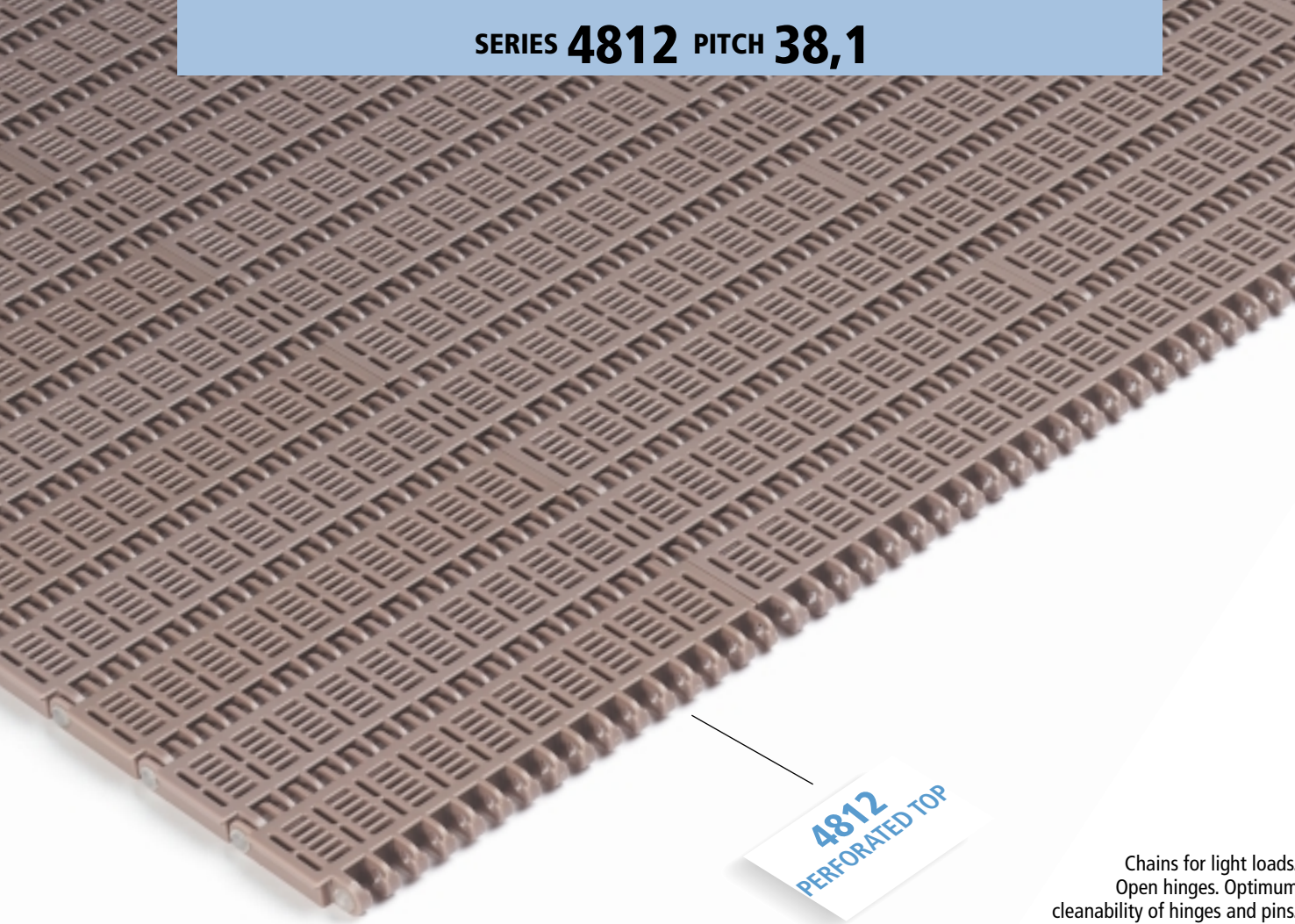
Material : polyamid PA (black).

Material characteristics / mounting instruction : see page 77-81

Example of codenumber: NS 4700 T23 R30 (including bore)

**5705
5706**
38,1

SERIES 4812 PITCH 38,1



4812
PERFORATED TOP

Chains for light loads.
Open hinges. Optimum
cleanability of hinges and pins.

CHAIN WIDTH
see page 58

MATERIAL CHARACTERISTICS
see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations:
see page 70
Guide rail and catenary:
see page 73-76

Mounting instructions:
see page 85

Chemical resistance :
see page 86

Pitch 38,1 mm (1 1/2")

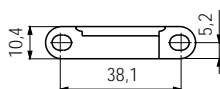
Open area 33%

FDA

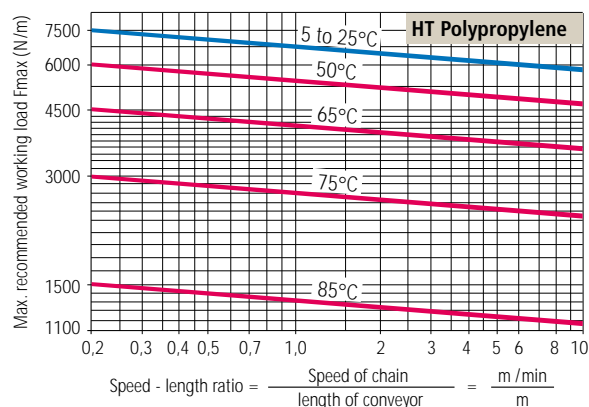
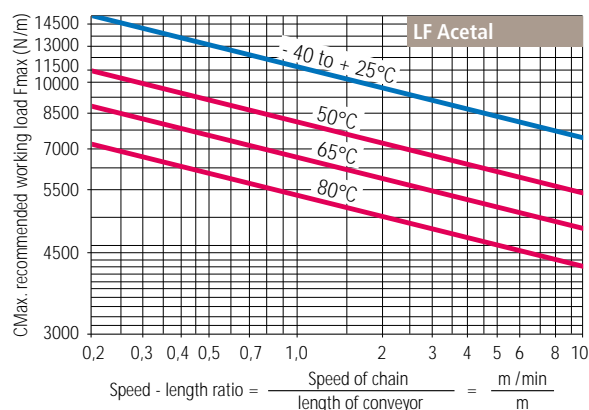
HT material approved
for direct contact
with food products.

Applications

Light duty accumulation tables.
Drainage systems and elevators.
Conveyors for snacks.



Maximum recommended working load- Fmax



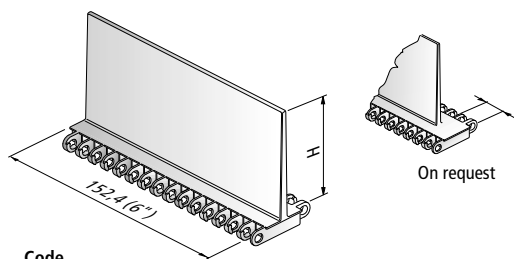
Standard materials	LF	HT
	Acetal	Polypropylene
Colour	Light brown	Beige
Nominal strength * (N/m)	14600	7300
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 105
Weight (Kg/m ²)	6,05	3,90
Pin material	WHT polypropylene (white)	

* = Values for a belt width of 1 m, at +20°C.

Pin retention : hotformed heads.

Available on request other materials and colours.

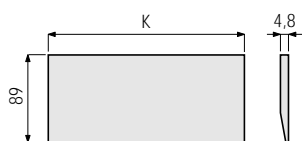
Flights



Code Rexnord Nr.	H mm	Material
LF 4812 F3	76	LF acetal (light brown)
HT 4812 F3		HT polypropylene (beige)

On request other heights can be supplied.
Material characteristics : see page 12.1-13.1.

Transfer plates

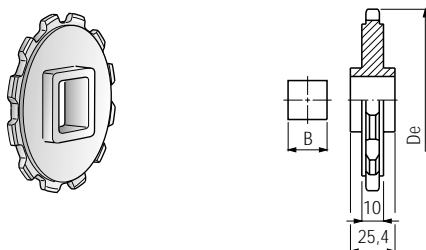


Code Rexnord Nr.	K mm	K inch	Material
Transfer plate K 06	152,4	6	LF acetal (white)
Transfer plate K 12	304,8	12	

Material characteristics / mounting instruction : see page 82.

SPROCKETS for 4812

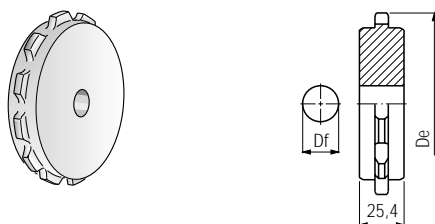
N 4802



Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
N 4802 T12 S...	12	12	147,22	147,3	40x40-65x65	0,13

Material : reinforced polyamid PA FV (black).
Material characteristics / mounting instruction : see page 77-81

KU 4802



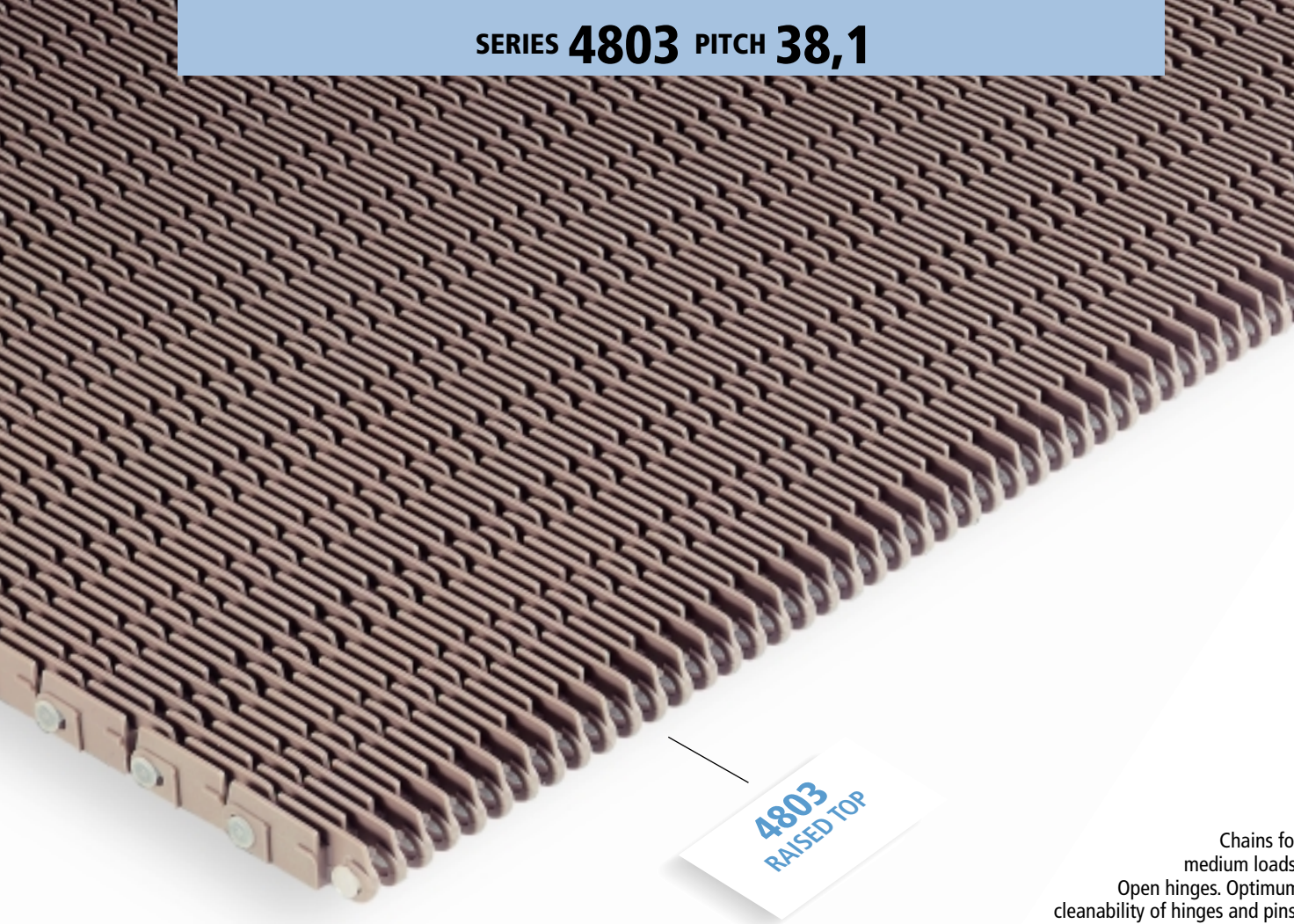
Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg
	actual	effective					
KU 4802 T08 R20	8	8	99,56	97,4	20 ^{H7}	50	—
KU 4802 T12 R20	12	12	147,22	147,3	20 ^{H7}	80	—

Material : polyamid PA (black).
Material characteristics / mounting instruction : see page 77-81

CHAINS AND
ACCESSORIES

Series Pitch

4812
38,1



4803
RAISED TOP

Chains for
medium loads.
Open hinges. Optimum
cleanability of hinges and pins.

CHAIN WIDTH

see page 59

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull
calculations:
see page 70

Guide rail and
catenary:
see page 73-76

Mounting
instructions:
see page 85

Chemical
resistance :
see page 86

Pitch 38,1 mm (1 1/2")

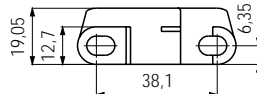
Open area 44%

FDA

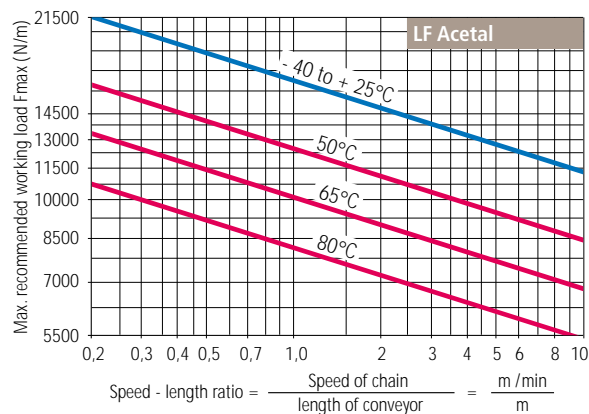
HT material approved
for direct contact
with food products.

Applications

Accumulation tables.
Medium size conveyors.
Small and medium pasteurizers.
Packaging systems.



Maximum recommended working load- Fmax

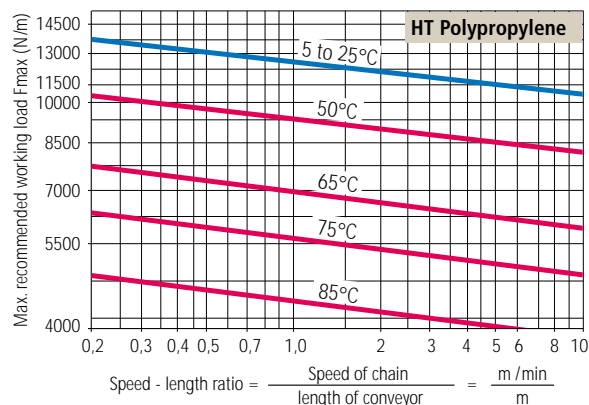


Standard materials	LF	HT
	Acetal	Polypropylene
Colour	Light brown	Beige
Nominal strength * (N/m)	21900	13000
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 105
Weight (Kg/m ²)	11,4	7,2
Pin material	WHT polypropylene (white)	

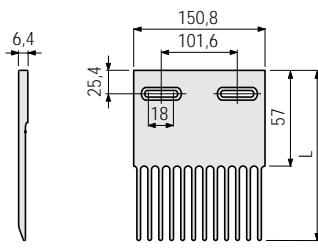
* = Values for a belt width of 1 m, at +20°C.

Pin retention : hotformed heads.

Available on request other materials and colours.



Transfer comb



Code Rexnord Nr.	L mm	Material
Comb 4803 152	152	Acetal (white)

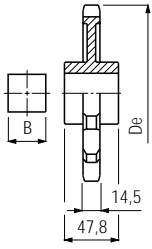
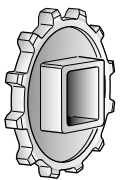
Supplied with screws M6 in stainless steel and plugs (clip-in) for the slotted holes.
Material characteristics / mounting instruction : see page 82.

CHAINS AND
ACCESSORIES

Series Pitch

SPROCKETS for 4803

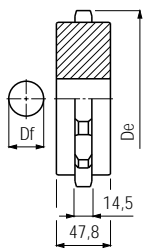
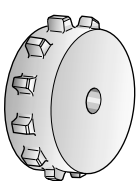
N 4803



Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
N 4803 T12 S...	12	12	147,22	147,2	40x40-65x65	0,19

Material : polyethylene PE (black).
Material characteristics / mounting instruction : see page 77- 81

KU 4803



Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg
	actual	effective					
KU 4803 T08 R20	8	8	99,56	97,4	20 ^{H7}	50	–
KU 4803 T12 R20	12	12	147,22	147,2	20 ^{H7}	80	–

Material : polyamid PA (black).
Material characteristics / mounting instruction : see page 77-81

4803
38,1

SERIES 6390 - 6391 - 6392 PITCH 50



Chains for medium-high loads. These chains can be supplied with and without tension plates. The tension plates improve the working load of the chain and the dimensional stability. Temperature of operation up to 130 °C (version YSM). Closed hinges. Smooth edges. Pins riveted.

CHAIN WIDTH
see page 64

MATERIAL CHARACTERISTICS
see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations:
see page 71
Guide rail and catenary:
see page 73-76

Mounting instructions:
see page 85
Chemical resistance :
see page 86

Pitch 50 mm (1 31/32")

Open area 6390 (2%)
6391 (26%)
6392 (48%)

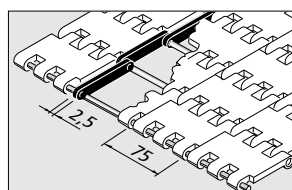
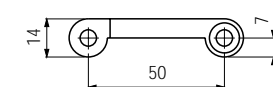
FDA

The WTH polypropylene and WLT polyethylene are approved for direct contact with food

Applications

Washers for vegetables.
Cooking and cooling equipments.
Elevators.

6390 - 6391 - 6392



Chains with tension plates

The tension plates give the chain an increased load capacity, an increased dimensional stability (length) against shockloads and extreme temperature differences (pasteurizers cookers, coolers, etc.). The thermal, transversal stability is ensured by the metal chain pins.

**The load capacity of the chain depends on the number of tension plates assembled in the chain. The max. working load for every row of tension plates is: 1500 N. Applying 2 rows of tension plates gives 3000 N, with 3 rows of tension plates 4500 N, etc. One row of tension plates can be applied every 75 mm of width (= module width).

Chains without tension plates

Suitable for light duty applications. The chains without tension plates are assembled with thermoplastic pins.

Standard materials	WHT		BHT		YSM	WLT	
	Polypropylene (white)		Polypropylene (blue)		Blend (yellow)	Polyethylene (white)	
State of supply	With plates	Without plates	With plates	Without plates	With plates	With plates	Without plates
Pin material	Stainless steel AISI 304	Polypropylene WHT	Stainless steel AISI 304	Polypropylene WHT	Stainless steel AISI 304	Stainless steel AISI 304	Polyethylene WLT
Max. working load without plates (N/m)	**	3000	**	3000	**	**	2000
WEIGHT (Kg/m ²)							
6390	9,55*	5,6	9,55*	5,6	9,55*	9,55*	5,6
6391	9,02*	5,1	9,02*	5,1	9,02*	9,02*	5,1
6392	8,75*	4,8	8,75*	4,8	8,75*	8,75*	4,8
TEMPERATURE OF OPERATION (°C)							
in air	+ 5 to + 105 + 105				+ 5 to + 130 + 130	- 70 to + 25	
in hot water							
Application characteristics	Suitable for general applications. High chemical resistance.				Increased resistance against high temperatures	Increased resistance against low temperatures. At temperatures under -5°C the version without tension plates is to be preferred as the risk of conveyed products freezing to the metal parts of the chain is almost minimal.	

* = Weight of tension plates to be added (1 row : 0,3 Kg/m).

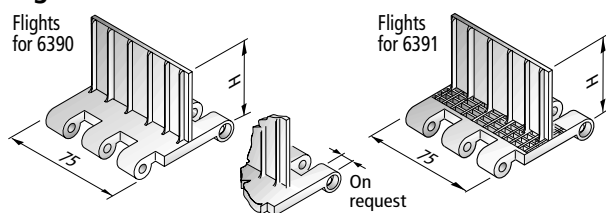
Tension plates material: stainless steel AISI 304.

On request the tension plates and pins can be supplied in stainless steel AISI 316.

(for an increased chemical resistance).

Pin retention : riveted.

Available on request other materials and colours.

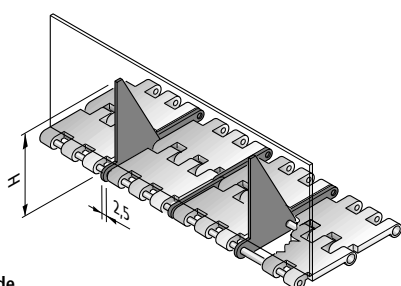
Flights for 6390 - 6391


Code 6390	Code 6391	H mm	Material
WHT 6390 H15	WHT 6391 H15	15	WHT polypropylene (white,blue)
YSM 6390 H15	YSM 6391 H15		YSM Blend (yellow)
WLT 6390 H15	WLT 6391 H15		WLT polyethylene (white)
WHT 6390 H50	WHT 6391 H50	50	WHT polypropylene (white,blue)
YSM 6390 H50	YSM 6391 H50		YSM Blend (yellow)
WLT 6390 H50	WLT 6391 H50		WLT polyethylene (white)

Not available for chain series 6392.

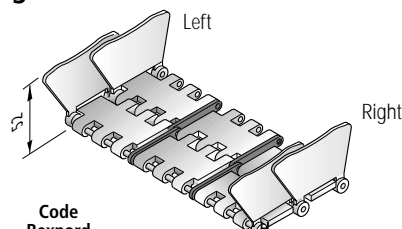
On request other heights can be supplied.

Material characteristics : see page 12.1-13.1.

Pusher attachments for flights 6390 - 6391 - 6392


Code Rexnord Nr.	H mm	Material
Pusher H60	60	Stainless steel AISI 304 (AISI 316 on request)
Pusher H75	75	

Application : permits the application of specially made metal flights.
Special flights can be welded on the pusher.

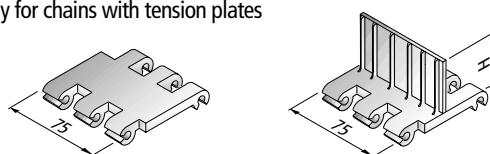
Side guards for 6390 - 6391 - 6392


Code Rexnord Nr.	Execution	Material
Side guard WHT 6000 DX	Right	WHT polypropylene (white,blue)
Side guard YSM 6000 DX		YSM Blend (yellow)
Side guard WLT 6000 DX		WLT polyethylene (white)
Side guard WHT 6000 SX	Left	WHT polypropylene (white,blue)
Side guard YSM 6000 SX		YSM Blend (yellow)
Side guard WLT 6000 SX		WLT polyethylene (white)

Material characteristics : see page 12.1-13.1.

Replacement modules and flights for 6390 - 6391 - 6392

Only for chains with tension plates

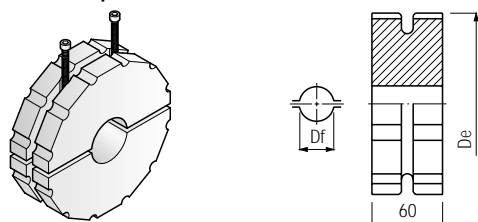
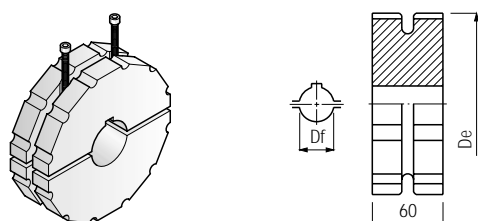
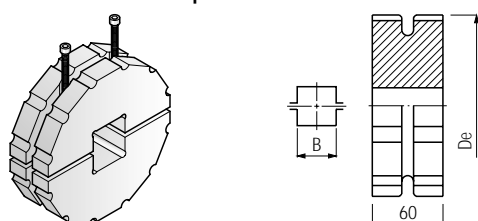


Chain	Code numbers for replacement modules			
	Module	Flight H 15	Flight H 50	
WHT 6390	WHT 6390 R	WHT 6390 H15 R	WHT 6390 H50 R	
YSM 6390	YSM 6390 R	YSM 6390 H15 R	YSM 6390 H50 R	
WLT 6390	WLT 6390 R	WLT 6390 H15 R	WLT 6390 H50 R	
WHT 6391	WHT 6391 R	WHT 6391 H15 R	WHT 6391 H50 R	
YSM 6391	YSM 6391 R	YSM 6391 H15 R	YSM 6391 H50 R	
WLT 6391	WLT 6391 R	WLT 6391 H15 R	WLT 6391 H50 R	
WHT 6392	WHT 6392 R	-	-	
YSM 6392	YSM 6392 R	-	-	
WLT 6392	WLT 6392 R	-	-	

Assembly : can be pressed into an existing chain. See page 85.

Material characteristics : see page 12.1-13.1.

SPROCKETS for 6390 - 6391 - 6392

KUS 6390 - With plain bore

KUS 6390 - With finished bore

KUS 6390 - With finished square bore


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	Df max mm	Weight kg
KUS 6390 T08 R19,5	8	8	130,64	120,7	19,5	0,59
KUS 6390 T10 R19,5	10	10	161,80	153,9	19,5	0,98
KUS 6390 T12 R19,5	12	12	193,18	186,6	19,5	1,48
KUS 6390 T16 R19,5	16	16	256,29	251,4	19,5	2,60

Material : polyethylene PE (white).

Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp	Outside dia. De	Bore dia. Df	Weight kg
	actual	effective	mm	mm	mm	
KUS 6390 T08 R35	8	8	130,64	120,7	35	0,59
KUS 6390 T10 R35	10	10	161,80	153,9	35	0,98
KUS 6390 T12 R35	12	12	193,18	186,6	35	1,48
KUS 6390 T16 R35	16	16	256,29	251,4	35	2,60

Material : polyethylene PE (white).

Seat keyway : UNI 6604-69. See page 77.

Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp	Outside dia. De	Square bore B	Weight	
	actual	effective	mm	mm	kg	
KUS 6390 T08 S40	8	8	130,64	120,7	40x40	0,59
KUS 6390 T10 S...	10	10	161,80	153,9	40x40, 50x50	0,98
KUS 6390 T12 S...	12	12	193,18	186,6	40x40, 50x50	1,48
KUS 6390 T16 S...	16	16	256,29	251,4	40x40, 50x50	2,60

Material : polyethylene PE (white).

Material characteristics / mounting instruction : see page 77-81

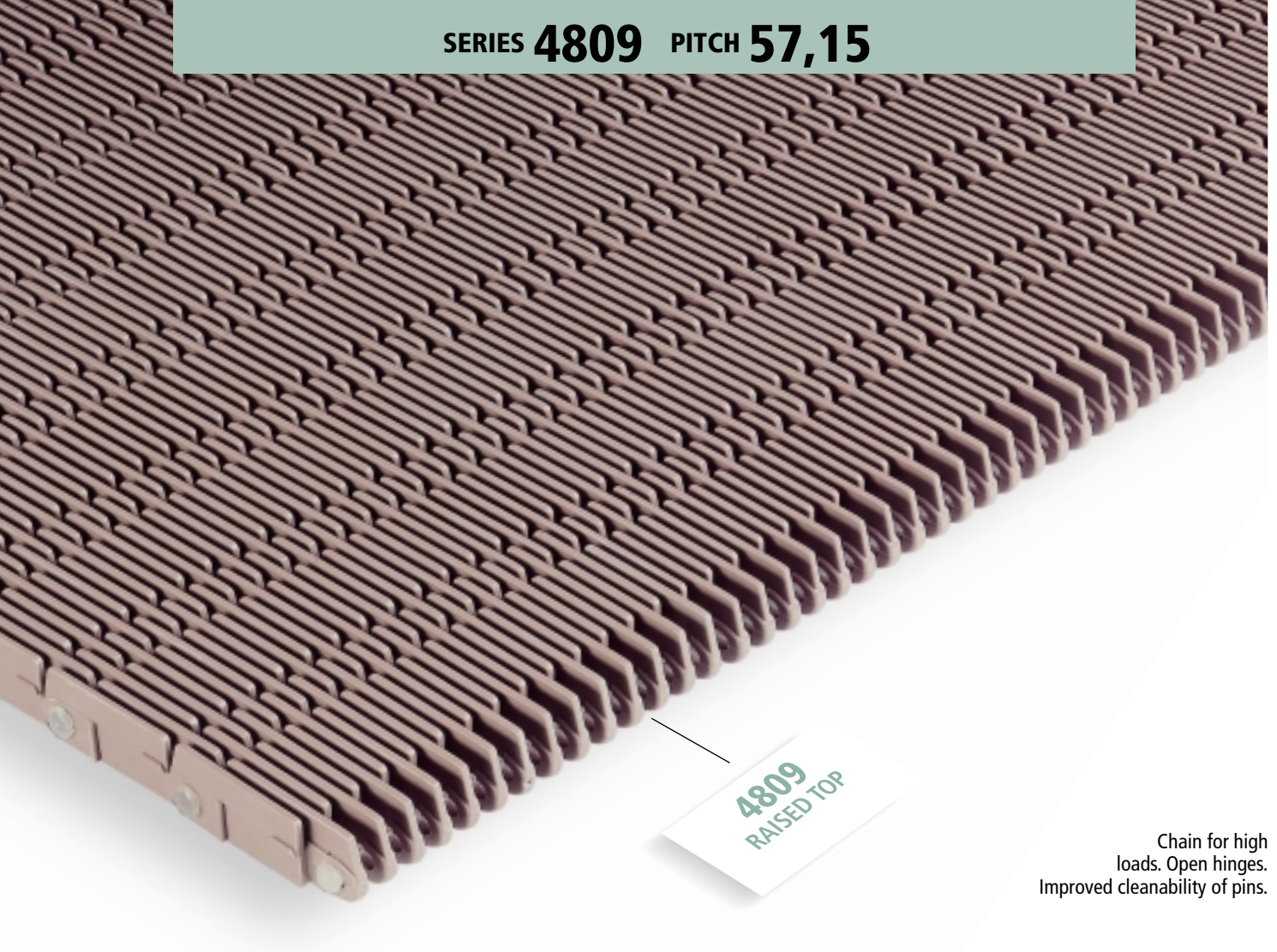
Example of codenumber : KUS 6390 T12 S40x40 (including bore)

CHAINS AND
ACCESSORIES

Series Pitch

6390
6391
6392

50



**4809
RAISED TOP**

Chain for high loads. Open hinges. Improved cleanability of pins.



CHAIN WIDTH

see page 60

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations:
see page 70

Guide rail and catenary:
see page 73-76

Mounting instructions:
see page 85

Chemical resistance :
see page 86

Pitch 57,15 mm (2 1/4")

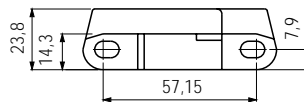
Open area 34%

FDA

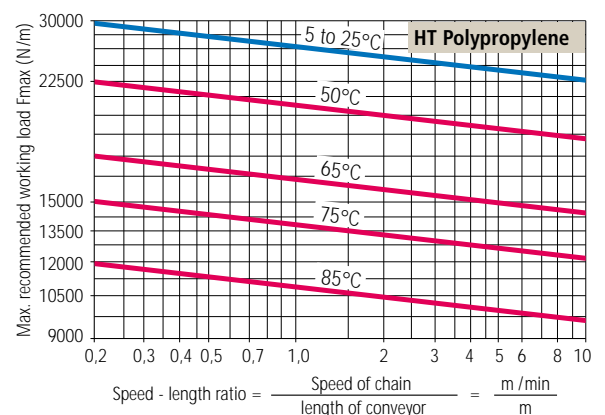
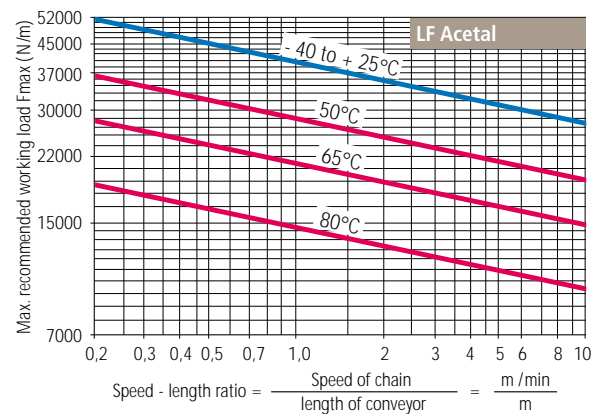
HT material approved for direct contact with food products.

Applications

Large pasteurizers.
Large accumulation tables.



Maximum recommended working load- Fmax



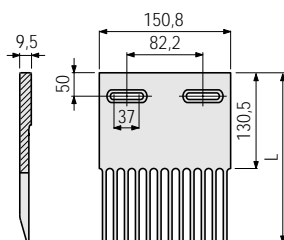
Standard materials	LF	HT
	Acetal	Polypropylene
Colour	Light brown	Beige
Nominal strength * (N/m)	43800	29200
TEMPERATURE OF OPERATION (°C)		
in air	- 40 to + 80	+ 5 to + 105
in hot water	+ 65	+ 105
Weight (Kg/m ²)	15	10
Pin material	WHT polypropylene (white)	

* = Values for a belt width of 1 m, at +20°C.

Pin retention : hot formed heads.

Available on request other materials and colours.

Standard transfer combs



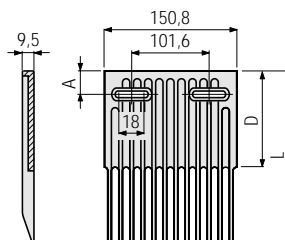
Code Rexnord Nr.	L mm	Material
Comb 4809 221	221	PA FV reinforced polyamid (black)

Supplied with screws M6 in stainless steel and plugs (clip-in) for the slotted holes.

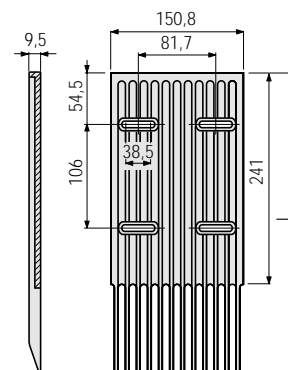
Material characteristics / mounting instruction : see page 82.

Transfer combs with grooved surface

With two mounting bolts



With four mounting bolts



Type	Code Rexnord Nr.	L mm	A mm	D mm	Material
With two mounting bolts	Comb LF 4809 146	146	25,4	57	LF acetal (light brown)
	Comb HT 4809 146				HT polypropylene (beige)
	Comb 4809 216	216	50,8	88,5	LF acetal (white)
With four mounting bolts	Comb 4809 331	331	-	-	HP™ (grey)

Supplied with screws M6 in stainless steel and plugs (clip-in) for the slotted holes.

Suitable for glass bottles. Prevents trapping glassparticles.

Not suitable for PET bottles or instable products.

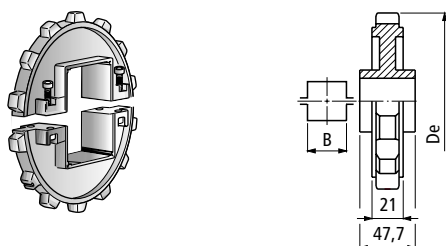
Material characteristics / mounting instruction : see page 82.

CHAIN AND
ACCESSORIES

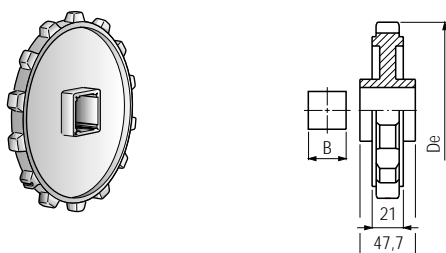
Series Pitch

SPROCKETS for 4809

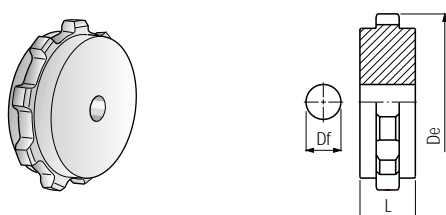
NS 5996 - split execution



N 5996 - N 5996 High Temperature



KU 5996



Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
	actual	effective				
NS 5996 T14 S...HS	14	14	256,82	256,5	90x90-120x120	0,77

Material : reinforced polyamid (green), high temperature resistant.

Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
	actual	effective				
N 5996 T07 S40	7	7	131,72	125,5	40x40	0,23
* N 5996 T09 S...HS	9	9	167,08	164,1	40x40-50x50-65x65	0,40
* N 5996 T14 S...HS	14	14	256,82	256,5	40x40-50x50-65x65-90x90	0,77

* High temperature resistance

Material : acetal, black (N 5996). Reinforced polyamid , green (N 5996 HS).

Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.		No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Df max mm	Weight kg
	actual	effective						
KU 5996 T09 R20	9	9	167,08	164,1	20 H7	44,3	90	—
KU 5996 T14 R20	14	14	256,82	256,5	20 H7	47,7	120	—

Material : polyamid PA (black).

Material characteristics / mounting instruction : see page 77-81

Example of codenumber : N 5996 T09 S50x50 (including bore)



The Mat Top® chain with highest load capacity. Smooth and rounded edges. Pins are locked by removable plugs.



CHAIN WIDTH

see page 62

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70

Guide rail and catenary: see page 73-76

Mounting instructions: see page 85

Chemical resistance: see page 86

Pitch 57,15 mm (2 1/4")

Open area 5996 (21%)
5997 (22%)

FDA

WHT, WLT, HT materials approved for direct contact with food products.

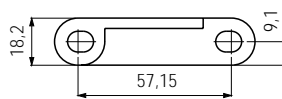
USDA

5996 approved for direct contact with meat and poultry.

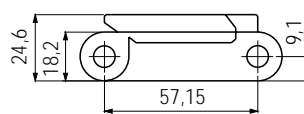
Applications

Large pasteurizers.
Accumulation tables in glass industry.
Large elevators.
Bulk conveyors in food industries.
Washing equipment in food industry.
Freezers and coolers.

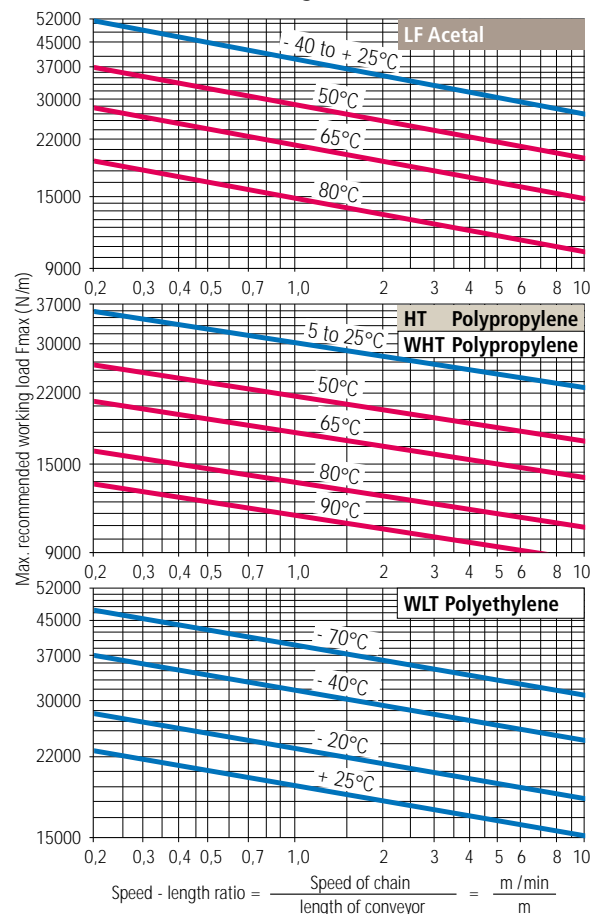
5996



5997



Maximum recommended working load- Fmax



5996

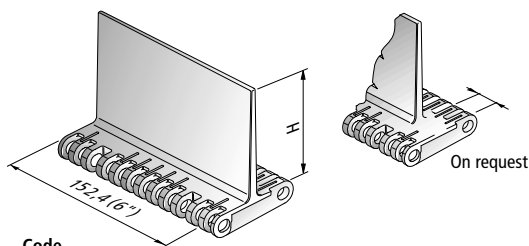
5997

Standard materials	LF	WHT	WLT	HT
	Acetal	Polypropylene	Polyethylene	Polypropylene
Colour	Light brown	White	White	Beige
Nominal strength * (N/m)	51000	35000	23300	35000
TEMPERATURE OF OPERATION (°C)				
in air	- 40 to + 80	+ 5 to + 105	- 70 to + 25	+ 5 to + 105
in hot water	+ 65	+ 105	-	+ 105
Weight (Kg/m²)	11,30	8,36	8,85	10,81
Pin material	WHT polypropylene (white)		WLT polyethylene (white)	WHT polypropylene (white)

* = Values for a belt width of 1 m, at +20°C.

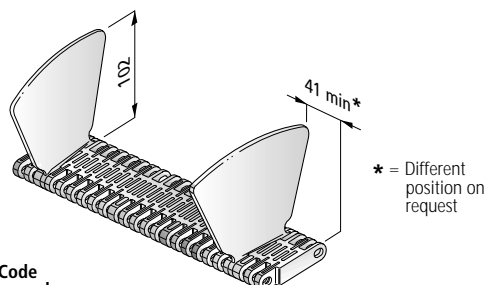
Pin retention : with plugs or hotformed heads.

Available on request other materials and colours.

Flights for 5996


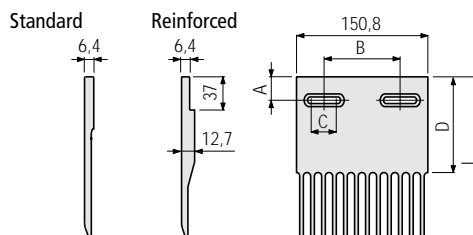
Code Rexnord Nr.	H mm	Material
LF 5996 F4	102	LF acetal (light brown)
WHT 5996 F4		WHT polypropylene (white)
WLT 5996 F4		WLT polyethylene (white)

On request other heights can be supplied.
Material characteristics : see page 12.1-13.1.

Side guards for 5996


Code Rexnord Nr.	Execution	Material
Side guard WHT 5996 DX	Right	WHT polypropylene (white)
Side guard WHT 5996 SX	Left	
Side guard WLT 5996 DX	Right	WLT polyethylene (white)
Side guard WLT 5996 SX	Left	

Material characteristics : see page 12.1-13.1.

Transfer combs for 5997


Code Rexnord Nr.	Execution	L mm	B mm	C mm	A mm	D mm
Comb 4707 146	Standard	146	101,6	18	25,4	50,8
Comb 4707 190		190	82,6	38	25,4	64,1
Comb 4707 216		216	82,6	38	50,8	89,5
Comb 4707 157 R	Reinforced	157	82,6	37	25,4	111,3
Comb 4707 187 R		187				

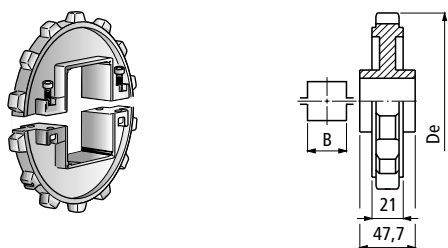
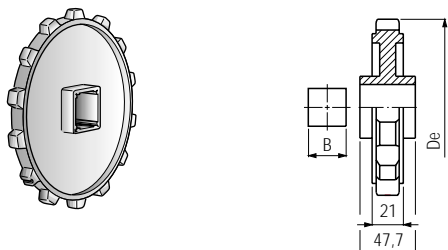
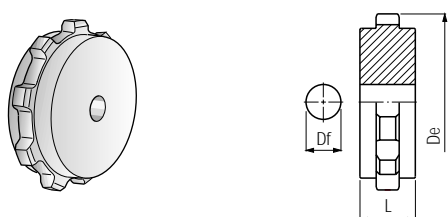
Material : reinforced polyamid PA FV (black). For L 146 : white acetal.
Supplied with screws M6 in stainless steel and plugs (clip-in) for the slotted holes.
Material characteristics / mounting instruction : see page 82.

Transfer plates for 5996


Code Rexnord Nr.	K mm	K inch	Material
Transfer plate K 06	152,4	6	LF acetal (white)
Transfer plate K 12	304,8	12	

Material characteristics / mounting instruction : see page 82.

SPROCKETS for 5996 - 5997

NS 5996 - split execution

N 5996 - N 5996 High Temperature

KU 5996


Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg
	actual	effective				
NS 5996 T14 S...HS	14	14	256,82	256,5	90x90-120x120	0,77

Material : reinforced polyamid (green), high temperature resistant.
Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
N 5996 T07 S40	7	7	131,72	125,5	40x40	0,23
N 5996 T09 S...HS	9	9	167,08	164,1	40x40-50x50-65x65	0,40
N 5996 T14 S...HS	14	14	256,82	256,5	40x40-50x50-65x65-90x90	0,77

* High temperature resistance

Material : acetal, black (N 5996). Reinforced polyamid , green (N 5996 HS).
Material characteristics / mounting instruction : see page 77-81

Code Rexnord Nr.	No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Df max mm	Weight kg
	actual	effective						
KU 5996 T09 R20	9	9	167,08	164,1	20 H7	44,3	90	—
KU 5996 T14 R20	14	14	256,82	256,5	20 H7	47,7	120	—

Material : polyamid PA (black).
Material characteristics / mounting instruction : see page 77-81

Example of codenumber : N 5996 T09 S50x50 (including bore)

**CHAINS AND
ACCESSORIES**

Series Pitch

**5996
5997**
57,15

Rex 5998 Chain: with 45% Open Area



- New, Rex® 5998 MatTop® thermoplastic chain provides an extremely large open area for highly efficient drainage while also providing heavy-duty chain strength
- The chain is easy to clean and has excellent chemical and abrasive resistance characteristics

- Rex® 5998 MatTop® chain features a unique pin retention design. There are no plugs and no need for a soldering gun to secure pins, therefore the pins are completely reusable.





5998
PERFORATED TOP

Chain for high loads. Open hinges. Improved cleanability of pins.



CHAIN WIDTH

see page 63

MATERIAL CHARACTERISTICS

see page 12.1-13.1

ENGINEERING INFORMATION

Chain pull calculations: see page 70

Guide rail and catenary: see page 73-76

Mounting instructions: see page 85

Chemical resistance : see page 86

Pitch 57,15 mm (2 1/4")

Open area 45%

FDA

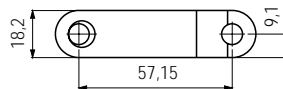
Material approved for direct contact with food products.

USDA

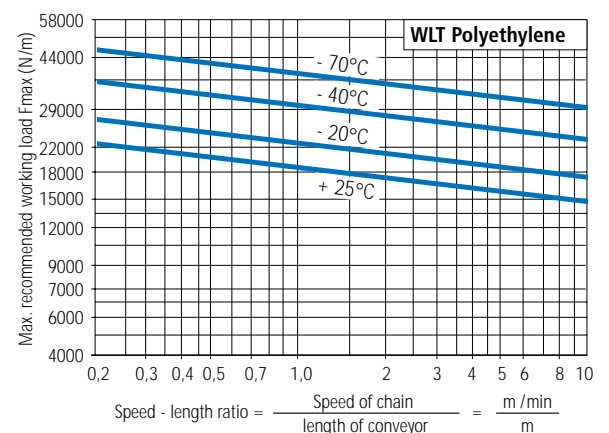
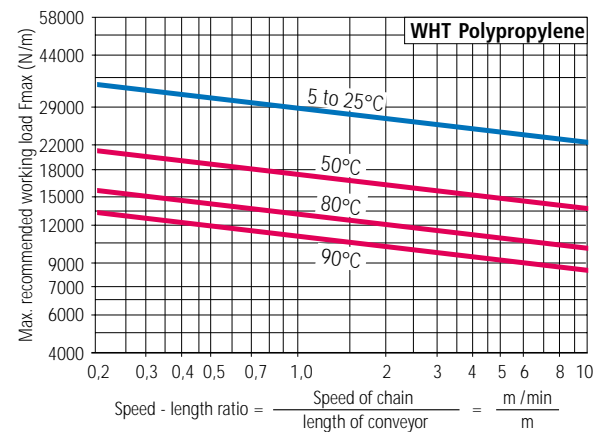
Chains approved for direct contact with meat and poultry.

Applications

Bulk food handling, freezing, blanching, cooking and washing.



Maximum recommended working load- Fmax



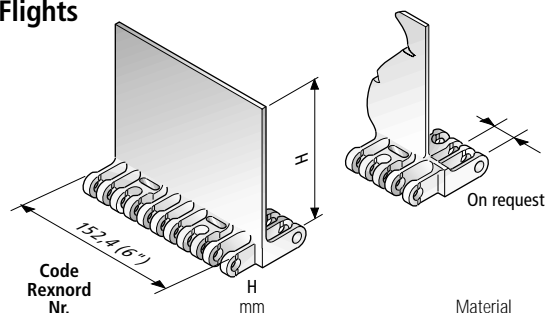
Standard materials	WHT	WLT
	Polypropylene	Polyethylene
Colour	White	White
Nominal strength * (N/m)	35000	23300
TEMPERATURE OF OPERATION (°C)		
in air	+ 5 to + 105	- 70 to + 25
in hot water	+ 105	-
Weight (Kg/m ²)	8,35	8,85
Pin material	WHT polypropylene (white)	

* = Values for a belt width of 1 m, at +20°C.

Pin retention : with plugs.

Available on request other materials and colours.

Flights



Code Rexnord Nr.	H mm	Material
WHT 5998 F4	102	WHT polypropylene (white)
WLT 5998 F4		WLT polyethylene (white)

On request other heights can be supplied.
Material characteristics : see page 12.1-13.1.

Transfer plates

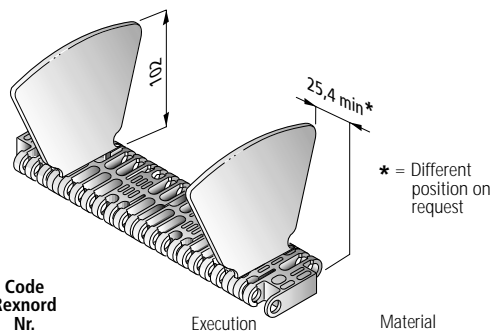


Code Rexnord Nr.	K mm	K inch	Material
Transfer plate K 06	152,4	6	LF acetal (white)
Transfer plate K 12	304,8	12	

Material characteristics / mounting instruction : see page 82.

CHAIN AND
ACCESSORIES

Side guards

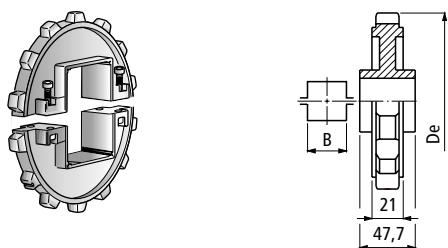


Code Rexnord Nr.	Execution	Material
Side guard WHT 5996 DX	Right	WHT polypropylene (white)
Side guard WHT 5996 SX	Left	
Side guard WLT 5996 DX	Right	WLT polyethylene (white)
Side guard WLT 5996 SX	Left	

Material characteristics : see page 12.1-13.1.

SPROCKETS for 5998

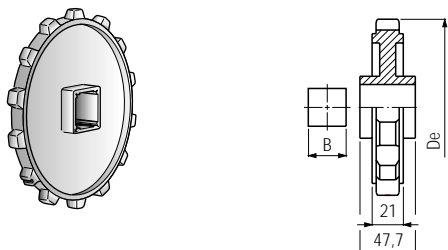
NS 5996 - split execution



Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp	Outside dia. De	Square bore B	Weight kg	
	actual	effective	mm	mm		
NS 5996 T14 S...HS	14	14	256,82	256,5	90x90-120x120	0,77

Material : reinforced polyamid (green), high temperature resistant.
Material characteristics / mounting instruction : see page 77-81

N 5996 - N 5996 High Temperature

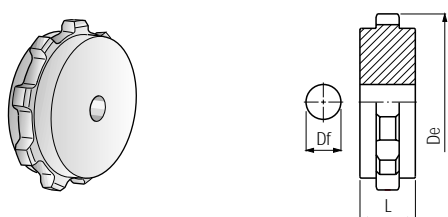


Code Rexnord Nr.	No. of teeth Z	Pitch dia. Dp mm	Outside dia. De mm	Square bore B mm	Weight kg	
N 5996 T07 S40	7	7	131,72	125,5	40x40	0,23
N 5996 T09 S...HS	9	9	167,08	164,1	40x40-50x50-65x65	0,40
N 5996 T14 S...HS	14	14	256,82	256,5	40x40-50x50-65x65-90x90	0,77

* High temperature resistance

Material : acetal, black (N 5996). Reinforced polyamid , green (N 5996 HS).
Material characteristics / mounting instruction : see page 77-81

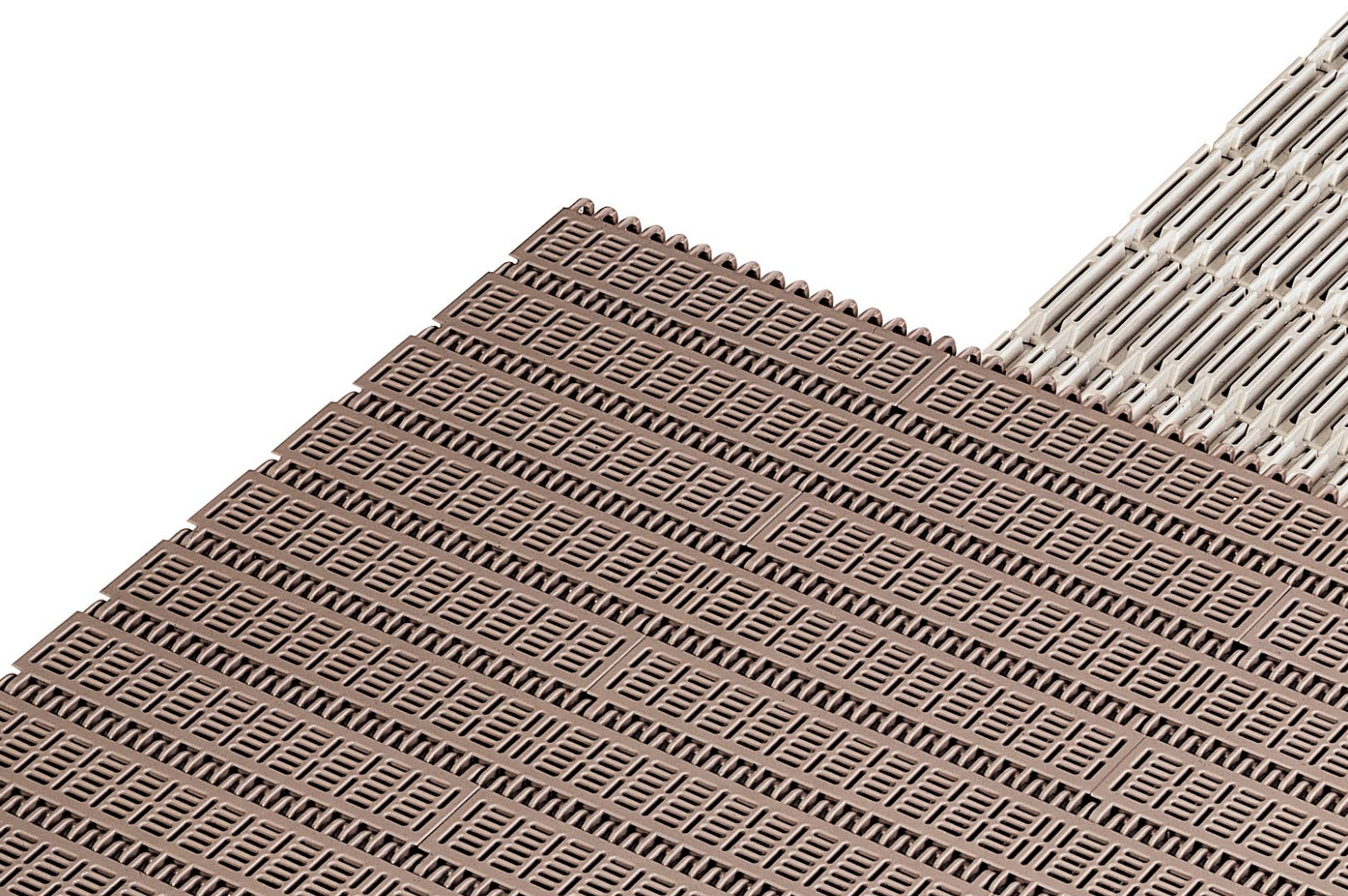
KU 5996



Code Rexnord Nr.		No. of teeth Z		Pitch dia. Dp mm	Outside dia. De mm	Bore dia. Df mm	L mm	Df max mm	Weight kg
		actual	effective						
KU 5996 T09 R20	9	9	167,08	164,1	20 H7	44,3	90	—	—
KU 5996 T14 R20	14	14	256,82	256,5	20 H7	47,7	120	—	—

Material : polyamid PA (black).
Material characteristics / mounting instruction : see page 77-81

Example of codenumber : N 5996 T09 S50x50 (including bore)





Mat Top[®]

CHAIN WIDTH

SERIES

1505 - 1506

NOMINAL
WIDTH
OF CHAINStandard widths
in **blue**Other widths
available **on
request**TOLERANCES
CHAIN WIDTHThe indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

Width nom. - mm	Code width	Width nom. - mm	Code width
76,2	K 03	1809,8	K 71,25
114,3	K 4,50	1828,8	K 72
133,4	K 5,25	1847,9	K 72,75
152,4	K 06	1866,9	K 73,50
171,5	K 6,75	1886,0	K 74,25
190,5	K 7,50	1905,0	K 75
209,6	K 8,25	1924,1	K 75,75
228,6	K 09	1943,1	K 76,50
247,7	K 9,75	1962,2	K 77,25
266,7	K 10,50	1981,2	K 78
285,8	K 11,25	2000,3	K 78,75
304,8	K 12	2019,3	K 79,50
323,9	K 12,75	2038,4	K 80,25
342,9	K 13,50	2057,4	K 81
362,0	K 14,25	2076,5	K 81,75
381,0	K 15	2095,5	K 82,50
400,1	K 15,75	2114,6	K 83,25
419,1	K 16,50	2133,6	K 84
438,2	K 17,25	2152,7	K 84,75
457,2	K 18	2171,7	K 85,50
476,3	K 18,75	2190,8	K 86,25
495,3	K 19,50	2209,8	K 87
514,4	K 20,25	2228,9	K 87,75
533,4	K 21	2247,9	K 88,50
552,5	K 21,75	2267,0	K 89,25
571,5	K 22,50	2286,0	K 90
590,6	K 23,25	2305,1	K 90,75
609,6	K 24	2324,1	K 91,50
628,7	K 24,75	2343,2	K 92,25
647,7	K 25,50	2362,2	K 93
666,8	K 26,25	2381,3	K 93,75
685,8	K 27	2400,3	K 94,50
704,9	K 27,75	2419,4	K 95,25
723,9	K 28,50	2438,4	K 96
743,0	K 29,25		
762,0	K 30		
781,1	K 30,75		
800,1	K 31,50		
819,2	K 32,25		
838,2	K 33		
857,3	K 33,75		
876,3	K 34,50		
895,4	K 35,25		
914,4	K 36		
933,5	K 36,75		
952,5	K 37,50		
971,6	K 38,25		
990,6	K 39		
1009,7	K 39,75		
1028,7	K 40,50		
1047,8	K 41,25		
1066,8	K 42		
1085,9	K 42,75		
1104,9	K 43,50		
1124,0	K 44,25		
1143,0	K 45		
1162,1	K 45,75		
1181,1	K 46,50		
1200,2	K 47,25		
1219,2	K 48		
1238,3	K 48,75		
1257,3	K 49,50		
1276,4	K 50,25		
1295,4	K 51		
1314,5	K 51,75		
1333,5	K 52,50		
1352,6	K 53,25		
1371,6	K 54		
1390,7	K 54,75		
1409,7	K 55,50		
1428,8	K 56,25		
1447,8	K 57		
1466,9	K 57,75		
1485,9	K 58,50		
1505,0	K 59,25		
1524,0	K 60		
1543,1	K 60,75		
1562,1	K 61,50		
1581,2	K 62,25		
1600,2	K 63		
1619,3	K 63,75		
1638,3	K 64,50		
1657,4	K 65,25		
1676,4	K 66		
1695,5	K 66,75		
1714,5	K 67,50		
1733,6	K 68,25		
1752,6	K 69		
1771,7	K 69,75		
1790,7	K 70,50		

1506 HP K06

Series |
Material
LF, HP, WHT |
Width code
(inch)

CHAINS

1505 - 1506
see page 20
2100
see page 32

SERIES

2100

Width nom. - mm	Code width	Width nom. - mm	Code width
76,2	K 03	2362,2	K 93
101,6	K 04	2387,6	K 94
127,0	K 05	2413,0	K 95
152,4	K 06	2438,4	K 96
177,8	K 07	2463,8	K 97
203,2	K 08	2489,2	K 98
228,6	K 09	2514,6	K 99
254,0	K 10	2540,0	K 100
279,4	K 11	2565,4	K 101
304,8	K 12	2590,8	K 102
330,2	K 13*	2616,2	K 103
355,6	K 14	2641,6	K 104
381,0	K 15	2667,0	K 105
406,4	K 16	2692,4	K 106
431,8	K 17	2717,8	K 107
457,2	K 18	2743,2	K 108
482,6	K 19	2768,6	K 109
508,0	K 20	2794,0	K 110
533,4	K 21	2819,4	K 111
558,8	K 22	2844,8	K 112
584,2	K 23	2870,2	K 113
609,6	K 24	2895,6	K 114
635,0	K 25	2921,0	K 115
660,4	K 26	2946,4	K 116
685,8	K 27	2971,8	K 117
711,2	K 28	2997,2	K 118
736,6	K 29	3022,6	K 119
762,0	K 30	3048,0	K 120
787,4	K 31	3073,4	K 121
812,8	K 32	3098,8	K 122
838,2	K 33	3124,2	K 123
863,6	K 34	3149,6	K 124
889,0	K 35	3175,0	K 125
914,4	K 36	3200,4	K 126
939,8	K 37	3225,8	K 127
965,2	K 38	3251,2	K 128
990,6	K 39	3276,6	K 129
1016,0	K 40	3302,0	K 130
1041,4	K 41	3327,4	K 131
1066,8	K 42	3352,8	K 132
1092,2	K 43	3378,2	K 133
1117,6	K 44	3403,6	K 134
1143,0	K 45	3429,0	K 135
1168,4	K 46	3454,4	K 136
1193,8	K 47	3479,8	K 137
1219,2	K 48	3505,2	K 138
1244,6	K 49	3530,6	K 139
1270,0	K 50	3556,0	K 140
1295,4	K 51	3581,4	K 141
1320,8	K 52	3606,8	K 142
1346,2	K 53	3632,2	K 143
1371,6	K 54	3657,6	K 144
1397,0	K 55	3683,0	K 145
1422,4	K 56	3708,4	K 146
1447,8	K 57	3733,8	K 147
1473,2	K 58	3759,2	K 148
1498,6	K 59	3784,6	K 149
1524,0	K 60	3810,0	K 150
1549,4	K 61	3835,4	K 151
1574,8	K 62	3860,8	K 152
1600,2	K 63	3886,2	K 153
1625,6	K 64	3911,6	K 154
1651,0	K 65	3937,0	K 155
1676,4	K 66	3962,4	K 156
1701,8	K 67	3987,8	K 157
1727,2	K 68	4013,2	K 158
1752,6	K 69	4038,6	K 159
1778,0	K 70	4064,0	K 160
1803,4	K 71	4089,4	K 161
1828,8	K 72	4114,8	K 162
1854,2	K 73	4140,2	K 163
1879,6	K 74	4165,6	K 164
1905,0	K 75	4191,0	K 165
1930,4	K 76	4216,4	K 166
1955,8	K 77	4241,8	K 167
1981,2	K 78	4267,2	K 168
2006,6	K 79	4292,6	K 169
2032,0	K 80	4318,0	K 170
2057,4	K 81	4343,4	K 171
2082,8	K 82	4368,8	K 172
2108,2	K 83	4394,2	K 173
2133,6	K 84	4419,6	K 174
2159,0	K 85	4445,0	K 175
2184,4	K 86	4470,4	K 176
2209,8	K 87	4495,8	K 177
2235,2	K 88		
2260,6	K 89		
2286,0	K 90		
2311,4	K 91		
2336,8	K 92		

* = K13 standard
width only
for LF

SERIES

4705 - 4706 - 4707 - 4705 vacuum

Width nom. - mm	Code width	Width nom. - mm	Code width
76,2	K 03	2362,2	K 93
101,6	K 04	2387,6	K 94
127,0	K 05	2413,0	K 95
152,4	K 06	2438,4	K 96
177,8	K 07	2463,8	K 97
203,2	K 08	2489,2	K 98
228,6	K 09	2514,6	K 99
254,0	K 10	2540,0	K 100
279,4	K 11	2565,4	K 101
304,8	K 12	2590,8	K 102
330,2	K 13	2616,2	K 103
355,6	K 14	2641,6	K 104
381,0	K 15	2667,0	K 105
406,4	K 16	2692,4	K 106
431,8	K 17	2717,8	K 107
457,2	K 18	2743,2	K 108
482,6	K 19	2768,6	K 109
508,0	K 20	2794,0	K 110
533,4	K 21	2819,4	K 111
558,8	K 22	2844,8	K 112
584,2	K 23	2870,2	K 113
609,6	K 24	2895,6	K 114
635,0	K 25	2921,0	K 115
660,4	K 26	2946,4	K 116
685,8	K 27	2971,8	K 117
711,2	K 28	2997,2	K 118
736,6	K 29	3022,6	K 119
762,0	K 30	3048,0	K 120
787,4	K 31	3073,4	K 121
812,8	K 32	3098,8	K 122
838,2	K 33	3124,2	K 123
863,6	K 34	3149,6	K 124
889,0	K 35	3175,0	K 125
914,4	K 36	3200,4	K 126
939,8	K 37	3225,8	K 127
965,2	K 38	3251,2	K 128
990,6	K 39	3276,6	K 129
1016,0	K 40	3302,0	K 130
1041,4	K 41	3327,4	K 131
1066,8	K 42	3352,8	K 132
1092,2	K 43	3378,2	K 133
1117,6	K 44	3403,6	K 134
1143,0	K 45	3429,0	K 135
1168,4	K 46	3454,4	K 136
1193,8	K 47	3479,8	K 137
1219,2	K 48	3505,2	K 138
1244,6	K 49	3530,6	K 139
1270,0	K 50	3556,0	K 140
1295,4	K 51	3581,4	K 141
1320,8	K 52	3606,8	K 142
1346,2	K 53	3632,2	K 143
1371,6	K 54	3657,6	K 144
1397,0	K 55	3683,0	K 145
1422,4	K 56	3708,4	K 146
1447,8	K 57	3733,8	K 147
1473,2	K 58	3759,2	K 148
1498,6	K 59	3784,6	K 149
1524,0	K 60	3810,0	K 150
1549,4	K 61	3835,4	K 151
1574,8	K 62	3860,8	K 152
1600,2	K 63	3886,2	K 153
1625,6	K 64	3911,6	K 154
1651,0	K 65	3937,0	K 155
1676,4	K 66	3962,4	K 156
1701,8	K 67	3987,8	K 157
1727,2	K 68	4013,2	K 158
1752,6	K 69	4038,6	K 159
1778,0	K 70	4064,0	K 160
1803,4	K 71	4089,4	K 161
1828,8	K 72	4114,8	K 162
1854,2	K 73	4140,2	K 163
1879,6	K 74	4165,6	K 164
1905,0	K 75	4191,0	K 165
1930,4	K 76	4216,4	K 166
1955,8	K 77	4241,8	K 167
1981,2	K 78	4267,2	K 168
2006,6	K 79	4292,6	K 169
2032,0	K 80	4318,0	K 170
2057,4	K 81	4343,4	K 171
2082,8	K 82	4368,8	K 172
2108,2	K 83	4394,2	K 173
2133,6	K 84	4419,6	K 174
2159,0	K 85	4445,0	K 175
2184,4	K 86	4470,4	K 176
2209,8	K 87	4495,8	K 177
2235,2	K 88		
2260,6	K 89		
2286,0	K 90		
2311,4	K 91		
2336,8	K 92		

**NOMINAL
WIDTH
OF CHAIN**Standard widths
in **blue**Other widths
available **on
request****TOLERANCES
CHAIN WIDTH**The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department**EXAMPLE OF
CODENUMBER****4706 LF K06**

Series	Material	Width code
4706	LF	K06
		(inch)

CHAINS4705-4706-4707
see page 34

SERIES

4812

NOMINAL
WIDTH
OF CHAINStandard widths
in **blue**Other widths
available **on
request**TOLERANCES
CHAIN WIDTH

The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width
10,9	K 0,43	262,9	K 10,35	849,6	K 33,45	1503,4	K 59,19	2155,7	K 84,87	2808,2	K 110,56		
15,5	K 0,61	268,0	K 10,55	855,7	K 33,69	1508,3	K 59,38	2165,4	K 85,25	2819,4	K 111		
17,3	K 0,68	269,7	K 10,62	865,1	K 34,06	1517,7	K 59,75	2170,2	K 85,44	2822,4	K 111,12		
20,3	K 0,80	272,5	K 10,73	870,0	K 34,25	1524,0	K 60	2179,6	K 85,81	2830,8	K 111,45		
22,1	K 0,87	274,6	K 10,81	880,4	K 34,66	1531,9	K 60,31	2184,4	K 86,00	2836,9	K 111,69		
25,4	K 1	277,6	K 10,93	883,9	K 34,80	1541,3	K 60,68	2193,8	K 86,37	2846,3	K 112,06		
29,7	K 1,17	281,9	K 11,10	893,8	K 35,19	1546,1	K 60,87	2198,6	K 86,56	2851,2	K 112,25		
31,5	K 1,24	284,0	K 11,18	898,7	K 35,38	1555,8	K 61,25	2209,8	K 87	2861,6	K 112,66		
34,5	K 1,36	287,0	K 11,30	908,1	K 35,75	1560,6	K 61,44	2212,8	K 87,12	2865,1	K 112,80		
36,3	K 1,43	289,1	K 11,38	914,4	K 36	1570,0	K 61,81	2221,2	K 87,45	2875,0	K 113,19		
39,4	K 1,55	292,1	K 11,50	922,3	K 36,31	1574,8	K 62	2227,3	K 87,69	2879,9	K 113,38		
44,2	K 1,74	296,4	K 11,67	931,7	K 36,68	1584,2	K 62,37	2236,7	K 88,06	2889,3	K 113,75		
45,7	K 1,80	298,5	K 11,75	936,5	K 36,87	1589,0	K 62,56	2241,6	K 88,25	2895,6	K 114		
49,0	K 1,93	301,0	K 11,85	946,2	K 37,25	1600,2	K 63	2252,0	K 88,66	2903,5	K 114,31		
50,5	K 1,99	303,0	K 11,93	951,0	K 37,44	1603,2	K 63,12	2255,5	K 88,80	2912,9	K 114,68		
53,3	K 2,10	304,8	K 12	960,4	K 37,81	1611,6	K 63,45	2265,4	K 89,19	2917,7	K 114,87		
58,4	K 2,30	312,7	K 12,31	965,2	K 38	1617,7	K 63,69	2270,3	K 89,38	2927,4	K 115,25		
59,9	K 2,36	322,1	K 12,68	974,6	K 38,37	1627,1	K 64,06	2279,7	K 89,75	2932,2	K 115,44		
63,5	K 2,50	326,9	K 12,87	979,4	K 38,56	1632,0	K 64,25	2286,0	K 90	2941,6	K 115,81		
65,0	K 2,56	336,6	K 13,25	990,6	K 39	1642,4	K 64,66	2293,9	K 90,31	2946,4	K 116		
68,1	K 2,68	341,4	K 13,44	993,6	K 39,12	1645,9	K 64,80	2303,3	K 90,68	2955,8	K 116,37		
72,9	K 2,87	350,8	K 13,81	1002,0	K 39,45	1655,8	K 65,19	2308,1	K 90,87	2960,6	K 116,56		
74,4	K 2,93	355,6	K 14	1008,1	K 39,69	1660,7	K 65,38	2317,8	K 91,25	2971,8	K 117		
76,2	K 3	365,0	K 14,37	1017,5	K 40,06	1670,1	K 65,75	2322,6	K 91,44	2974,8	K 117,12		
79,5	K 3,13	369,8	K 14,56	1022,4	K 40,25	1676,4	K 66	2332,0	K 91,81	2983,2	K 117,45		
82,3	K 3,24	381,0	K 15	1032,8	K 40,66	1684,3	K 66,31	2336,8	K 92	2989,3	K 117,69		
87,1	K 3,43	384,0	K 15,12	1036,3	K 40,80	1693,7	K 66,68	2346,2	K 92,37	2998,7	K 118,06		
88,6	K 3,49	392,4	K 15,45	1046,2	K 41,19	1698,5	K 66,87	2351,0	K 92,56	3003,6	K 118,25		
91,7	K 3,61	398,5	K 15,69	1051,1	K 41,38	1708,2	K 67,25	2362,2	K 93	3014,0	K 118,66		
93,5	K 3,68	407,9	K 16,06	1060,5	K 41,75	1713,0	K 67,44	2365,2	K 93,12	3017,5	K 118,80		
96,8	K 3,81	412,8	K 16,25	1066,8	K 42	1722,4	K 67,81	2373,6	K 93,45	3027,4	K 119,19		
101,3	K 3,99	423,2	K 16,66	1074,7	K 42,31	1727,2	K 68	2379,7	K 93,69	3032,3	K 119,38		
103,1	K 4,06	426,7	K 16,80	1084,1	K 42,68	1736,6	K 68,37	2389,1	K 94,06	3041,7	K 119,75		
106,2	K 4,18	436,6	K 17,19	1088,9	K 42,87	1741,4	K 68,56	2394,0	K 94,25	3048,0	K 120		
107,7	K 4,24	441,5	K 17,38	1098,6	K 43,25	1752,6	K 69	2404,4	K 94,66				
111,0	K 4,37	450,9	K 17,75	1103,4	K 43,44	1755,6	K 69,12	2407,9	K 94,80				
115,8	K 4,56	457,2	K 18	1112,8	K 43,81	1764,0	K 69,45	2417,8	K 95,19				
117,3	K 4,62	465,1	K 18,31	1117,6	K 44	1770,1	K 69,69	2422,7	K 95,38				
120,4	K 4,74	474,5	K 18,68	1127,0	K 44,37	1779,5	K 70,06	2432,1	K 95,75				
121,9	K 4,80	479,3	K 18,87	1131,8	K 44,56	1784,4	K 70,25	2438,4	K 96				
125,5	K 4,94	489,0	K 19,25	1143,0	K 45	1794,8	K 70,66	2446,3	K 96,31				
130,0	K 5,12	493,8	K 19,44	1146,0	K 45,12	1798,3	K 70,80	2455,7	K 96,68				
131,6	K 5,18	503,2	K 19,81	1154,4	K 45,45	1808,2	K 71,19	2460,5	K 96,87				
134,9	K 5,31	508,0	K 20	1160,5	K 45,69	1813,1	K 71,38	2470,2	K 97,25				
136,7	K 5,38	517,4	K 20,37	1169,9	K 46,06	1822,5	K 71,75	2475,0	K 97,44				
139,7	K 5,50	522,2	K 20,56	1174,8	K 46,25	1828,8	K 72	2484,4	K 97,81				
144,3	K 5,68	533,4	K 21	1185,2	K 46,66	1836,7	K 72,31	2489,2	K 98				
146,1	K 5,75	536,4	K 21,12	1188,7	K 46,80	1846,1	K 72,68	2498,6	K 98,37				
149,1	K 5,87	544,8	K 21,45	1198,6	K 47,19	1850,9	K 72,87	2503,4	K 98,56				
150,6	K 5,93	550,9	K 21,69	1203,5	K 47,38	1860,6	K 73,25	2514,6	K 99				
152,4	K 6	560,3	K 22,06	1212,9	K 47,75	1865,4	K 73,44	2517,6	K 99,12				
153,9	K 6,06	565,2	K 22,25	1219,2	K 48	1874,8	K 73,81	2526,0	K 99,45				
155,7	K 6,13	575,6	K 22,66	1227,1	K 48,31	1879,6	K 74	2532,1	K 99,69				
158,5	K 6,24	579,1	K 22,80	1236,5	K 48,68	1889,0	K 74,37	2541,5	K 100,06				
160,3	K 6,31	589,0	K 23,19	1241,3	K 48,87	1893,8	K 74,56	2546,4	K 100,25				
163,6	K 6,44	593,9	K 23,38	1251,0	K 49,25	1905,0	K 75	2556,8	K 100,66				
167,9	K 6,61	603,3	K 23,75	1255,8	K 49,44	1908,0	K 75,12	2560,3	K 100,80				
169,7	K 6,68	609,6	K 24	1265,2	K 49,81	1916,4	K 75,45	2570,2	K 101,19				
172,5	K 6,79	617,5	K 24,31	1270,0	K 50	1922,5	K 75,69	2575,1	K 101,38				
174,5	K 6,87	626,9	K 24,68	1279,4	K 50,37	1931,9	K 76,06	2584,5	K 101,75				
177,5	K 6,99	631,7	K 24,87	1284,2	K 50,56	1936,8	K 76,25	2590,8	K 102				
182,1	K 7,17	641,4	K 25,25	1295,4	K 51	1947,2	K 76,66	2598,7	K 102,31				
183,9	K 7,24	646,2	K 25,44	1298,4	K 51,12	1950,7	K 76,80	2608,1	K 102,68				
186,9	K 7,36	655,6	K 25,81	1306,8	K 51,45	1960,6	K 77,19	2612,9	K 102,87				
189,0	K 7,44	660,4	K 26	1312,9	K 51,69	1965,5	K 77,38	2622,6	K 103,25				
192,0	K 7,56	669,8	K 26,37	1322,3	K 52,06	1974,9	K 77,75	2627,4	K 103,44				
196,6	K 7,74	674,6	K 26,56	1327,2	K 52,25	1981,2	K 78	2636,8	K 103,81				
198,1	K 7,80	685,8	K 27	1337,6	K 52,66	1989,1	K 78,31	2641,6	K 104				
200,9	K 7,91	688,8	K 27,12	1341,1	K 52,80	1998,5	K 78,68	2651,0	K 104,37				
202,9	K 7,99	697,2	K 27,45	1351,0	K 53,19	2003,3	K 78,87	2655,8	K 104,56				
206,0	K 8,11	703,3	K 27,69	1355,9	K 53,38	2013,0	K 79,25	2667,0	K 105				
210,6	K 8,29	712,7	K 28,06	1365,3	K 53,75	2017,8	K 79,44	2670,0	K 105,12				
212,3	K 8,36	717,6	K 28,25	1371,6	K 54	2027,2	K 79,81	2678,4	K 105,45				
215,4	K 8,48	728,0	K 28,66	1379,5	K 54,31	2032,0	K 80	2684,5	K 105,69				
218,4	K 8,60	731,5	K 28,80	1388,9	K 54,68	2041,4	K 80,37	2693,9	K 106,06				
220,5	K 8,68	741,4	K 29,19	1393,7	K 54,87	2046,2	K 80,56	2698,8	K 106,25				
225,0	K 8,86	746,3	K 29,38	1403,4	K 55,25	2057,4	K 81	2709,2	K 106,66				
226,8	K 8,93	755,7	K 29,75	1408,2	K 55,44	2060,4	K 81,12	2712,7	K 106,80				
228,6	K 9	762,0	K 30	1417,6	K 55,81	2068,8	K 81,45	2722,6	K 107,19				
231,9	K 9,13	769,9	K 30,31	1422,4	K 56	2074,9	K 81,69	2727,5	K 107,38				
234,4	K 9,23	779,3	K 30,68	1431,8	K 56,37	2084,3	K 82,06	2736,9	K 107,75				
239,5	K 9,43	784,1	K 30,87	1436,6	K 56,56	2089,2	K 82,25	2743,2	K 108				
241,3	K 9,50	793,8	K 31,25	1447,8	K 57	2099,6	K 82,66	2751,1	K 108,31				
244,1	K 9,61	798,6	K 31,44	1450,8	K 57,12	2103,1	K 82,80	2760,5	K 108,68				
247,7	K 9,75	808,0	K 31,81	1459,2	K 57,45	2113,0	K 83,19	2765,3	K 108,87				
248,9	K 9,80	812,8	K 32	1465,3	K 57,69	2117,9	K 83,38	2775,0	K 109,25				
253,5	K 9,98	822,2	K 32,37	1474,7	K 58,06	2127,3	K 83,75	2779,8	K 109,44				
254,0	K 10	827,0	K 32,56	1479,6	K 58,25	2133,6	K 84	2789,2	K 109,81				
258,1	K 10,16	838,2	K 33	1490,0	K 58,66	2141,5	K 84,31	2794,0	K 110				
260,1	K 10,24	841,2	K 33,12	1493,5	K 58,80	2150,9	K 84,68	2803,4	K 110,37				

EXAMPLE OF
COD

SERIES

4803

Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width
20,8	K 0,82	474,0	K 18,66	998,2	K 39,30	1531,6	K 60,30	2057,4	K 81	2583,7	K 101,72
25,4	K 1	478,8	K 18,85	1001,8	K 39,44	1535,2	K 60,44	2060,2	K 81,11	2590,8	K 102
29,7	K 1,17	483,6	K 19,04	1007,4	K 39,66	1540,8	K 60,66	2065,0	K 81,30	2598,4	K 102,30
34,0	K 1,34	503,2	K 19,81	1012,2	K 39,85	1545,6	K 60,85	2068,6	K 81,44	2602,0	K 102,44
39,4	K 1,55	508,0	K 20	1017,0	K 40,04	1550,4	K 61,04	2074,2	K 81,66	2607,6	K 102,66
44,2	K 1,74	512,1	K 20,16	1022,1	K 40,24	1570,0	K 61,81	2079,0	K 81,85	2612,4	K 102,85
48,8	K 1,92	516,9	K 20,35	1041,4	K 41	1574,8	K 62	2083,8	K 82,04	2617,2	K 103,04
53,6	K 2,11	522,7	K 20,58	1045,5	K 41,16	1578,9	K 62,16	2088,9	K 82,24	2636,8	K 103,81
58,4	K 2,30	526,3	K 20,72	1050,3	K 41,35	1583,7	K 62,35	2108,2	K 83	2641,6	K 104
59,9	K 2,36	531,4	K 20,92	1056,1	K 41,58	1589,5	K 62,58	2112,3	K 83,16	2645,7	K 104,16
64,8	K 2,55	533,4	K 21	1059,7	K 41,72	1593,1	K 62,72	2117,1	K 83,35	2650,5	K 104,35
69,6	K 2,74	536,2	K 21,11	1066,8	K 42	1598,2	K 62,92	2122,9	K 83,58	2656,3	K 104,58
74,2	K 2,92	541,0	K 21,30	1074,4	K 42,30	1600,2	K 63	2126,5	K 83,72	2659,9	K 104,72
76,2	K 3	544,6	K 21,44	1078,0	K 42,44	1603,0	K 63,11	2133,6	K 84	2665,0	K 104,92
79,0	K 3,11	550,2	K 21,66	1083,6	K 42,66	1607,8	K 63,30	2141,2	K 84,30	2667,0	K 105
83,8	K 3,30	555,0	K 21,85	1088,4	K 42,85	1611,4	K 63,44	2144,8	K 84,44	2669,8	K 105,11
88,4	K 3,48	559,8	K 22,04	1093,2	K 43,04	1617,0	K 63,66	2150,4	K 84,66	2674,6	K 105,30
93,2	K 3,67	564,9	K 22,24	1112,8	K 43,81	1621,8	K 63,85	2155,2	K 84,85	2678,2	K 105,44
97,8	K 3,85	584,2	K 23	1117,6	K 44	1626,6	K 64,04	2160,0	K 85,04	2683,8	K 105,66
101,6	K 4	588,3	K 23,16	1121,7	K 44,16	1631,7	K 64,24	2179,6	K 85,81	2688,6	K 105,85
105,9	K 4,17	593,1	K 23,35	1126,5	K 44,35	1651,0	K 65	2184,4	K 86	2693,4	K 106,04
110,5	K 4,35	598,9	K 23,58	1132,3	K 44,58	1655,1	K 65,16	2188,5	K 86,16	2698,5	K 106,24
115,3	K 4,54	602,5	K 23,72	1135,9	K 44,72	1659,9	K 65,35	2193,3	K 86,35	2717,8	K 107
119,9	K 4,72	609,6	K 24	1141,0	K 44,92	1665,7	K 65,58	2199,1	K 86,58	2721,9	K 107,16
124,7	K 4,91	617,2	K 24,30	1143,0	K 45	1669,3	K 65,72	2202,7	K 86,72	2726,7	K 107,35
129,5	K 5,10	620,8	K 24,44	1145,8	K 45,11	1676,4	K 66	2207,8	K 86,92	2732,5	K 107,58
134,4	K 5,29	626,4	K 24,66	1150,6	K 45,30	1684,0	K 66,30	2209,8	K 87	2736,1	K 107,72
138,9	K 5,47	631,2	K 24,85	1154,2	K 45,44	1687,6	K 66,44	2212,6	K 87,11	2743,2	K 108
145,3	K 5,72	636,0	K 25,04	1159,8	K 45,66	1693,2	K 66,66	2217,4	K 87,30	2750,8	K 108,30
152,4	K 6	655,6	K 25,81	1164,6	K 45,85	1698,0	K 66,85	2221,0	K 87,44	2754,4	K 108,44
153,4	K 6,04	660,4	K 26	1169,4	K 46,04	1702,8	K 67,04	2226,6	K 87,66	2760,0	K 108,66
158,5	K 6,24	664,5	K 26,16	1174,5	K 46,24	1722,4	K 67,81	2231,4	K 87,85	2764,8	K 108,85
163,1	K 6,42	669,3	K 26,35	1193,8	K 47	1727,2	K 68	2236,2	K 88,04	2769,6	K 109,04
167,4	K 6,59	675,1	K 26,58	1197,9	K 47,16	1731,3	K 68,16	2241,3	K 88,24	2789,2	K 109,81
172,0	K 6,77	678,7	K 26,72	1202,7	K 47,35	1736,1	K 68,35	2260,6	K 89	2794,0	K 110
177,0	K 6,97	683,8	K 26,92	1208,5	K 47,58	1741,9	K 68,58	2264,7	K 89,16	2798,1	K 110,16
182,1	K 7,17	685,8	K 27	1212,1	K 47,72	1745,5	K 68,72	2269,5	K 89,35	2802,9	K 110,35
186,9	K 7,36	688,6	K 27,11	1219,2	K 48	1750,6	K 68,92	2275,3	K 89,58	2808,7	K 110,58
192,0	K 7,56	693,4	K 27,30	1226,8	K 48,30	1752,6	K 69	2278,9	K 89,72	2812,3	K 110,72
198,1	K 7,80	697,0	K 27,44	1230,4	K 48,44	1755,4	K 69,11	2286,0	K 90	2817,4	K 110,92
200,9	K 7,91	702,6	K 27,66	1236,0	K 48,66	1760,2	K 69,30	2293,6	K 90,30	2819,4	K 111
206,0	K 8,11	707,4	K 27,85	1240,8	K 48,85	1763,8	K 69,44	2297,2	K 90,44	2822,2	K 111,11
210,6	K 8,29	712,2	K 28,04	1245,6	K 49,04	1769,4	K 69,66	2302,8	K 90,66	2827,0	K 111,30
215,4	K 8,48	717,3	K 28,24	1265,2	K 49,81	1774,2	K 69,85	2307,6	K 90,85	2830,6	K 111,44
221,0	K 8,70	736,6	K 29	1270,0	K 50	1779,0	K 70,04	2312,4	K 91,04	2836,2	K 111,66
226,1	K 8,90	740,7	K 29,16	1274,1	K 50,16	1784,1	K 70,24	2332,0	K 91,81	2841,0	K 111,85
230,4	K 9,07	745,5	K 29,35	1278,9	K 50,35	1803,4	K 71	2336,8	K 92	2845,8	K 112,04
235,0	K 9,25	751,3	K 29,58	1284,7	K 50,58	1807,5	K 71,16	2340,9	K 92,16	2850,9	K 112,24
239,8	K 9,44	754,9	K 29,72	1288,3	K 50,72	1812,3	K 71,35	2345,7	K 92,35	2870,2	K 113
245,1	K 9,65	762,0	K 30	1293,4	K 50,92	1818,1	K 71,58	2351,5	K 92,58	2874,3	K 113,16
249,4	K 9,82	769,6	K 30,30	1295,4	K 51	1821,7	K 71,72	2355,1	K 92,72	2879,1	K 113,35
254,0	K 10	773,2	K 30,44	1298,2	K 51,11	1828,8	K 72	2360,2	K 92,92	2884,9	K 113,58
258,1	K 10,16	778,8	K 30,66	1303,0	K 51,30	1836,4	K 72,30	2362,2	K 93	2888,5	K 113,72
262,9	K 10,35	783,6	K 30,85	1306,6	K 51,44	1840,0	K 72,44	2365,0	K 93,11	2895,6	K 114
268,0	K 10,55	788,4	K 31,04	1312,2	K 51,66	1845,6	K 72,66	2369,8	K 93,30	2903,2	K 114,30
272,0	K 10,71	808,0	K 31,81	1317,0	K 51,85	1850,4	K 72,85	2373,4	K 93,44	2906,8	K 114,44
277,1	K 10,91	812,8	K 32	1321,8	K 52,04	1855,2	K 73,04	2379,0	K 93,66	2912,4	K 114,66
281,9	K 11,10	816,9	K 32,16	1326,9	K 52,24	1874,8	K 73,81	2383,8	K 93,85	2917,2	K 114,85
286,5	K 11,28	821,7	K 32,35	1346,2	K 53	1879,6	K 74	2388,6	K 94,04	2922,0	K 115,04
291,6	K 11,48	827,5	K 32,58	1350,3	K 53,16	1883,7	K 74,16	2393,7	K 94,24	2941,6	K 115,81
296,9	K 11,69	831,1	K 32,72	1355,1	K 53,35	1888,5	K 74,35	2413,0	K 95	2946,4	K 116
304,8	K 12	836,2	K 32,92	1360,9	K 53,58	1894,3	K 74,58	2417,1	K 95,16	2950,5	K 116,16
312,4	K 12,30	838,2	K 33	1364,5	K 53,72	1897,9	K 74,72	2421,9	K 95,35	2955,3	K 116,35
316,0	K 12,44	841,0	K 33,11	1371,6	K 54	1903,0	K 74,92	2427,7	K 95,58	2961,1	K 116,58
321,6	K 12,66	845,8	K 33,30	1379,2	K 54,30	1905,0	K 75	2431,3	K 95,72	2964,7	K 116,72
326,4	K 12,85	849,4	K 33,44	1382,8	K 54,44	1907,8	K 75,11	2438,4	K 96	2969,8	K 116,92
331,2	K 13,04	855,0	K 33,66	1388,4	K 54,66	1912,6	K 75,30	2446,0	K 96,30	2971,8	K 117
350,8	K 13,81	859,8	K 33,85	1393,2	K 54,85	1916,2	K 75,44	2449,6	K 96,44	2974,6	K 117,11
355,6	K 14	864,6	K 34,04	1398,0	K 55,04	1921,8	K 75,66	2455,2	K 96,66	2979,4	K 117,30
359,7	K 14,16	869,7	K 34,24	1417,6	K 55,81	1926,6	K 75,85	2460,0	K 96,85	2983,0	K 117,44
364,5	K 14,35	889,0	K 35	1422,4	K 56	1931,4	K 76,04	2464,8	K 97,04	2988,6	K 117,66
370,3	K 14,58	893,1	K 35,16	1426,5	K 56,16	1936,5	K 76,24	2484,4	K 97,81	2993,4	K 117,85
373,9	K 14,72	897,9	K 35,35	1431,3	K 56,35	1955,8	K 77	2489,2	K 98	2998,2	K 118,04
379,0	K 14,92	903,7	K 35,58	1437,1	K 56,58	1959,9	K 77,16	2493,3	K 98,16	3003,3	K 118,24
381,0	K 15	907,3	K 35,72	1440,7	K 56,72	1964,7	K 77,35	2498,1	K 98,35	3022,6	K 119
383,8	K 15,11	914,4	K 36	1445,8	K 56,92	1970,5	K 77,58	2503,9	K 98,58	3026,7	K 119,16
388,6	K 15,30	922,0	K 36,30	1447,8	K 57	1974,1	K 77,72	2507,5	K 98,72	3031,5	K 119,35
392,2	K 15,44	925,6	K 36,44	1450,6	K 57,11	1981,2	K 78	2512,6	K 98,92	3037,3	K 119,58
397,8	K 15,66	931,2	K 36,66	1455,4	K 57,30	1988,8	K 78,30	2514,6	K 99	3040,9	K 119,72
402,6	K 15,85	936,0	K 36,85	1459,0	K 57,44	1992,4	K 78,44	2517,4	K 99,11	3048,0	K 120
407,4	K 16,04	940,8	K 37,04	1464,6	K 57,66	1998,0	K 78,66	2522,2	K 99,30		
412,5	K 16,24	960,4	K 37,81	1469,4	K 57,85	2002,8	K 78,85	2525,8	K 99,44		
431,8	K 17	965,2	K 38	1474,2	K 58,04	2007,6	K 79,04	2531,4	K 99,66		
435,9	K 17,16	969,3	K 38,16	1479,3	K 58,24	2027,2	K 79,81	2536,2	K 99,85		
440,7	K 17,35	974,1	K 38,35	1498,6	K 59	2032,0	K 80	2541,0	K 100,04		
446,5	K 17,58	979,9	K 38,58	1502,7	K 59,16	2036,1	K 80,16	2546,1	K 100,24		
450,1	K 17,72	983,5	K 38,72	1507,5	K 59,35	2040,9	K 80,35	2565,4	K 101		
457,2	K 18	988,6	K 38,92	1513,3	K 59,58	2046,7	K 80,58	2569,5	K 101,16		
464,8	K 18,30	990,6	K 39	1516,9	K 59,72	2050,3	K 80,72	2574,3	K 101,35		
468,4	K 18,44	993,4	K 39,11	1524,0	K 60	2055,4	K 80,92	2580,1	K 101,58		

NOMINAL
WIDTH
OF CHAINStandard widths
in **blue**Other widths
available **on**
requestTOLERANCES
CHAIN WIDTHThe indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
DepartmentEXAMPLE OF
CODENUMBER

4803 LF K06

Series | Material | Width code
LF, HT (inch

SERIES

4809

NOMINAL
WIDTH
OF CHAIN

Standard widths
in **blue**

Other widths
available **on
request**

TOLERANCES
CHAIN WIDTH

The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width
24,1	K 0,95	584,2	K 23	1233,7	K 48,57	1892,3	K 74,50	2534,7	K 99,79
29,0	K 1,14	590,8	K 23,26	1239,3	K 48,79	1897,4	K 74,70	2540,0	K 100
34,0	K 1,34	596,9	K 23,50	1244,6	K 49	1905,0	K 75	2545,3	K 100,21
39,4	K 1,55	602,0	K 23,70	1266,7	K 49,87	1908,3	K 75,13	2565,4	K 101
44,7	K 1,76	609,6	K 24	1270,0	K 50	1913,6	K 75,34	2572,0	K 101,26
50,3	K 1,98	618,2	K 24,34	1276,6	K 50,26	1919,5	K 75,57	2578,1	K 101,50
55,6	K 2,19	624,1	K 24,57	1282,7	K 50,50	1925,1	K 75,79	2583,2	K 101,70
61,0	K 2,40	629,7	K 24,79	1287,8	K 50,70	1930,4	K 76	2590,8	K 102
68,6	K 2,70	635,0	K 25	1295,4	K 51	1935,7	K 76,21	2599,4	K 102,34
73,9	K 2,91	657,1	K 25,87	1298,7	K 51,13	1955,8	K 77	2605,3	K 102,57
79,5	K 3,13	660,4	K 26	1304,0	K 51,34	1962,4	K 77,26	2610,9	K 102,79
85,1	K 3,35	667,0	K 26,26	1309,9	K 51,57	1968,5	K 77,50	2616,2	K 103
90,4	K 3,56	673,1	K 26,50	1315,5	K 51,79	1973,6	K 77,70	2638,3	K 103,87
95,8	K 3,77	678,2	K 26,70	1320,8	K 52	1981,2	K 78	2641,6	K 104
101,6	K 4	685,8	K 27	1326,1	K 52,21	1989,8	K 78,34	2648,2	K 104,26
105,4	K 4,15	689,1	K 27,13	1346,2	K 53	1995,7	K 78,57	2654,3	K 104,50
110,5	K 4,35	694,4	K 27,34	1352,8	K 53,26	2001,3	K 78,79	2659,4	K 104,70
115,6	K 4,55	700,3	K 27,57	1358,9	K 53,50	2006,6	K 79	2667,0	K 105
120,9	K 4,76	705,9	K 27,79	1364,0	K 53,70	2028,7	K 79,87	2670,3	K 105,13
126,2	K 4,97	711,2	K 28	1371,6	K 54	2032,0	K 80	2675,6	K 105,34
131,8	K 5,19	716,5	K 28,21	1380,2	K 54,34	2038,6	K 80,26	2681,5	K 105,57
137,2	K 5,40	736,6	K 29	1386,1	K 54,57	2044,7	K 80,50	2687,1	K 105,79
142,7	K 5,62	743,2	K 29,26	1391,7	K 54,79	2049,8	K 80,70	2692,4	K 106
148,1	K 5,83	749,3	K 29,50	1397,0	K 55	2057,4	K 81	2697,7	K 106,21
152,4	K 6	754,4	K 29,70	1419,1	K 55,87	2060,7	K 81,13	2717,8	K 107
153,4	K 6,04	762,0	K 30	1422,4	K 56	2066,0	K 81,34	2724,4	K 107,26
159,0	K 6,26	770,6	K 30,34	1429,0	K 56,26	2071,9	K 81,57	2730,5	K 107,50
165,1	K 6,50	776,5	K 30,57	1435,1	K 56,50	2077,5	K 81,79	2735,6	K 107,70
169,9	K 6,69	782,1	K 30,79	1440,2	K 56,70	2082,8	K 82	2743,2	K 108
175,0	K 6,89	787,4	K 31	1447,8	K 57	2088,1	K 82,21	2751,8	K 108,34
181,1	K 7,13	809,5	K 31,87	1451,1	K 57,13	2108,2	K 83	2757,7	K 108,57
185,9	K 7,32	812,8	K 32	1456,4	K 57,34	2114,8	K 83,26	2763,3	K 108,79
191,5	K 7,54	819,4	K 32,26	1462,3	K 57,57	2120,9	K 83,50	2768,6	K 109
197,1	K 7,76	825,5	K 32,50	1467,9	K 57,79	2126,0	K 83,70	2790,7	K 109,87
202,4	K 7,97	830,6	K 32,70	1473,2	K 58	2133,6	K 84	2794,0	K 110
208,0	K 8,19	838,2	K 33	1478,5	K 58,21	2142,2	K 84,34	2800,6	K 110,26
214,1	K 8,43	841,5	K 33,13	1498,6	K 59	2148,1	K 84,57	2806,7	K 110,50
215,9	K 8,50	846,8	K 33,34	1505,2	K 59,26	2153,7	K 84,79	2811,8	K 110,70
221,0	K 8,70	852,7	K 33,57	1511,3	K 59,50	2159,0	K 85	2819,4	K 111
227,1	K 8,94	858,3	K 33,79	1516,4	K 59,70	2181,1	K 85,87	2822,7	K 111,13
231,9	K 9,13	863,6	K 34	1524,0	K 60	2184,4	K 86	2828,0	K 111,34
237,5	K 9,35	868,9	K 34,21	1532,6	K 60,34	2191,0	K 86,26	2833,9	K 111,57
242,8	K 9,56	889,0	K 35	1538,5	K 60,57	2197,1	K 86,50	2839,5	K 111,79
248,2	K 9,77	895,6	K 35,26	1544,1	K 60,79	2202,2	K 86,70	2844,8	K 112
253,0	K 9,96	901,7	K 35,50	1549,4	K 61	2209,8	K 87	2850,1	K 112,21
262,9	K 10,35	906,8	K 35,70	1571,5	K 61,87	2213,1	K 87,13	2870,2	K 113
268,5	K 10,57	914,4	K 36	1574,8	K 62	2218,4	K 87,34	2876,8	K 113,26
273,6	K 10,77	923,0	K 36,34	1581,4	K 62,26	2224,3	K 87,57	2882,9	K 113,50
278,9	K 10,98	928,9	K 36,57	1587,5	K 62,50	2229,9	K 87,79	2888,0	K 113,70
284,5	K 11,20	934,5	K 36,79	1592,6	K 62,70	2235,2	K 88	2895,6	K 114
290,1	K 11,42	939,8	K 37	1600,2	K 63	2240,5	K 88,21	2904,2	K 114,34
297,4	K 11,71	961,9	K 37,87	1603,5	K 63,13	2260,6	K 89	2910,1	K 114,57
304,8	K 12	965,2	K 38	1608,8	K 63,34	2267,2	K 89,26	2915,7	K 114,79
313,4	K 12,34	971,8	K 38,26	1614,7	K 63,57	2273,3	K 89,50	2921,0	K 115
319,3	K 12,57	977,9	K 38,50	1620,3	K 63,79	2278,4	K 89,70	2943,1	K 115,87
324,9	K 12,79	983,0	K 38,70	1625,6	K 64	2286,0	K 90	2946,4	K 116
330,2	K 13	990,6	K 39	1630,9	K 64,21	2294,6	K 90,34	2953,0	K 116,26
352,3	K 13,87	993,9	K 39,13	1651,0	K 65	2300,5	K 90,57	2959,1	K 116,50
355,6	K 14	999,2	K 39,34	1657,6	K 65,26	2306,1	K 90,79	2964,2	K 116,70
362,2	K 14,26	1005,1	K 39,57	1663,7	K 65,50	2311,4	K 91	2971,8	K 117
368,3	K 14,50	1010,7	K 39,79	1668,8	K 65,70	2333,5	K 91,87	2975,1	K 117,13
373,4	K 14,70	1016,0	K 40	1676,4	K 66	2336,8	K 92	2980,4	K 117,34
381,0	K 15	1021,3	K 40,21	1685,0	K 66,34	2343,4	K 92,26	2986,3	K 117,57
384,3	K 15,13	1041,4	K 41	1690,9	K 66,57	2349,5	K 92,50	2991,9	K 117,79
389,6	K 15,34	1048,0	K 41,26	1696,5	K 66,79	2354,6	K 92,70	2997,2	K 118
395,5	K 15,57	1054,1	K 41,50	1701,8	K 67	2362,2	K 93	3002,5	K 118,21
401,1	K 15,79	1059,2	K 41,70	1723,9	K 67,87	2365,5	K 93,13	3022,6	K 119
406,4	K 16	1066,8	K 42	1727,2	K 68	2370,8	K 93,34	3029,2	K 119,26
411,7	K 16,21	1075,4	K 42,34	1733,8	K 68,26	2376,7	K 93,57	3035,3	K 119,50
431,8	K 17	1081,3	K 42,57	1739,9	K 68,50	2382,3	K 93,79	3040,4	K 119,70
438,4	K 17,26	1086,9	K 42,79	1745,0	K 68,70	2387,6	K 94	3048,0	K 120
444,5	K 17,50	1092,2	K 43	1752,6	K 69	2392,9	K 94,21		
449,6	K 17,70	1114,3	K 43,87	1755,9	K 69,13	2413,0	K 95		
457,2	K 18	1117,6	K 44	1761,2	K 69,34	2419,6	K 95,26		
465,8	K 18,34	1124,2	K 44,26	1767,1	K 69,57	2425,7	K 95,50		
471,7	K 18,57	1130,3	K 44,50	1772,7	K 69,79	2430,8	K 95,70		
477,3	K 18,79	1135,4	K 44,70	1778,0	K 70	2438,4	K 96		
482,6	K 19	1143,0	K 45	1783,3	K 70,21	2447,0	K 96,34		
504,7	K 19,87	1146,3	K 45,13	1803,4	K 71	2452,9	K 96,57		
508,0	K 20	1151,6	K 45,34	1810,0	K 71,26	2458,5	K 96,79		
514,6	K 20,26	1157,5	K 45,57	1816,1	K 71,50	2463,8	K 97		
520,7	K 20,50	1163,1	K 45,79	1821,2	K 71,70	2485,9	K 97,87		
525,8	K 20,70	1168,4	K 46	1828,8	K 72	2489,2	K 98		
533,4	K 21	1173,7	K 46,21	1837,4	K 72,34	2495,8	K 98,26		
536,7	K 21,13	1193,8	K 47	1843,3	K 72,57	2501,9	K 98,50		
542,0	K 21,34	1200,4	K 47,26	1848,9	K 72,79	2507,0	K 98,70		
547,9	K 21,57	1206,5	K 47,50	1854,2	K 73	2514,6	K 99		
553,5	K 21,79	1211,6	K 47,70	1876,3	K 73,87	2517,9	K 99,13		
558,8	K 22	1219,2	K 48	1879,6	K 74	2523,2	K 99,34		
564,1	K 22,21	1227,8	K 48,34	1886,2	K 74,26	2529,1	K 99,57		

EXAMPLE OF
CODENUMBER

4809 LF K 12

Series
Material
LF, HT
Width code
(inch)

CHAINS

4809
see page 46

SERIES

5705 - 5706

Width nom. - mm	Code width	Width nom. - mm	Code width
76,2	K 03	2311,4	K 91
82,6	K 3,25	2336,8	K 92
114,3	K 4,5	2362,2	K 93
127,0	K 05	2387,6	K 94
152,4	K 06	2413,0	K 95
177,8	K 07	2438,4	K 96
190,5	K 7,5	2463,8	K 97
203,2	K 08	2489,2	K 98
228,6	K 09	2514,6	K 99
254,0	K 10	2540,0	K 100
279,4	K 11	2565,4	K 101
304,8	K 12	2590,8	K 102
330,2	K 13	2616,2	K 103
355,6	K 14	2641,6	K 104
381,0	K 15	2667,0	K 105
406,4	K 16	2692,4	K 106
431,8	K 17	2717,8	K 107
457,2	K 18	2743,2	K 108
482,6	K 19	2768,6	K 109
508,0	K 20	2794,0	K 110
533,4	K 21	2819,4	K 111
558,8	K 22	2844,8	K 112
584,2	K 23	2870,2	K 113
609,6	K 24	2895,6	K 114
635,0	K 25	2921,0	K 115
660,4	K 26	2946,4	K 116
685,8	K 27	2971,8	K 117
711,2	K 28	2997,2	K 118
736,6	K 29	3022,6	K 119
762,0	K 30	3048,0	K 120
787,4	K 31		
812,8	K 32		
838,2	K 33		
863,6	K 34		
889,0	K 35		
914,4	K 36		
939,8	K 37		
965,2	K 38		
990,6	K 39		
1016,0	K 40		
1041,4	K 41		
1066,8	K 42		
1092,2	K 43		
1117,6	K 44		
1143,0	K 45		
1168,4	K 46		
1193,8	K 47		
1219,2	K 48		
1244,6	K 49		
1270,0	K 50		
1295,4	K 51		
1320,8	K 52		
1346,2	K 53		
1371,6	K 54		
1397,0	K 55		
1422,4	K 56		
1447,8	K 57		
1473,2	K 58		
1498,6	K 59		
1524,0	K 60		
1549,4	K 61		
1574,8	K 62		
1600,2	K 63		
1625,6	K 64		
1651,0	K 65		
1676,4	K 66		
1701,8	K 67		
1727,2	K 68		
1752,6	K 69		
1778,0	K 70		
1803,4	K 71		
1828,8	K 72		
1854,2	K 73		
1879,6	K 74		
1905,0	K 75		
1930,4	K 76		
1955,8	K 77		
1981,2	K 78		
2006,6	K 79		
2032,0	K 80		
2057,4	K 81		
2082,8	K 82		
2108,2	K 83		
2133,6	K 84		
2159,0	K 85		
2184,4	K 86		
2209,8	K 87		
2235,2	K 88		
2260,6	K 89		
2286,0	K 90		

SERIES

5935 - 5936 - 5935 vacuum

Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width
76,2	K 03	1790,7	K 70,50	3505,2	K 138
95,3	K 3,75	1809,8	K 71,25	3524,3	K 138,75
114,3	K 4,50	1828,8	K 72	3543,3	K 139,50
133,4	K 5,25	1847,9	K 72,75	3562,4	K 140,25
152,4	K 06	1866,9	K 73,50	3581,4	K 141*
171,5	K 6,75	1886,0	K 74,25	3600,5	K 141,75
190,5	K 7,50	1905,0	K 75*	3619,5	K 142,50
209,6	K 8,25	1924,1	K 75,75	3638,6	K 143,25
228,6	K 09*	1943,1	K 76,50	3657,6	K 144
247,7	K 9,75	1962,2	K 77,25	3676,7	K 144,75
266,7	K 10,50	1981,2	K 78	3695,7	K 145,50
285,8	K 11,25	2000,3	K 78,75	3714,8	K 146,25
304,8	K 12*	2019,3	K 79,50	3733,8	K 147*
323,9	K 12,75	2038,4	K 80,25	3752,9	K 147,75
342,9	K 13,50	2057,4	K 81*	3771,9	K 148,50
362,0	K 14,25	2076,5	K 81,75	3791,0	K 149,25
381,0	K 15*	2095,5	K 82,50	3810,0	K 150
400,1	K 15,75	2114,6	K 83,25	3829,1	K 150,75
419,1	K 16,50	2133,6	K 84	3848,1	K 151,50
438,2	K 17,25	2152,7	K 84,75	3867,2	K 152,25
457,2	K 18	2171,7	K 85,50	3886,2	K 153*
476,3	K 18,75	2190,8	K 86,25	3905,3	K 153,75
495,3	K 19,50	2209,8	K 87*	3924,3	K 154,50
514,4	K 20,25	2228,9	K 87,75	3943,4	K 155,25
533,4	K 21*	2247,9	K 88,50	3962,4	K 156
552,5	K 21,75	2267,0	K 89,25	3981,5	K 156,75
571,5	K 22,50	2286,0	K 90	4000,5	K 157,50
590,6	K 23,25	2305,1	K 90,75	4019,6	K 158,25
609,6	K 24	2324,1	K 91,50	4038,6	K 159*
628,7	K 24,75	2343,2	K 92,25	4057,7	K 159,75
647,7	K 25,50	2362,2	K 93*	4076,7	K 160,50
666,8	K 26,25	2381,3	K 93,75	4095,8	K 161,25
685,8	K 27*	2400,3	K 94,50	4114,8	K 162
704,9	K 27,75	2419,4	K 95,25	4133,9	K 162,75
723,9	K 28,50	2438,4	K 96	4152,9	K 163,50
743,0	K 29,25	2457,5	K 96,75	4172,0	K 164,25
762,0	K 30	2476,5	K 97,50	4191,0	K 165*
781,1	K 30,75	2495,6	K 98,25	4210,1	K 165,75
800,1	K 31,50	2514,6	K 99*	4229,1	K 166,50
819,2	K 32,25	2533,7	K 99,75	4248,2	K 167,25
838,2	K 33*	2552,7	K 100,50	4267,2	K 168
857,3	K 33,75	2571,8	K 101,25	4286,3	K 168,75
876,3	K 34,50	2590,8	K 102	4305,3	K 169,50
895,4	K 35,25	2609,9	K 102,75	4324,4	K 170,25
914,4	K 36	2628,9	K 103,50	4343,4	K 171*
933,5	K 36,75	2648,0	K 104,25	4362,5	K 171,75
952,5	K 37,50	2667,0	K 105*	4381,5	K 172,50
971,6	K 38,25	2686,1	K 105,75	4400,6	K 173,25
990,6	K 39*	2705,1	K 106,50	4419,6	K 174
1009,7	K 39,75	2724,2	K 107,25	4438,7	K 174,75
1028,7	K 40,50	2743,2	K 108	4457,7	K 175,50
1047,8	K 41,25	2762,3	K 108,75	4476,8	K 176,25
1066,8	K 42	2781,3	K 109,50	4495,8	K 177*
1085,9	K 42,75	2800,4	K 110,25		
1104,9	K 43,50	2819,4	K 111*		
1124,0	K 44,25	2838,5	K 111,75		
1143,0	K 45*	2857,5	K 112,50		
1162,1	K 45,75	2876,6	K 113,25		
1181,1	K 46,50	2895,6	K 114		
1200,2	K 47,25	2914,7	K 114,75		
1219,2	K 48	2933,7	K 115,50		
1238,3	K 48,75	2952,8	K 116,25		
1257,3	K 49,50	2971,8	K 117*		
1276,4	K 50,25	2990,9	K 117,75		
1295,4	K 51*	3009,9	K 118,50		
1314,5	K 51,75	3029,0	K 119,25		
1333,5	K 52,50	3048,0	K 120		
1352,6	K 53,25	3067,1	K 120,75		
1371,6	K 54	3086,1	K 121,50		
1390,7	K 54,75	3105,2	K 122,25		
1409,7	K 55,50	3124,2	K 123*		
1428,8	K 56,25	3143,3	K 123,75		
1447,8	K 57*	3162,3	K 124,50		
1466,9	K 57,75	3181,4	K 125,25		
1485,9	K 58,50	3200,4	K 126		
1505,0	K 59,25	3219,5	K 126,75		
1524,0	K 60	3238,5	K 127,50		
1543,1	K 60,75	3257,6	K 128,25		
1562,1	K 61,50	3276,6	K 129*		
1581,2	K 62,25	3295,7	K 129,75		
1600,2	K 63*	3314,7	K 130,50		
1619,3	K 63,75	3333,8	K 131,25		
1638,3	K 64,50	3352,8	K 132		
1657,4	K 65,25	3371,9	K 132,75		
1676,4	K 66	3390,9	K 133,50		
1695,5	K 66,75	3410,0	K 134,25		
1714,5	K 67,50	3429,0	K 135*		
1733,6	K 68,25	3448,1	K 135,75		
1752,6	K 69*	3467,1	K 136,50		
1771,7	K 69,75	3486,2	K 137,25		

* = standard only
for 5935 -
5935 vacuum

NOMINAL
WIDTH
OF CHAIN

Standard widths
in blue

Other widths
available on
request

TOLERANCES
CHAIN WIDTH

The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

EXAMPLE OF
CODENUMBER

5706 HP K06

Series |
Material
HP, WHP,
LF, HT

Width code
(inch)

CHAINS

5705-5706

see page 38

5935-5936-5935v

see page 26

SERIES

5996 - 5997

NOMINAL
WIDTH
OF CHAINStandard widths
in **blue**Other widths
available **on**
requestTOLERANCES
CHAIN WIDTH

The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width	Width nom. - mm	Code width
114,3	K 4,5	1257,3	K 49,5	2400,3	K 94,5	3543,3	K 139,5
127,0	K 05	1270,0	K 50	2413,0	K 95	3556,0	K 140
139,7	K 5,5	1282,7	K 50,5	2425,7	K 95,5	3568,7	K 140,5
152,4	K 06	1295,4	K 51	2438,4	K 96	3581,4	K 141
165,1	K 6,5	1308,1	K 51,5	2451,1	K 96,5	3594,1	K 141,5
177,8	K 07	1320,8	K 52	2463,8	K 97	3606,8	K 142
190,5	K 7,5	1333,5	K 52,5	2476,5	K 97,5	3619,5	K 142,5
203,2	K 08	1346,2	K 53	2489,2	K 98	3632,2	K 143
215,9	K 8,5	1358,9	K 53,5	2501,9	K 98,5	3644,9	K 143,5
228,6	K 09	1371,6	K 54	2514,6	K 99	3657,6	K 144
241,3	K 9,5	1384,3	K 54,5	2527,3	K 99,5		
254,0	K 10	1397,0	K 55	2540,0	K 100		
266,7	K 10,5	1409,7	K 55,5	2552,7	K 100,5		
279,4	K 11	1422,4	K 56	2565,4	K 101		
292,1	K 11,5	1435,1	K 56,5	2578,1	K 101,5		
304,8	K 12	1447,8	K 57	2590,8	K 102		
317,5	K 12,5	1460,5	K 57,5	2603,5	K 102,5		
330,2	K 13	1473,2	K 58	2616,2	K 103		
342,9	K 13,5	1485,9	K 58,5	2628,9	K 103,5		
355,6	K 14	1498,6	K 59	2641,6	K 104		
368,3	K 14,5	1511,3	K 59,5	2654,3	K 104,5		
381,0	K 15	1524,0	K 60	2667,0	K 105		
393,7	K 15,5	1536,7	K 60,5	2679,7	K 105,5		
406,4	K 16	1549,4	K 61	2692,4	K 106		
419,1	K 16,5	1562,1	K 61,5	2705,1	K 106,5		
431,8	K 17	1574,8	K 62	2717,8	K 107		
444,5	K 17,5	1587,5	K 62,5	2730,5	K 107,5		
457,2	K 18	1600,2	K 63	2743,2	K 108		
469,9	K 18,5	1612,9	K 63,5	2755,9	K 108,5		
482,6	K 19	1625,6	K 64	2768,6	K 109		
495,3	K 19,5	1638,3	K 64,5	2781,3	K 109,5		
508,0	K 20	1651,0	K 65	2794,0	K 110		
520,7	K 20,5	1663,7	K 65,5	2806,7	K 110,5		
533,4	K 21	1676,4	K 66	2819,4	K 111		
546,1	K 21,5	1689,1	K 66,5	2832,1	K 111,5		
558,8	K 22	1701,8	K 67	2844,8	K 112		
571,5	K 22,5	1714,5	K 67,5	2857,5	K 112,5		
584,2	K 23	1727,2	K 68	2870,2	K 113		
596,9	K 23,5	1739,9	K 68,5	2882,9	K 113,5		
609,6	K 24	1752,6	K 69	2895,6	K 114		
622,3	K 24,5	1765,3	K 69,5	2908,3	K 114,5		
635,0	K 25	1778,0	K 70	2921,0	K 115		
647,7	K 25,5	1790,7	K 70,5	2933,7	K 115,5		
660,4	K 26	1803,4	K 71	2946,4	K 116		
673,1	K 26,5	1816,1	K 71,5	2959,1	K 116,5		
685,8	K 27	1828,8	K 72	2971,8	K 117		
698,5	K 27,5	1841,5	K 72,5	2984,5	K 117,5		
711,2	K 28	1854,2	K 73	2997,2	K 118		
723,9	K 28,5	1866,9	K 73,5	3009,9	K 118,5		
736,6	K 29	1879,6	K 74	3022,6	K 119		
749,3	K 29,5	1892,3	K 74,5	3035,3	K 119,5		
762,0	K 30	1905,0	K 75	3048,0	K 120		
774,7	K 30,5	1917,7	K 75,5	3060,7	K 120,5		
787,4	K 31	1930,4	K 76	3073,4	K 121		
800,1	K 31,5	1943,1	K 76,5	3086,1	K 121,5		
812,8	K 32	1955,8	K 77	3098,8	K 122		
825,5	K 32,5	1968,5	K 77,5	3111,5	K 122,5		
838,2	K 33	1981,2	K 78	3124,2	K 123		
850,9	K 33,5	1993,9	K 78,5	3136,9	K 123,5		
863,6	K 34	2006,6	K 79	3149,6	K 124		
876,3	K 34,5	2019,3	K 79,5	3162,3	K 124,5		
889,0	K 35	2032,0	K 80	3175,0	K 125		
901,7	K 35,5	2044,7	K 80,5	3187,7	K 125,5		
914,4	K 36	2057,4	K 81	3200,4	K 126		
927,1	K 36,5	2070,1	K 81,5	3213,1	K 126,5		
939,8	K 37	2082,8	K 82	3225,8	K 127		
952,5	K 37,5	2095,5	K 82,5	3238,5	K 127,5		
965,2	K 38	2108,2	K 83	3251,2	K 128		
977,9	K 38,5	2120,9	K 83,5	3263,9	K 128,5		
990,6	K 39	2133,6	K 84	3276,6	K 129		
1003,3	K 39,5	2146,3	K 84,5	3289,3	K 129,5		
1016,0	K 40	2159,0	K 85	3302,0	K 130		
1028,7	K 40,5	2171,7	K 85,5	3314,7	K 130,5		
1041,4	K 41	2184,4	K 86	3327,4	K 131		
1054,1	K 41,5	2197,1	K 86,5	3340,1	K 131,5		
1066,8	K 42	2209,8	K 87	3352,8	K 132		
1079,5	K 42,5	2222,5	K 87,5	3365,5	K 132,5		
1092,2	K 43	2235,2	K 88	3378,2	K 133		
1104,9	K 43,5	2247,9	K 88,5	3390,9	K 133,5		
1117,6	K 44	2260,6	K 89	3403,6	K 134		
1130,3	K 44,5	2273,3	K 89,5	3416,3	K 134,5		
1143,0	K 45	2286,0	K 90	3429,0	K 135		
1155,7	K 45,5	2298,7	K 90,5	3441,7	K 135,5		
1168,4	K 46	2311,4	K 91	3454,4	K 136		
1181,1	K 46,5	2324,1	K 91,5	3467,1	K 136,5		
1193,8	K 47	2336,8	K 92	3479,8	K 137		
1206,5	K 47,5	2349,5	K 92,5	3492,5	K 137,5		
1219,2	K 48	2362,2	K 93	3505,2	K 138		
1231,9	K 48,5	2374,9	K 93,5	3517,9	K 138,5		
1244,6	K 49	2387,6	K 94	3530,6	K 139		

EXAMPLE OF
CODENUMBER

5996 LF K 25

Series |
Material |
LF, HT, WHT |
WLT |
Width code
(inch)

CHAINS

5996-5997
see page 48

SERIES

5998

Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width
127,0	K 05	1270,0	K 50	2413,0	K 95	3556,0	K 140
139,7	K 5,5	1282,7	K 50,5	2425,7	K 95,5	3568,7	K 140,5
152,4	K 06	1295,4	K 51	2438,4	K 96	3581,4	K 141
165,1	K 6,5	1308,1	K 51,5	2451,1	K 96,5	3594,1	K 141,5
177,8	K 07	1320,8	K 52	2463,8	K 97	3606,8	K 142
190,5	K 7,5	1333,5	K 52,5	2476,5	K 97,5	3619,5	K 142,5
203,2	K 08	1346,2	K 53	2489,2	K 98	3632,2	K 143
215,9	K 8,5	1358,9	K 53,5	2501,9	K 98,5	3644,9	K 143,5
228,6	K 09	1371,6	K 54	2514,6	K 99	3657,6	K 144
241,3	K 9,5	1384,3	K 54,5	2527,3	K 99,5		
254,0	K 10	1397,0	K 55	2540,0	K 100		
266,7	K 10,5	1409,7	K 55,5	2552,7	K 100,5		
279,4	K 11	1422,4	K 56	2565,4	K 101		
292,1	K 11,5	1435,1	K 56,5	2578,1	K 101,5		
304,8	K 12	1447,8	K 57	2590,8	K 102		
317,5	K 12,5	1460,5	K 57,5	2603,5	K 102,5		
330,2	K 13	1473,2	K 58	2616,2	K 103		
342,9	K 13,5	1485,9	K 58,5	2628,9	K 103,5		
355,6	K 14	1498,6	K 59	2641,6	K 104		
368,3	K 14,5	1511,3	K 59,5	2654,3	K 104,5		
381,0	K 15	1524,0	K 60	2667,0	K 105		
393,7	K 15,5	1536,7	K 60,5	2679,7	K 105,5		
406,4	K 16	1549,4	K 61	2692,4	K 106		
419,1	K 16,5	1562,1	K 61,5	2705,1	K 106,5		
431,8	K 17	1574,8	K 62	2717,8	K 107		
444,5	K 17,5	1587,5	K 62,5	2730,5	K 107,5		
457,2	K 18	1600,2	K 63	2743,2	K 108		
469,9	K 18,5	1612,9	K 63,5	2755,9	K 108,5		
482,6	K 19	1625,6	K 64	2768,6	K 109		
495,3	K 19,5	1638,3	K 64,5	2781,3	K 109,5		
508,0	K 20	1651,0	K 65	2794,0	K 110		
520,7	K 20,5	1663,7	K 65,5	2806,7	K 110,5		
533,4	K 21	1676,4	K 66	2819,4	K 111		
546,1	K 21,5	1689,1	K 66,5	2832,1	K 111,5		
558,8	K 22	1701,8	K 67	2844,8	K 112		
571,5	K 22,5	1714,5	K 67,5	2857,5	K 112,5		
584,2	K 23	1727,2	K 68	2870,2	K 113		
596,9	K 23,5	1739,9	K 68,5	2882,9	K 113,5		
609,6	K 24	1752,6	K 69	2895,6	K 114		
622,3	K 24,5	1765,3	K 69,5	2908,3	K 114,5		
635,0	K 25	1778,0	K 70	2921,0	K 115		
647,7	K 25,5	1790,7	K 70,5	2933,7	K 115,5		
660,4	K 26	1803,4	K 71	2946,4	K 116		
673,1	K 26,5	1816,1	K 71,5	2959,1	K 116,5		
685,8	K 27	1828,8	K 72	2971,8	K 117		
698,5	K 27,5	1841,5	K 72,5	2984,5	K 117,5		
711,2	K 28	1854,2	K 73	2997,2	K 118		
723,9	K 28,5	1866,9	K 73,5	3009,9	K 118,5		
736,6	K 29	1879,6	K 74	3022,6	K 119		
749,3	K 29,5	1892,3	K 74,5	3035,3	K 119,5		
762,0	K 30	1905,0	K 75	3048,0	K 120		
774,7	K 30,5	1917,7	K 75,5	3060,7	K 120,5		
787,4	K 31	1930,4	K 76	3073,4	K 121		
800,1	K 31,5	1943,1	K 76,5	3086,1	K 121,5		
812,8	K 32	1955,8	K 77	3098,8	K 122		
825,5	K 32,5	1968,5	K 77,5	3111,5	K 122,5		
838,2	K 33	1981,2	K 78	3124,2	K 123		
850,9	K 33,5	1993,9	K 78,5	3136,9	K 123,5		
863,6	K 34	2006,6	K 79	3149,6	K 124		
876,3	K 34,5	2019,3	K 79,5	3162,3	K 124,5		
889,0	K 35	2032,0	K 80	3175,0	K 125		
901,7	K 35,5	2044,7	K 80,5	3187,7	K 125,5		
914,4	K 36	2057,4	K 81	3200,4	K 126		
927,1	K 36,5	2070,1	K 81,5	3213,1	K 126,5		
939,8	K 37	2082,8	K 82	3225,8	K 127		
952,5	K 37,5	2095,5	K 82,5	3238,5	K 127,5		
965,2	K 38	2108,2	K 83	3251,2	K 128		
977,9	K 38,5	2120,9	K 83,5	3263,9	K 128,5		
990,6	K 39	2133,6	K 84	3276,6	K 129		
1003,3	K 39,5	2146,3	K 84,5	3289,3	K 129,5		
1016,0	K 40	2159,0	K 85	3302,0	K 130		
1028,7	K 40,5	2171,7	K 85,5	3314,7	K 130,5		
1041,4	K 41	2184,4	K 86	3327,4	K 131		
1054,1	K 41,5	2197,1	K 86,5	3340,1	K 131,5		
1066,8	K 42	2209,8	K 87	3352,8	K 132		
1079,5	K 42,5	2222,5	K 87,5	3365,5	K 132,5		
1092,2	K 43	2235,2	K 88	3378,2	K 133		
1104,9	K 43,5	2247,9	K 88,5	3390,9	K 133,5		
1117,6	K 44	2260,6	K 89	3403,6	K 134		
1130,3	K 44,5	2273,3	K 89,5	3416,3	K 134,5		
1143,0	K 45	2286,0	K 90	3429,0	K 135		
1155,7	K 45,5	2298,7	K 90,5	3441,7	K 135,5		
1168,4	K 46	2311,4	K 91	3454,4	K 136		
1181,1	K 46,5	2324,1	K 91,5	3467,1	K 136,5		
1193,8	K 47	2336,8	K 92	3479,8	K 137		
1206,5	K 47,5	2349,5	K 92,5	3492,5	K 137,5		
1219,2	K 48	2362,2	K 93	3505,2	K 138		
1231,9	K 48,5	2374,9	K 93,5	3517,9	K 138,5		
1244,6	K 49	2387,6	K 94	3530,6	K 139		
1257,3	K 49,5	2400,3	K 94,5	3543,3	K 139,5		

NOMINAL
WIDTH
OF CHAINStandard widths
in **blue**Other widths
available **on
request**TOLERANCES
CHAIN WIDTH

The indicated widths are nominal dimensions. For certified widths and tolerances refer to our Technical Department

EXAMPLE OF
CODENUMBER

5998 WHT K 12

Series | Material WHT, WLT | Width code (inch)

CHAINS

5998
see page 52

SERIES

6390 - 6391 - 6392

NOMINAL
WIDTH
OF CHAIN

Nom. width
without tension
plates - mm

- 75
- 150
- 225
- 300
- 375
- 450
- 525
- 600
- 675
- 750
- 825
- 900
- 975
- 1050
- 1125
- 1200
- 1275
- 1350
- 1425
- 1500
- 1575
- 1650
- 1725
- 1800
- 1875
- 1950
- 2025
- 2100
- 2175
- 2250
- 2325
- 2400
- 2475
- 2550
- 2625
- 2700
- 2775
- 2850
- 2925
- 3000

All indicated
widths are
standard

Other widths
available on
request

TOLERANCES
CHAIN WIDTH

The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

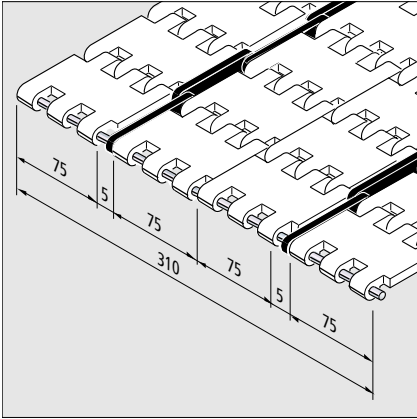
The indicated values are for chain widths without tension plates.

To determine the width with tension plates these dimensions should be added with the widths of the tension plates (5 mm for every row of tension plates).

The number of rows of tension plates depends on the total tension in the chain. See page 71.

Example of calculation of definite width of a chain with 2 rows of tension plates

Definitive width = Nominal width without tension plates (300 mm) + 2 rows of tension plates (10 mm) = 310 mm



EXAMPLE OF
CODENUMBER

6390 WHT K310

Series |
Material
WHT, BHT,
YSM, WLT |
Width incl.
tension plates
(mm) |

CHAINS

6390-6391-6392
see page 44

SERIES

7705 - 7706

Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width
76,2	K 03	1231,9	K 48,5	2374,9	K 93,5
82,6	K 3,25	1244,6	K 49	2387,6	K 94
114,3	K 4,5	1257,3	K 49,5	2400,3	K 94,5
127,0	K 05	1270,0	K 50	2413,0	K 95
139,7	K 5,5	1282,7	K 50,5	2425,7	K 95,5
152,4	K 06	1295,4	K 51	2438,4	K 96
165,1	K 6,5	1308,1	K 51,5	2451,1	K 96,5
177,8	K 07	1320,8	K 52	2463,8	K 97
190,5	K 7,5	1333,5	K 52,5	2476,5	K 97,5
203,2	K 08	1346,2	K 53	2489,2	K 98
215,9	K 8,5	1358,9	K 53,5	2501,9	K 98,5
228,6	K 09	1371,6	K 54	2514,6	K 99
241,3	K 9,5	1384,3	K 54,5	2527,3	K 99,5
254,0	K 10	1397,0	K 55	2540,0	K 100
266,7	K 10,5	1409,7	K 55,5	2552,7	K 100,5
279,4	K 11	1422,4	K 56	2565,4	K 101
292,1	K 11,5	1435,1	K 56,5	2578,1	K 101,5
304,8	K 12	1447,8	K 57	2590,8	K 102
317,5	K 12,5	1460,5	K 57,5	2603,5	K 102,5
330,2	K 13	1473,2	K 58	2616,2	K 103
342,9	K 13,5	1485,9	K 58,5	2628,9	K 103,5
355,6	K 14	1498,6	K 59	2641,6	K 104
368,3	K 14,5	1511,3	K 59,5	2654,3	K 104,5
381,0	K 15	1524,0	K 60	2667,0	K 105
393,7	K 15,5	1536,7	K 60,5	2679,7	K 105,5
406,4	K 16	1549,4	K 61	2692,4	K 106
419,1	K 16,5	1562,1	K 61,5	2705,1	K 106,5
431,8	K 17	1574,8	K 62	2717,8	K 107
444,5	K 17,5	1587,5	K 62,5	2730,5	K 107,5
457,2	K 18	1600,2	K 63	2743,2	K 108
469,9	K 18,5	1612,9	K 63,5	2755,9	K 108,5
482,6	K 19	1625,6	K 64	2768,6	K 109
495,3	K 19,5	1638,3	K 64,5	2781,3	K 109,5
508,0	K 20	1651,0	K 65	2794,0	K 110
520,7	K 20,5	1663,7	K 65,5	2806,7	K 110,5
533,4	K 21	1676,4	K 66	2819,4	K 111
546,1	K 21,5	1689,1	K 66,5	2832,1	K 111,5
558,8	K 22	1701,8	K 67	2844,8	K 112
571,5	K 22,5	1714,5	K 67,5	2857,5	K 112,5
584,2	K 23	1727,2	K 68	2870,2	K 113
596,9	K 23,5	1739,9	K 68,5	2882,9	K 113,5
609,6	K 24	1752,6	K 69	2895,6	K 114
622,3	K 24,5	1765,3	K 69,5	2908,3	K 114,5
635,0	K 25	1778,0	K 70	2921,0	K 115
647,7	K 25,5	1790,7	K 70,5	2933,7	K 115,5
660,4	K 26	1803,4	K 71	2946,4	K 116
673,1	K 26,5	1816,1	K 71,5	2959,1	K 116,5
685,8	K 27	1828,8	K 72	2971,8	K 117
698,5	K 27,5	1841,5	K 72,5	2984,5	K 117,5
711,2	K 28	1854,2	K 73	2997,2	K 118
723,9	K 28,5	1866,9	K 73,5	3009,9	K 118,5
736,6	K 29	1879,6	K 74	3022,6	K 119
749,3	K 29,5	1892,3	K 74,5	3035,3	K 119,5
762,0	K 30	1905,0	K 75	3048,0	K 120
774,7	K 30,5	1917,7	K 75,5		
787,4	K 31	1930,4	K 76		
800,1	K 31,5	1943,1	K 76,5		
812,8	K 32	1955,8	K 77		
825,5	K 32,5	1968,5	K 77,5		
838,2	K 33	1981,2	K 78		
850,9	K 33,5	1993,9	K 78,5		
863,6	K 34	2006,6	K 79		
876,3	K 34,5	2019,3	K 79,5		
889,0	K 35	2032,0	K 80		
901,7	K 35,5	2044,7	K 80,5		
914,4	K 36	2057,4	K 81		
927,1	K 36,5	2070,1	K 81,5		
939,8	K 37	2082,8	K 82		
952,5	K 37,5	2095,5	K 82,5		
965,2	K 38	2108,2	K 83		
977,9	K 38,5	2120,9	K 83,5		
990,6	K 39	2133,6	K 84		
1003,3	K 39,5	2146,3	K 84,5		
1016,0	K 40	2159,0	K 85		
1028,7	K 40,5	2171,7	K 85,5		
1041,4	K 41	2184,4	K 86		
1054,1	K 41,5	2197,1	K 86,5		
1066,8	K 42	2209,8	K 87		
1079,5	K 42,5	2222,5	K 87,5		
1092,2	K 43	2235,2	K 88		
1104,9	K 43,5	2247,9	K 88,5		
1117,6	K 44	2260,6	K 89		
1130,3	K 44,5	2273,3	K 89,5		
1143,0	K 45	2286,0	K 90		
1155,7	K 45,5	2298,7	K 90,5		
1168,4	K 46	2311,4	K 91		
1181,1	K 46,5	2324,1	K 91,5		
1193,8	K 47	2336,8	K 92		
1206,5	K 47,5	2349,5	K 92,5		
1219,2	K 48	2362,2	K 93		

NOMINAL
WIDTH
OF CHAINStandard widths
in **blue**Other widths
available **on
request**TOLERANCES
CHAIN WIDTHThe indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
DepartmentEXAMPLE OF
CODENUMBER

7705 HP K09

Series	Material	Width code (inch)
7705	HP, WHP	K09

CHAINS

7705-7706
see page 30

SERIES
8505 - 8506

NOMINAL
WIDTH
OF CHAIN

Standard widths
in blue

Other widths
available on
request

TOLERANCES
CHAIN WIDTH

The indicated
widths are nominal
dimensions. For
certified widths
and tolerances
refer to our
Technical
Department

Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width	Width nom.-mm	Code width
59,3	K 2,33	795,9	K 31,33	1557,9	K 61,33	2319,8	K 91,33
67,7	K 2,67	804,3	K 31,67	1566,3	K 61,67	2328,3	K 91,67
76,2	K 3,00	812,8	K 32,00	1574,8	K 62,00	2336,8	K 92,00
82,6	K 3,25	821,3	K 32,33	1583,3	K 62,33	2345,2	K 92,33
85,0	K 3,33	829,7	K 32,67	1591,7	K 62,67	2353,7	K 92,67
93,1	K 3,67	838,2	K 33,00	1600,2	K 63,00	2362,2	K 93,00
101,6	K 4,00	846,7	K 33,33	1608,7	K 63,33	2370,6	K 93,33
110,1	K 4,33	855,1	K 33,67	1617,1	K 63,67	2379,1	K 93,67
114,3	K 4,50	863,6	K 34,00	1625,6	K 64,00	2387,6	K 94,00
118,5	K 4,67	872,1	K 34,33	1634,1	K 64,33	2396,0	K 94,33
127,0	K 5,00	880,5	K 34,67	1642,5	K 64,67	2404,5	K 94,67
135,5	K 5,33	889,0	K 35,00	1651,0	K 65,00	2413,0	K 95,00
143,9	K 5,67	897,5	K 35,33	1659,5	K 65,33	2421,4	K 95,33
152,4	K 6,00	905,9	K 35,67	1667,9	K 65,67	2429,9	K 95,67
160,9	K 6,33	914,4	K 36,00	1676,4	K 66,00	2438,4	K 96,00
169,3	K 6,67	922,9	K 36,33	1684,9	K 66,33	2446,8	K 96,33
177,8	K 7,00	931,3	K 36,67	1693,3	K 66,67	2455,3	K 96,67
186,3	K 7,33	939,8	K 37,00	1701,8	K 67,00	2463,8	K 97,00
190,5	K 7,50	948,3	K 37,33	1710,3	K 67,33	2472,2	K 97,33
194,7	K 7,67	956,7	K 37,67	1718,7	K 67,67	2480,7	K 97,67
203,2	K 8,00	965,2	K 38,00	1727,2	K 68,00	2489,2	K 98,00
211,7	K 8,33	973,7	K 38,33	1735,6	K 68,33	2497,6	K 98,33
220,1	K 8,67	982,1	K 38,67	1744,1	K 68,67	2506,1	K 98,67
228,6	K 9,00	990,6	K 39,00	1752,6	K 69,00	2514,6	K 99,00
237,1	K 9,33	999,1	K 39,33	1761,0	K 69,33	2523,0	K 99,33
245,5	K 9,67	1007,5	K 39,67	1769,5	K 69,67	2531,5	K 99,67
254,0	K 10,00	1016,0	K 40,00	1778,0	K 70,00	2540,0	K 100,00
262,5	K 10,33	1024,5	K 40,33	1786,4	K 70,33	2548,4	K 100,33
270,9	K 10,67	1032,9	K 40,67	1794,9	K 70,67	2556,9	K 100,67
279,4	K 11,00	1041,4	K 41,00	1803,4	K 71,00	2565,4	K 101,00
287,9	K 11,33	1049,9	K 41,33	1811,8	K 71,33	2573,8	K 101,33
296,3	K 11,67	1058,3	K 41,67	1820,3	K 71,67	2582,3	K 101,67
304,8	K 12,00	1066,8	K 42,00	1828,8	K 72,00	2590,8	K 102,00
313,3	K 12,33	1075,3	K 42,33	1837,2	K 72,33	2599,2	K 102,33
321,7	K 12,67	1083,7	K 42,67	1845,7	K 72,67	2607,7	K 102,67
330,2	K 13,00	1092,2	K 43,00	1854,2	K 73,00	2616,2	K 103,00
338,7	K 13,33	1100,7	K 43,33	1862,6	K 73,33	2624,6	K 103,33
347,1	K 13,67	1109,1	K 43,67	1871,1	K 73,67	2633,1	K 103,67
355,6	K 14,00	1117,6	K 44,00	1879,6	K 74,00	2641,6	K 104,00
364,1	K 14,33	1126,1	K 44,33	1888,0	K 74,33	2650,0	K 104,33
372,5	K 14,67	1134,5	K 44,67	1896,5	K 74,67	2658,5	K 104,67
381,0	K 15,00	1143,0	K 45,00	1905,0	K 75,00	2667,0	K 105,00
389,5	K 15,33	1151,5	K 45,33	1913,4	K 75,33	2675,4	K 105,33
397,9	K 15,67	1159,9	K 45,67	1921,9	K 75,67	2683,9	K 105,67
406,4	K 16,00	1168,4	K 46,00	1930,4	K 76,00	2692,4	K 106,00
414,9	K 16,33	1176,9	K 46,33	1938,8	K 76,33	2700,8	K 106,33
423,3	K 16,67	1185,3	K 46,67	1947,3	K 76,67	2709,3	K 106,67
431,8	K 17,00	1193,8	K 47,00	1955,8	K 77,00	2717,8	K 107,00
440,3	K 17,33	1202,3	K 47,33	1964,2	K 77,33	2726,2	K 107,33
448,7	K 17,67	1210,7	K 47,67	1972,7	K 77,67	2734,7	K 107,67
457,2	K 18,00	1219,2	K 48,00	1981,2	K 78,00	2743,2	K 108,00
465,7	K 18,33	1227,7	K 48,33	1989,6	K 78,33		
474,1	K 18,67	1236,1	K 48,67	1998,1	K 78,67		
482,6	K 19,00	1244,6	K 49,00	2006,6	K 79,00		
491,1	K 19,33	1253,1	K 49,33	2015,0	K 79,33		
499,5	K 19,67	1261,5	K 49,67	2023,5	K 79,67		
508,0	K 20,00	1270,0	K 50,00	2032,0	K 80,00		
516,5	K 20,33	1278,5	K 50,33	2040,4	K 80,33		
524,9	K 20,67	1286,9	K 50,67	2048,9	K 80,67		
533,4	K 21,00	1295,4	K 51,00	2057,4	K 81,00		
541,9	K 21,33	1303,9	K 51,33	2065,8	K 81,33		
550,3	K 21,67	1312,3	K 51,67	2074,3	K 81,67		
558,8	K 22,00	1320,8	K 52,00	2082,8	K 82,00		
567,3	K 22,33	1329,3	K 52,33	2091,2	K 82,33		
575,7	K 22,67	1337,7	K 52,67	2099,7	K 82,67		
584,2	K 23,00	1346,2	K 53,00	2108,2	K 83,00		
592,7	K 23,33	1354,7	K 53,33	2116,6	K 83,33		
601,1	K 23,67	1363,1	K 53,67	2125,1	K 83,67		
609,6	K 24,00	1371,6	K 54,00	2133,6	K 84,00		
618,1	K 24,33	1380,1	K 54,33	2142,0	K 84,33		
626,5	K 24,67	1388,5	K 54,67	2150,5	K 84,67		
635,0	K 25,00	1397,0	K 55,00	2159,0	K 85,00		
643,5	K 25,33	1405,5	K 55,33	2167,4	K 85,33		
651,9	K 25,67	1413,9	K 55,67	2175,9	K 85,67		
660,4	K 26,00	1422,4	K 56,00	2184,4	K 86,00		
668,9	K 26,33	1430,9	K 56,33	2192,8	K 86,33		
677,3	K 26,67	1439,3	K 56,67	2201,3	K 86,67		
685,8	K 27,00	1447,8	K 57,00	2209,8	K 87,00		
694,3	K 27,33	1456,3	K 57,33	2218,2	K 87,33		
702,7	K 27,67	1464,7	K 57,67	2226,7	K 87,67		
711,2	K 28,00	1473,2	K 58,00	2235,2	K 88,00		
719,7	K 28,33	1481,7	K 58,33	2243,6	K 88,33		
728,1	K 28,67	1490,1	K 58,67	2252,1	K 88,67		
736,6	K 29,00	1498,6	K 59,00	2260,6	K 89,00		
745,1	K 29,33	1507,1	K 59,33	2269,0	K 89,33		
753,5	K 29,67	1515,5	K 59,67	2277,5	K 89,67		
762,0	K 30,00	1524,0	K 60,00	2286,0	K 90,00		
770,5	K 30,33	1532,5	K 60,33	2294,4	K 90,33		
778,9	K 30,67	1540,9	K 60,67	2302,9	K 90,67		
787,4	K 31,00	1549,4	K 61,00	2311,4	K 91,00		

EXAMPLE OF
CODENUMBER

8506 HP K06

Series |

Material
HP, WHP,
WHT |

Width code
(inch) |

CHAINS

8505-8506
see page 24

MatTop®

Calculation of chain pull (F) Horizontal conveyors

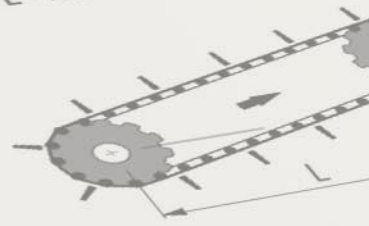


Without accumulation
With accumulation

$$F = (2W + M) \cdot L \cdot Fw \cdot 9,81$$

$$F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm)] \cdot 9,81$$

Inclined conveyors with flights



$$Fw + (M \cdot H)] \cdot 9,81$$



Conveyors
flights

Without accumulation
With accumulation

$$F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm)] \cdot 9,81$$

$$F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm)] \cdot 9,81$$

Calculation of required

SF = Service factor
Continuous operation
Occasional start
Frequent start

SOFTWARE REXNORD

To ensure optimum operation of MatTop® chains, Rexnord has developed special software for the calculation of the loads and tensions in the chains.

This program also provides additional information about the design of almost every type of conveyor.

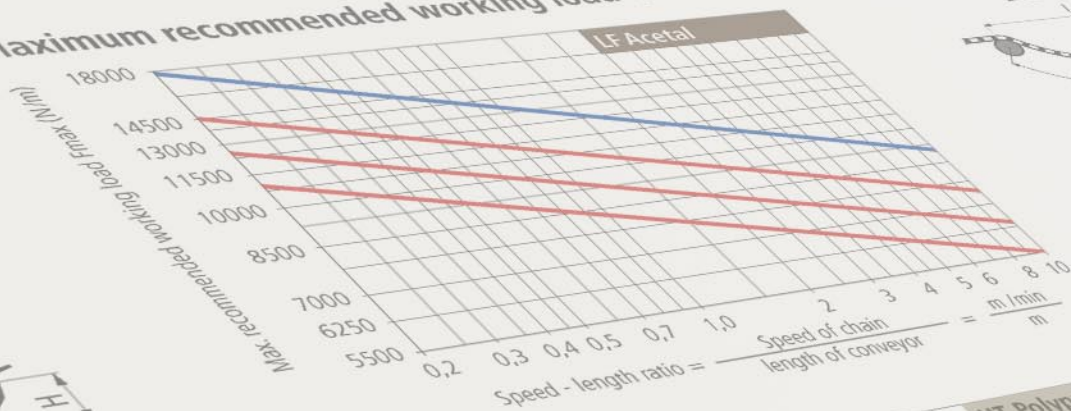
For more information please contact our Engineering Department.

Legend

F
W

Engineering Manual

Maximum recommended working load- F max



Calculation of catenary force (Fc)



$$F_c = \frac{P \cdot W}{799 \cdot l} + \frac{W \cdot l}{102}$$

F_c = Catenary force - N/m
 l = Span - mm
 W = Product weight - mm
 P = Sag - mm

Table 1 - Coefficient of friction between chain and conveyor

Material chain	Lubrication
D-AS	Dry Water Water and Oil

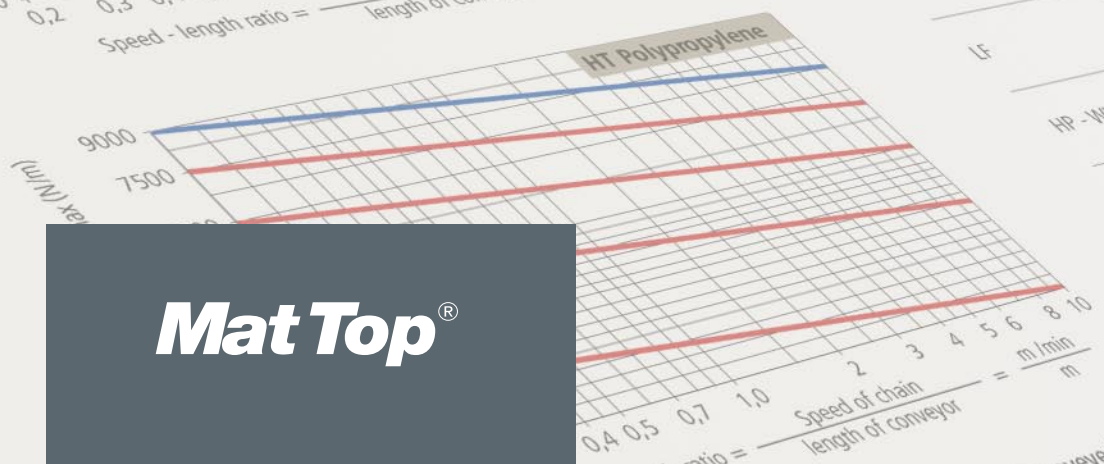


Table 2 - Coefficient of friction between chain and conveyor

Material of conveyed products	Lubrication
Plastic PET	Dry Water Water and Oil
Cardboard	Dry
Steel	
Aluminium	
Glass	

Mat Top®

**ENGINEERING
MANUAL**

Required horsepower (P)

$$P = \frac{F \cdot K \cdot V}{60'000} \cdot SF$$

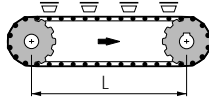
To obtain the horsepower of the drive system, consider:

1,2
1,4
1,6

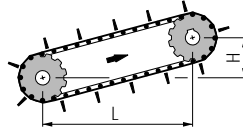
ation
s/stops
s/stops

nd

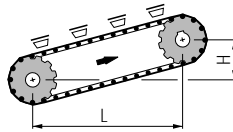
- = Chainpull (per meter width of conveyor) - N/m.
- = Weight of chain per square meter- Kg/m². See page with information of selected chain.
- = Weight of conveyed product per square meter - Kg/m².
- = Horizontal centre distance - m.
- = Coefficient of friction between chain and wearstrip. See table 1.
- = Distance between chain and conveyed product.
- = Shaft - Kw.

CHAIN
SELECTION**1 Calculation of chain pull (F)****Horizontal conveyors**

Without accumulation $F = (2W + M) \cdot L \cdot Fw \cdot 9,81$
 With accumulation $F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm)] \cdot 9,81$

Inclined conveyors with flights

$$F = [(2W + M) \cdot L \cdot Fw + (M \cdot H)] \cdot 9,81$$

Inclined conveyors without flights

Without accumulation $F = [(2W + M) \cdot L \cdot Fw + (M \cdot H)] \cdot 9,81$
 With accumulation $F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm) + (M \cdot H)] \cdot 9,81$

When the factor H/L is smaller as 0,1 the formula of horizontal conveyors is to be used.

2 Verification of chainpull

The actual chainpull F should be lower then the max. recommended chainpull Fmax, as indicated in the diagram of the page with the chain specifications.

$$F_{max} > F$$

Fmax = max. recommended chainpull - N/m. See tables on pages with chain specifications.
F = chainpull - N/m.

3 Calculation of required horsepower (P)

$$P = \frac{F \cdot K \cdot V}{60'000} \cdot SF$$

SF = Service factor
 Continuous operation 1,2
 Occasional starts/stops 1,4
 Frequent starts/stops 1,6

To obtain the required motor horsepower the efficiency of the drive system should be taken into consideration.

Legend

F = Chainpull (per meter width of conveyor) - N/m.

W = Weight of chain per square meter- Kg/m².
 See page with information of selected chain.

M = Weight of conveyed product per square meter - Kg/m².

L = Horizontal centre distance - m.

Fw = Coefficient of friction between chain and wearstrip.
 See table 1.

Ls = Length of conveyor, where accumulation occurs - m.

Fm = Coefficient of friction between chain and conveyed product.
 See table 2.

H = Vertical centre distance - m.

P = Required horsepower at conveyor drive shaft - Kw.

K = Width of chain - m.

V = Chainspeed - m/min.

Table 1 - Coefficient of friction between chain and wearstrip (Fw)

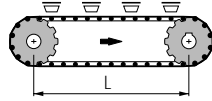
Material chain	Lubrication	Wear strip materials	
		Steel Stainless steel Fw	UHMWPE Nylatron Fw
D - AS	Dry	0,30	0,25
	Water	0,23	0,21
	Water and soap	0,15	0,15
	Oil	0,10	0,10
LF	Dry	0,25	0,20
	Water	0,20	0,18
	Water and soap	0,15	0,15
	Oil	0,10	0,10
HP - WHP	Dry	0,22	0,18
	Water	0,20	0,16
	Water and soap	0,15	0,14
	Oil	0,10	0,10
WLT - WSM	Dry	0,28	0,23
	Water	0,22	0,20
	Water and soap	0,15	0,15
	Oil	0,10	0,10
HT - WHT	Dry	0,35	0,30
	Water	0,25	0,25
	Water and soap	0,20	0,20
	Oil	0,10	0,10

Table 2 - Coefficient of friction between chain and conveyed products (Fm)

Material of conveyed products		Material and type of chain							
		LF		HP - WHP		WLT		HT - WHT	
		Solid Top Perforated Top Fm	Raised Top Fm	Solid Top Perforated Top Fm	Solid Top Perforated Top Fm	Solid Top Perforated Top Fm	Raised Top Fm	Solid Top Perforated Top Fm	Raised Top Fm
Plastic PET	Dry	0,20	0,18	0,18	0,22	0,19	0,30	0,24	
	Water	0,18	0,14	0,16	0,19	0,16	0,25	0,20	
	Water and soap	0,15	0,10	0,14	0,15	0,12	0,20	0,16	
Cardboard	Dry	0,30	0,22	0,25	0,30	0,25	0,35	0,28	
	Water	0,25	0,16	0,18	0,28	0,25	0,35	0,28	
	Water and soap	0,15	0,10	0,13	0,15	0,12	0,20	0,16	
Steel	Dry	0,20	0,13	0,18	0,22	0,20	0,28	0,22	
	Water	0,15	0,11	0,14	0,17	0,14	0,19	0,15	
	Water and soap	0,12	0,08	0,12	0,12	0,10	0,16	0,13	
Aluminium	Dry	0,15	0,12	0,14	0,18	0,14	0,22	0,20	
	Water	0,13	0,10	0,12	0,14	0,11	0,17	0,15	
	Water and soap	0,10	0,08	0,10	0,10	0,08	0,10	0,10	
Glass	Dry	0,20	0,16	0,18	0,24	0,19	0,29	0,27	
	Water	0,16	0,12	0,16	0,17	0,14	0,21	0,18	
	Water and soap	0,14	0,11	0,14	0,14	0,11	0,14	0,14	
Returnable glass bottles	Dry	0,15	0,12	0,13	0,18	0,14	0,22	0,20	
	Water	0,13	0,10	0,11	0,14	0,11	0,17	0,15	
	Water and soap	0,10	0,08	0,10	0,10	0,08	0,10	0,10	
Non returnable glass bottles	Dry	0,15	0,12	0,13	0,18	0,14	0,22	0,20	
	Water	0,13	0,10	0,11	0,14	0,11	0,17	0,15	
	Water and soap	0,10	0,08	0,10	0,10	0,08	0,10	0,10	

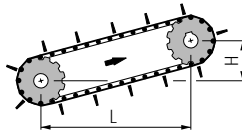
1 Calculation of chain pull (F)

Horizontal conveyors



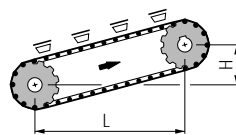
Without accumulation $F = (2W + M) \cdot L \cdot Fw \cdot 9,81$
 With accumulation $F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm)] \cdot 9,81$

Inclined conveyors with flights



$F = [(2W + M) \cdot L \cdot Fw + (M \cdot H)] \cdot 9,81$

Inclined conveyors without flights



Without accumulation $F = [(2W + M) \cdot L \cdot Fw + (M \cdot H)] \cdot 9,81$
 With accumulation $F = [(2W + M) \cdot L \cdot Fw + (M \cdot Ls \cdot Fm) + (M \cdot H)] \cdot 9,81$

When the factor H/L is smaller as 0,1 the formula of horizontal conveyors is to be used.

Legend

- F** = Chain pull (per meter width of conveyor) - N/m.
M = Weight of conveyed product per square meter - Kg/m².
L = Horizontal centre distance - m.
Fw = Coefficient of friction between chain and wearstrip.
 See table 1, page 70.
Ls = Length of conveyor, where accumulation occurs - m.
Fm = Coefficient of friction between chain and conveyed product.
 See table 2, page 70.
H = Vertical centre distance - m.
W = Weight of the chain with tension plates (indicative* or exact) - Kg/m².

* = When the exact number of tension plates is not yet calculated the following guidelines can be applied :

Width of chain	Apply
From 75 to 525 mm	No. 2 tension plates
From 525 to 1050 mm	No. 4 tension plates
From 1050 to 1575 mm	No. 6 tension plates
From 1575 to 2100 mm	No. 8 tension plates
From 2100 to 3000 mm	No. 10 tension plates

The total weight of chain W (Kg/m²) can be calculated as follows :

$W = \text{Weight of chain without tension plates (Kg/m}^2\text{)} + \text{Weight of tension plates (1 row : 0,3 Kg/m)}.$

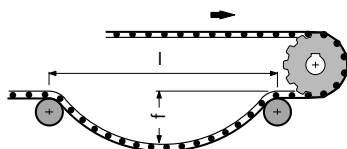
- For weight of chain without tension plates see page 44.

2 Calculation of total chain tension (Ftot)

$F_{tot} = \frac{F + F_c}{SF \cdot Kv}$

F_{tot} = Total chain tension - N/m.
F = Chain pull - N/m.
Fc = Catenary force - N/m.
SF = Service factor.
Kv = Speed factor.

Catenary force (Fc)



$F_c = \frac{l^2 \cdot W}{799 \cdot f} + \frac{W \cdot f}{102}$

Fc = Catenary force - N/m.
l = Span - mm.
W = Weight of chain - Kg/m².
f = Sag - mm.

**CHAIN
SELECTION FOR
6390-6391-6392
WITH TENSION
PLATES**

Service factor (SF)

Starting up empty, gradual increase of load	1
Starting up fully loaded (more than 1 times hour)	0,83
Elevators	0,55

Speed factor (Kv)

No. of teeth Z	Speed of chain - m/min					
	15	30	45	60	75	90
8	1,0	0,68	0,48	0,36	0,28	0,22
10	1,0	0,80	0,57	0,43	0,34	0,27
12	1,0	0,95	0,68	0,50	0,40	0,34
16	1,0	1,0	0,80	0,60	0,49	0,40

3 Calculation of number of tension plates

$\text{No. tension plates} \geq \frac{F_{tot}}{1500}$

F_{tot} = Total tension of chain - N/m.
 1500 = Recommended tension per tension plates - N.

After the exact number of tension plates has been determined and the definite number is different from the earlier made estimation, the calculation should be repeated, using the definite number of tension plates.

SHAFT
DIMENSION
CALCULATIONS

1 Calculation of chain pull (F)

See step 1, page 70.

2 Calculation of adjusted chain pull (Fadjusted)

Depending on the type of conveyor the adjusted chainpull (Fadjusted) should be calculated with the help of table 3, this value is necessary for the use of diagrams 1 - 2 - 3.

3 Determination of shaft diameter

Round shafts

The selection of shaft diameter depends on: shaft deflection, shaft bending and torsion.
For every type of load (see diagrams 1 - 2 - 3), the shaft diameter d1 - d2 - d3 should be determined using the adjusted chainpull F in relationship to the centre distances of the bearings L.
In case a third bearing is mounted, we consider this to be in the centre of the shaft.

Square shafts

The dimensions of a square shaft can be obtained by multiplying the diameter of the round shaft with the factors from table 4.

Table 4	Diagram 1 - Deflection	0,838
	Diagram 2 - Bending	0,876
	Diagram 3 - Torsion	1

4 Selection of shaft diameter

From the 3 different shaft diameters, obtained using the 3 different diagrams the largest diameter should be selected for final application.

Example From diagram 1: d1 = 48 mm.
 From diagram 2: d2 = 55 mm.
 From diagram 3: d3 = 35 mm.
 Definite selection
 d2 = 55 mm

Diagram 1 - Deflection

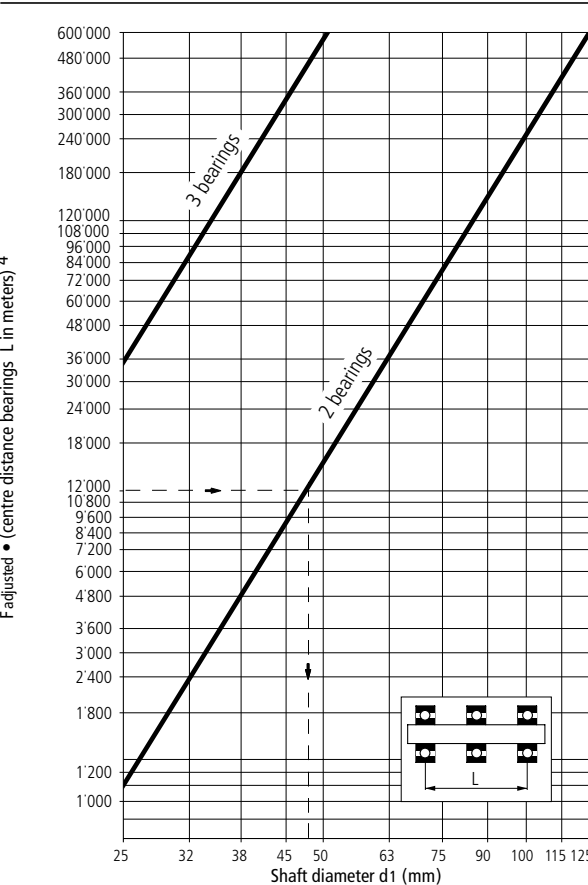


Table 3 - Adjusted chain pull Fadjusted)

Type of conveyor	Type shaft	Chainpull Fadjusted - N/m	
		Diag. 1 - Diag. 2	Diag. 3
Uni-directional 	Drive	Fadjusted = F	Fadjusted = F
	Return	Fadjusted = 2 • (W • L • Fw) • 9,81	Fadjusted = 0 no torsion
Bi-directional 	Drive	Fadjusted = 2,6 • F	Fadjusted = F
	Return	Fadjusted = 2 • F	Fadjusted = 0 no torsion
Bi-directional 	Drive	Fadjusted = F	Fadjusted = F
	Idler	Fadjusted = 1,5 • F	Fadjusted = 0 no torsion
	Return	Fadjusted = 2 • F	Fadjusted = 0 no torsion

Fig. 2 - Bending

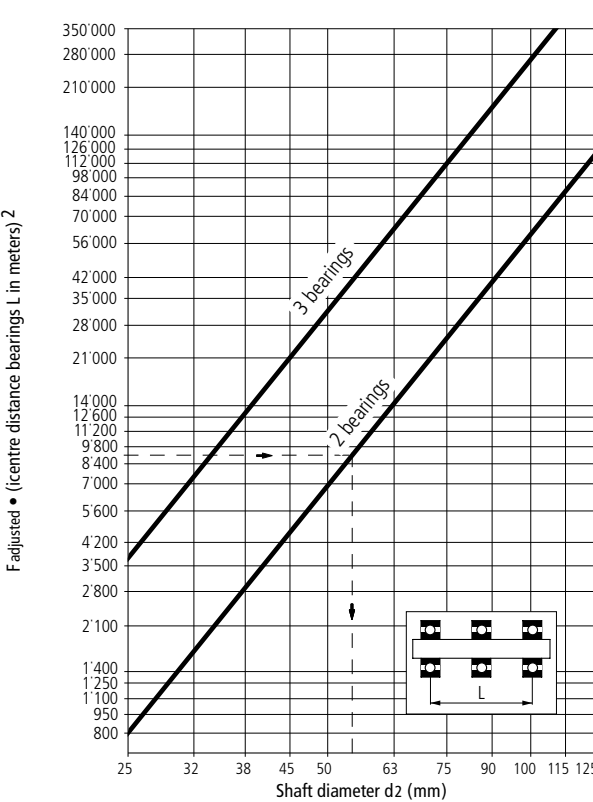
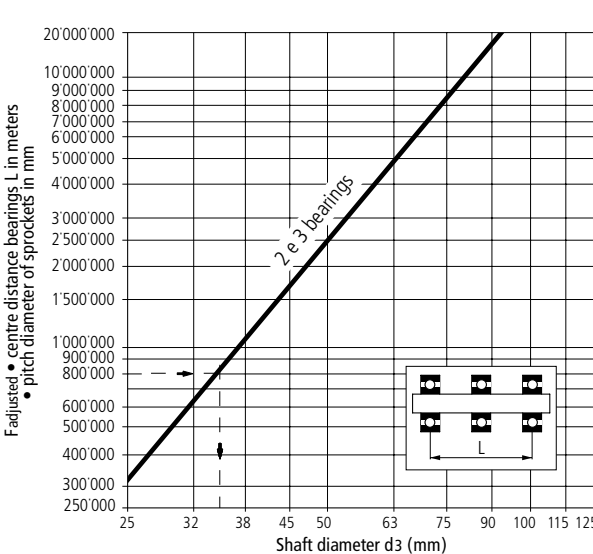


Diagram 3 - Torsion



Support for conveyors

CHAIN SUPPORT

Material characteristics

Wearstrip made from metal

A higher coefficient of friction than plastic materials.
Recommended for abrasive environments and high temperatures.

Carbon steel

It is recommended to use a cold-rolled type of steel with a surface roughness of $1,6 \div 3,2 \mu$ with a surface hardness of HRC 25 \div 30.
Lubricants must contain an anti corrosion additive
Operating temperatures:
in air (- 40 a + 180 °C)
in hot water (+ 120 °C)

Stainless steel

It is recommended to use a cold-rolled type of stainless steel with a surface roughness of $1,6 \div 3,2 \mu$ with a min. hardness of HRC 25.
Austenitic and ferritic types of stainless steel have the same wear resistance, however austenitic steel has a higher chemical resistance.
Operating temperatures:
in air (- 70 a + 400 °C)
in hot water (+ 120 °C)

Plastic wear strip material

A lower coefficient of friction compared with metal.
Simple assembly, quiet operation..
Recommendation : for polypropylene chains WHT , which are running dry, always apply plastic wear strip.

Nylatron

Polyamid with molydisulfide additive. The best solution for conveyors, which are operating without lubrication. It has a low coefficient of friction and high wear resistance. However absorbs humidity and expands.
Operating temperatures:
in air (0 a + 80 °C)
in hot water (+ 65 °C)

UHMWPE

Polyethylene with a molecular weight of 1000000. Suitable for dry and lubricated applications. Under dry conditions the wear resistance is the same as Nylatron.
No moisture absorption. Has a high chemical resistance. The rigidity is lower than for Nylatron, may deflect under elevated loads. Not recommended for abrasive applications.
Operating temperatures:
in air (- 40 a + 80 °C)
in hot water (+ 70 °C)
Coefficient of linear expansion between + 20 e 120 °C : 2×10^{-4} .

Thermal expansion and contraction

When installing parallel- or herringbone types of pattern (in Nylatron and UHMWPE) the thermal expansion and/or contraction should be considered.

$$\Delta L = L \cdot e \cdot (T - 20 \text{ °C})$$

ΔL = Variation in length, due to temperature change (mm).
L = Length of guiderail (mm).
e = Coefficient of linear expansion.
T = Operating temperature (°C).
20 °C = Temperatura ambiente.

Example

A guide rail from UHMWPE with a nominal length of L = 1000 mm, and with a linear coefficient of expansion of 2×10^{-4} , at an operating temperature of 70 °C, gives the following elongation:

$$\Delta L = 1000 \text{ mm} \cdot 0,0002 \cdot (70 \text{ °C} - 20 \text{ °C}) = 10 \text{ mm}$$

Other informations

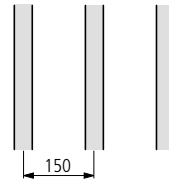
Chemical resistance: see page 86.

Coefficients of friction (Fw) : see table 1, page 70.

Systems of chain support

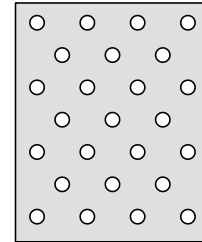
Parallel guides

Recommended for light-medium loads. Chains with a width up to 1 m. Economical solution. For uni - and bidirectional conveyors (with central drive unit).



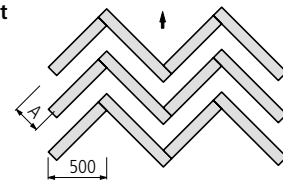
Flat bed support

Recommended for high loads. The sheet should be perforated. Material in stainless steel or Formica. Polyethylene is not suitable.



"Herringbone" type of support

For chain widths between 1÷3 meters. Uni-directional conveyors with high loads and bi-directional conveyors (with central drive unit). Accumulation tables. The wear of the chain is distributed equally over the whole width of the chain.



	Weight of conveyed product	
	100 Kg/m ²	200 Kg/m ²
Chain	A (mm)	A (mm)
1505 - 1506	250	200
2100 - 5935 - 5936 - 5935 Vacuum	200	150
4705 - 4706 - 4705 Vacuum - 5705 - 5706	250	200
4707	200	150
4803 - 4812	250	200
4809	300	250
5996 - 5997	200	150
6390 - 6391 - 6392	300	250
7705 - 7706	300	250

Types of wear strips (UHMWPE)

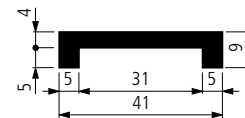
Part. 244

- H = 3 - 5.
- Colour : green.



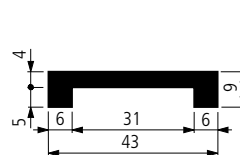
Part. 362

- Colour : green and black.



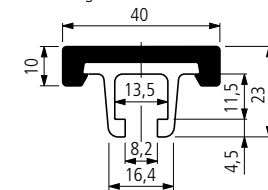
Part. 387

- Colour : black.



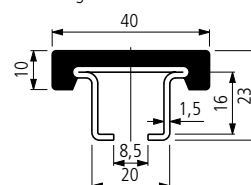
Part. 422

- Aluminium profile.
- Only for running dry.
- Colour : green.



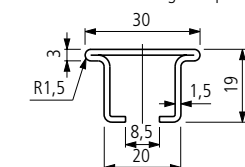
Part. 367

- Metal profile in AISI 304.
- Colour : green.



Part. 368

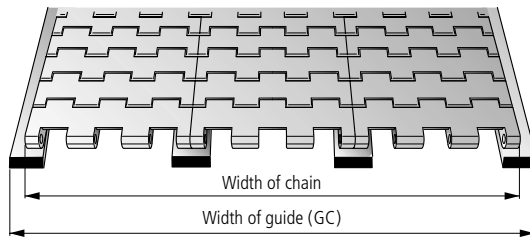
- Stainless steel AISI 304.
- Recommended for high temperature.



For additional information about the characteristics and systems of assembly see : **Marbett catalog "Conveyor Components"**

CHAIN
SUPPORT

■ Width of guide (GC)



■ Operation at ambient temperature (20°C)

$$GC = \text{Width "effective" chain} + A$$

Length of conveyor	A
Up to 10 metri	10 mm
From 10 to 15 meters	15 mm
Over 15 meters	20 mm

A = Clearance between chain and guide.

■ Operation at temperature higher than 20°C

At higher temperatures the thermal expansion of the chain must be taken into account.

$$GC = \text{Width "effective" chain} + A + \Delta K$$

Calculation of thermal expansion (ΔK)

$$\Delta K = K \cdot e \cdot (T - 20^{\circ}\text{C})$$

$$\Delta K = \text{Variation of chain width, due to temperature (mm).}$$

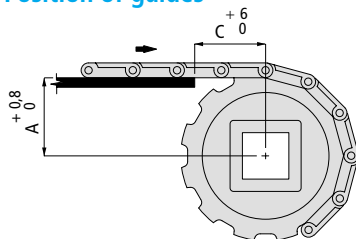
K = Effective width of chain - mm.

e = Linear coefficient of expansion (to contact our engineering dept.).

T = Operating temperature - °C.

20°C = Ambient temperature.

■ Position of guides



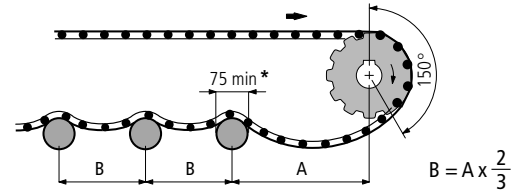
Chain	A mm	C mm
1505 - 1506	$\frac{D_p}{2} - 4,95$	15
2100	$\frac{D_p}{2} - 4,37$	25
4705 - 4706 - 4707 - 4705 vacuum 4803 - 5705 - 5706	$\frac{D_p}{2} - 6,35$	38
4812	$\frac{D_p}{2} - 5,2$	38
4809	$\frac{D_p}{2} - 7,9$	57
5935 - 5936 - 5935 vacuum 8505 - 8506	$\frac{D_p}{2} - 4,35$	19
5996 - 5997 - 5998	$\frac{D_p}{2} - 9,1$	57
6390 - 6391 - 6392	$\frac{D_p}{2} - 7,0$	50
7705 - 7706	$\frac{D_p}{2} - 6,35$	25
7956	$\frac{D_p}{2} - 6,35$	32

Dp = Pitch diameter - mm.

Support of the return of the chain

■ Guide systems

■ **Return with rollers**



* = For the chain 5997 a min. diameter of 140 mm is recommended. The radius of the rollers must be bigger as the min. backflex radius of the chain. See table 5.

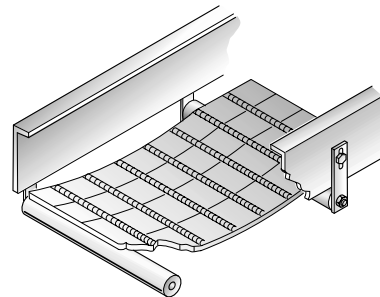
Table 5 - Min. backflex radius

Chain	Min. Radius (mm)
1505 - 1506	16
2100 - 5935 - 5936 - 5935 Vacuum - 8505 - 8506	25
4705 - 4706 - 4705 Vacuum - 5705 - 5706 - 5996 - 5998	38
4707 - 4803 - 6390 - 6391 - 6392	50
4812	75
4809	100
5997	70
7705 - 7706	30
7956	32

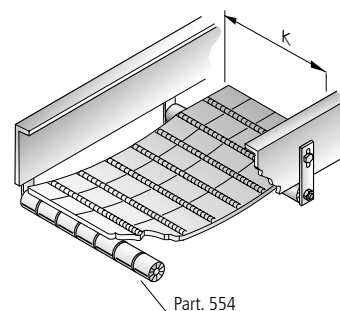
■ Return with drums, made from plastic, rubber or metal

For elevated temperatures (pasteurizers), metal rollers are recommended. In applications with products, which tend to adhere (for example sugar, etc.) fixed rollers should be used and/or frequent cleaning be applied.

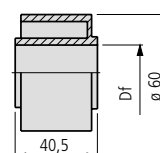
Important: to avoid chain deformation the shafts of the support rollers must have sufficient rigidity and/or be supported in the middle.



■ **Return with rollers Part. 554**



Width of chain K mm	Df mm
675	15,5
770	16,5
1000	18,5
1200	20,5



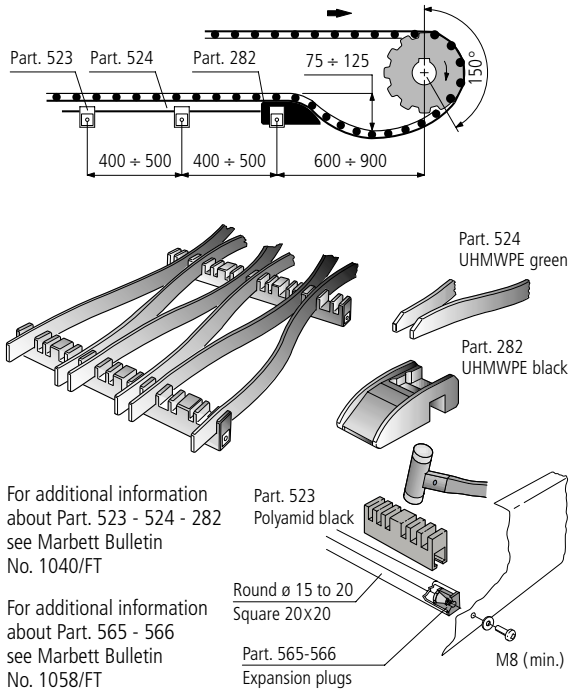
Part. 554

Material: selflubricating PA polyamid (grey).

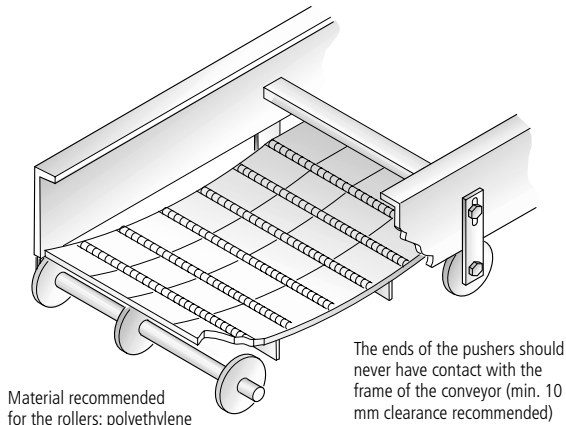
For additional information see
our catalog Marbett
"Conveyor Accessories"

■ Serpentine return

Recommended for all chains with a pitch of 38,1 mm

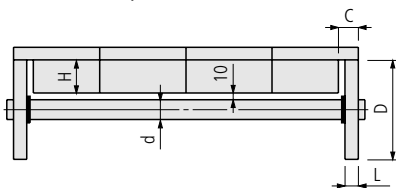


■ Support system for chains with pushers



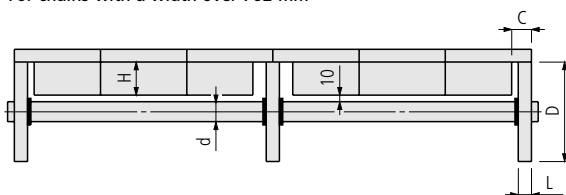
■ Return with rollers

For chains with a width up to 762 mm



■ Return with rollers

For chains with a width over 762 mm



$$D = 2 \cdot \left(H + 10 + \frac{d}{2} \right)$$

$$L = C - 5 \text{ mm}$$

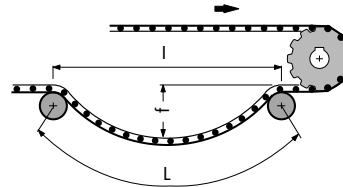
D = Diameter of roller - mm
L = Width of roller - mm
d = Shaft diameter - mm
H = Height of pusher - mm
10 = Clearance min. - mm

■ Catenary

CHAIN SUPPORT

The catenary is the length of chain in the return section, which is not supported.

The weight of this length of chain causes a tension in the chain. This tension is necessary to ensure proper engagement between chain and drive sprockets. The catenary further absorbs differences in the length of chain caused by the working load, shock loads, and thermal expansion/contraction.



Calculation of catenary force (F_c)

$$F_c = \frac{I^2 \cdot W}{799 \cdot f} + \frac{W \cdot f}{102}$$

F_c = Catenary force - N/m.
 I = Span - mm.
 W = Product weight - Kg/m².
 f = Sag - mm.

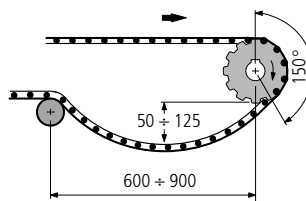
Calculation of sag (f)

$$f = \sqrt{0,375 \cdot I \cdot (L - I)}$$

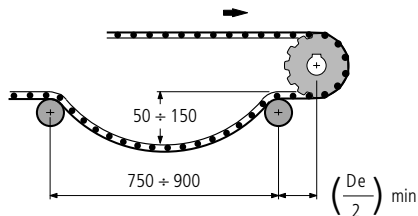
f = Sag - mm.
 I = Span - mm.
 L = Length of chain - mm.

■ Catenary for uni-directional conveyors

■ Conveyors with a centre distance up to 12 meters, and a product weight of max. 75 Kg/m².

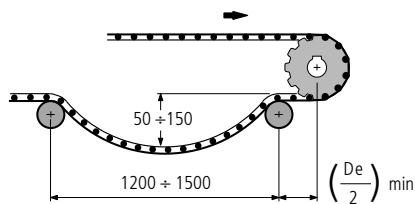


■ Conveyors with a centre distance up to 20 meters, and a product weight of max. 100 Kg/m².



D_e = Outside diameter of drive sprockets - mm

■ Conveyors with a centre distance of over 20 meters and a product weight of over 100 Kg/m².



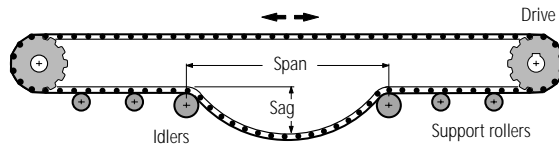
D_e = Outside diameter of drive sprockets - mm

CHAIN
SUPPORT

■ Catenary for bi-directional conveyors

■ Drive unit at the end

Conveyors with centre distances between 3 and 6 meter.
Light duty applications



Calculation of the dimensions of the catenary.

1 - Calculation of chainpull (F_{adjusted})

$F_{adjusted} = F \cdot 2$ (N/meter) Where: F = chain pull (N/m).
See step 1, page 70.

2 - Calculation of sag force (F_c)

To determine the sag force F_c, apply table 6.
As the sag force F_c in table 6, is based on a chainweight of (1Kg/m²), the F_{adjusted} must be divided by the weight of the chain (Kg/m²).
With the help of this value the required catenary information can be obtained from table 6.

For example

Given: $F_{adjusted} = 1044$ N/m
Weight of chain = 10,46 Kg/m²

The required sag force F_c will be:

$$F_c = \frac{F_{adjusted}}{\text{Weight of chain (Kg/m}^2\text{)}} = \frac{1044}{10,46} = 99,8 \text{ N}$$

Referring to table 6, the closest value to 99,8 is:

$$F_c = 95,20 \text{ N}$$

3 - Dimensions catenary

In table 6, the value of F_c = 95,20 N, corresponds with a sag 100 mm, and a span of 2750 mm.

4 - Verify if the sag force F_c is within 5% of the chain pull

For a satisfactory performance of the conveyor, the sag force F_c must be equal to F adjusted chainpull F_d (with a permissible deviation of $\pm 5\%$).

$$F_{adjusted} \pm 5\% = 1044 \pm 5\% = 992 \div 1096$$

The sag force F_c = 95,20 • 10,46 (weight of chain) = 996 N, is within the 5% permissible deviation.

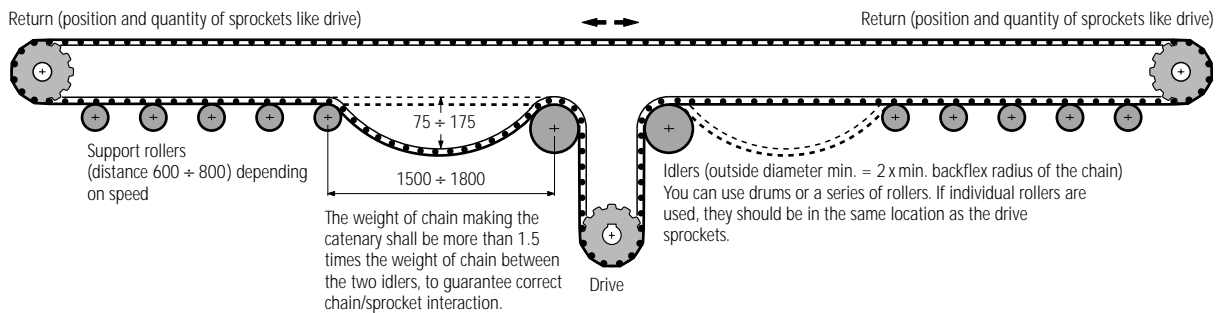
If this is not the case a bottom drive configuration must be chosen.

Table 6 - Dimensions catenary

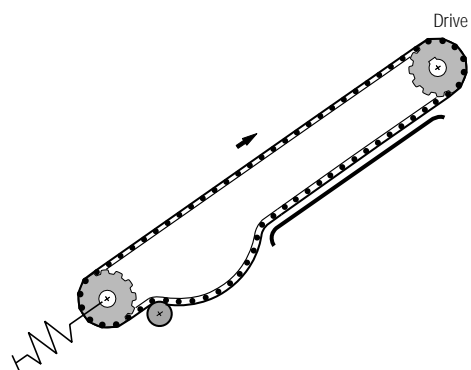
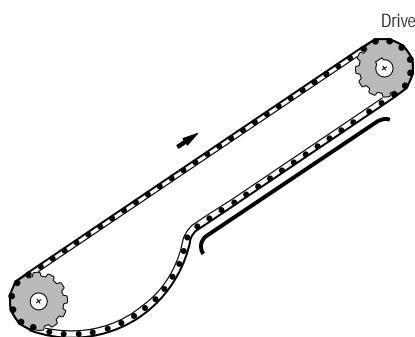
		Sag force F _c (N)									
		For chain with a weight of 1 Kg/m ²									
Span (mm)	250	1,77	1,77	1,77	2,06	2,06	2,35	2,65	2,65	3,34	
	500	4,81	4,22	3,92	3,63	3,63	3,63	3,63	3,92	3,92	
	750	10,20	10,20	6,90	6,30	5,70	5,40	5,40	5,40	5,40	
	1000	17,40	13,40	11,40	9,90	9,00	8,30	7,70	7,50	7,20	
	1250	26,70	20,40	16,80	14,30	12,90	11,70	10,80	10,20	9,60	
	1500	38,30	29,00	23,60	20,40	17,70	16,20	14,70	13,70	12,30	
	1750	52,00	39,20	31,70	27,00	23,60	21,00	19,10	17,70	15,90	
	2000	67,70	50,80	41,30	34,70	30,20	27,00	24,50	22,50	19,70	
	2250	85,30	64,10	51,80	43,80	37,80	33,60	30,20	27,90	23,90	
	2500	105,00	79,10	63,80	53,60	46,40	41,00	36,80	33,80	29,00	
	2750	127,00	95,20	76,60	64,40	55,70	49,10	44,30	40,10	34,40	
	3000	151,00	113,00	91,20	76,30	65,80	58,10	52,00	47,40	40,40	
		75	100	125	150	175	200	225	250	300	
		Chain sag (mm)									

■ Conveyors with bottom drive

Heavy duty applications.



■ Catenary for inclined conveyors



Material characteristics

Acetal (black)

Suitable for high loads. High rigidity and shock load resistance. High dimensional stability. Good resistance against humidity and chemicals.
Operating temperatures:
in air (-40 a +80°C)
in hot water (+65°C)

PA Polyamid (black)

High toughness. Optimum dimensional stability, also at relatively high temperatures. Good chemical resistance.
Operating temperatures:
in air (0 a +80°C)
in hot water (+65°C)

PA FV Polyamid reinforced (black)

Compared with polyamid PA: improved strength, rigidity and dimensional stability. Higher operating temperatures.
Operating temperatures:
in air (-5 a +120°C)
in hot water (+100°C)

PE Polyethylene (black / white)

High chemical resistance. Low coefficient of friction. Improved wear resistance. No absorption of humidity.
Operating temperatures:
in air (-40 a +80°C)
in hot water (+70°C)

Heat stabilized, reinforced Polyamid (green)

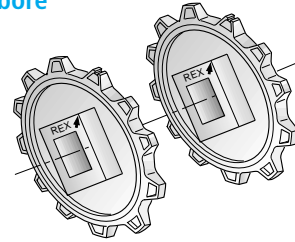
Specially formulated that resist thermal degradation from boiling water spray (i.e. rinsers, sterilizers, pasteurizers).
Operating temperatures:
in hot water (+105°C)

Operation at high- and low temperatures

SPROCKETS

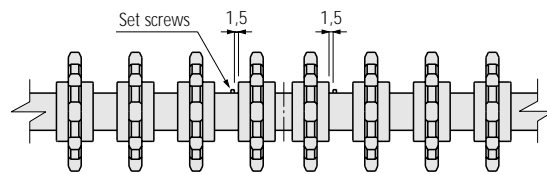
Sprockets with square bore

For these applications sprockets with square bores are recommended. It is important that the notched teeth of the sprockets are in line when installed.

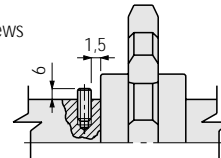


Recommendations for installation

In order to allow the width of the chain to change as a result of temperature fluctuations, secure only the centre sprockets (2 or 4), using locking screws or set collars. All other sprockets remain freely moveable on the shaft.
This applies to both the drive side and the return side.
For calculation of thermal expansion : see page 74.



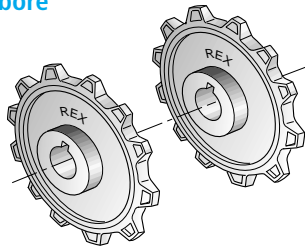
Sprocket position secured with set screws or set collars



Operation at ambient temperature (20°C)

Sprockets with round bore

Sprockets with round bores and keyways are normally recommended. When fixing the sprockets ensure that the sprocket teeth are all in line.



Recommendations for mounting

Uni-directional conveyors

Drive sprockets.

Position the sprockets as indicated on page 78÷81. All sprockets must be keyed.

Idlers.

Secure only the 2 central sprockets. The other sprockets to remain freely on the shaft.

Bi-directional conveyors "with drive unit at one end"

Sprocket position and keys the same as for uni-directional conveyors.

Bi-directional conveyors "with bottom drive unit"

Drive sprockets.

For the drive sprockets refer to the uni-directional conveyors.

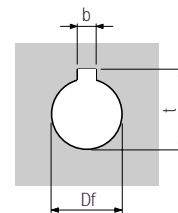
Idlers.

At least 2 sprockets must be locked, preferably those at the outside. With multiple strand conveyors the sprockets of the middle strand should be keyed.

Keyway dimensions

Dimensions according to UNI 6604-69 / ISO 773

Df mm	b mm		t mm	
	nom.	toll.	nom.	toll.
25	8		28,3	
30	8		33,3	
35	10	J 9	38,3	+ 0,2 0
40	12		43,3	
45	14		48,8	
50	14		53,8	



DRIVE SPROCKETS

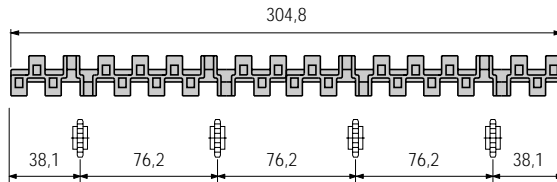
Position and quantity of sprockets

Due to the tolerances of the chain, the exact position of the sprockets must be determined after the chain has been mounted.

Chains 1505 - 1506

Number of drive and return sprockets

For every type of working load 4 sprockets for every 304,8 mm (12") of chain width.



Chains 2100

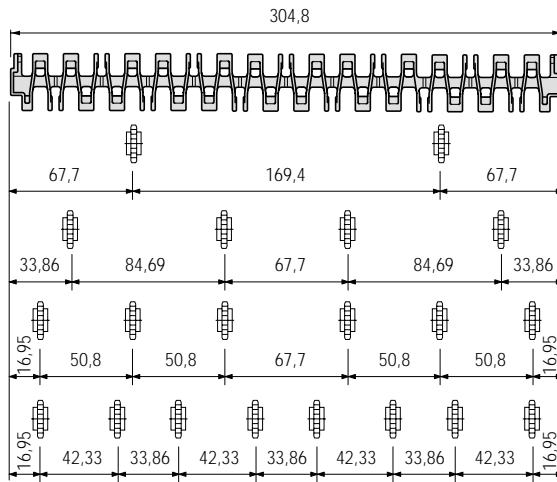
Number of drive sprockets

The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/Fmax.

Factor F/Fmax	Qty. sprockets
0, ÷ 0,25	2
0,26 ÷ 0,50	4
0,51 ÷ 0,75	6
0,76 ÷ 1,00	8

Number of return sprockets

For uni-directional conveyors 4 sprockets for every 304,8 mm of chain width.



Chains 4705 - 4706 - 4707 - 4705 vacuum

Number of drive sprockets

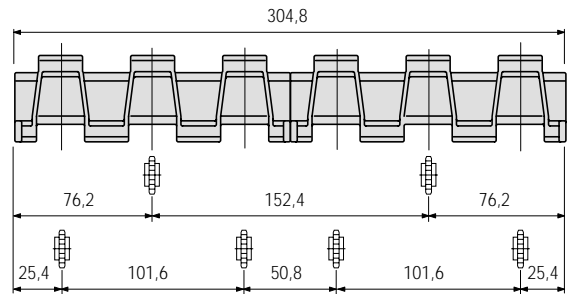
The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/Fmax.

Factor F/Fmax	Qty. sprockets
0 ÷ 0,80	2
0,81 ÷ 1,00	4

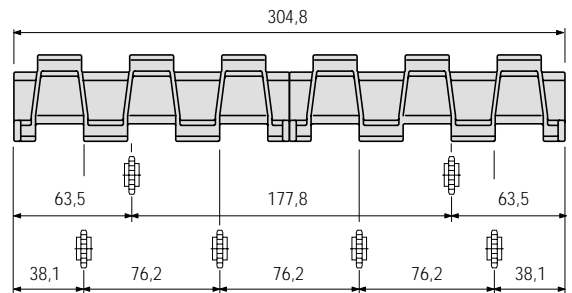
Number of return sprockets

For uni-directional conveyors 2 sprockets for every 304,8 mm of chain width.

With sprockets N 4700 - N 5700 - NS 5700 - KU 4700



With sprockets NS 4700 - KU 4700 with centre groove



Chains 4812

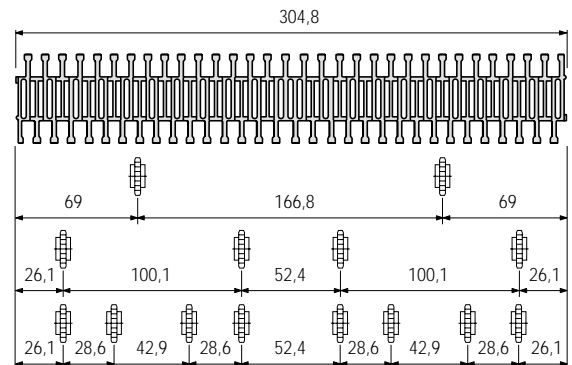
Number of drive sprockets

The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/Fmax.

Factor F/Fmax	Qty. sprockets
0 ÷ 0,25	2
0,26 ÷ 0,50	4
0,51 ÷ 1,00	8

Number of return sprockets

For uni-directional conveyors 2 sprockets for every 304,8 mm of chain width.



* F = Chain pull. See step 1, page 70

* Fmax = max. recommended chain pull. See diagram on page of selected chain.

Chains 4803

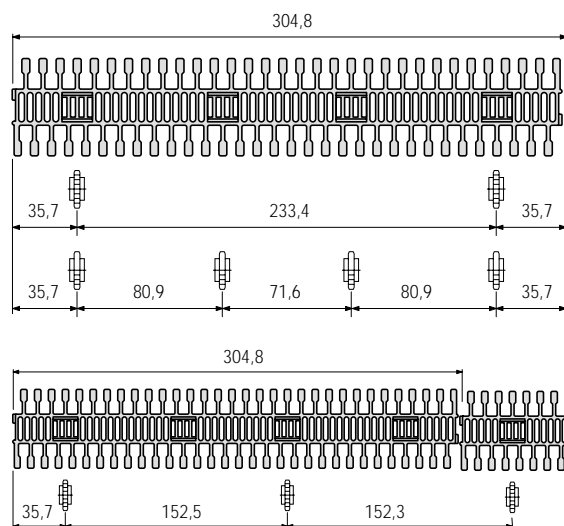
Number of drive sprockets

The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/F_{max} .

Factor $\frac{F}{F_{max}}$	Qty. sprockets
0 ÷ 0,40	2
0,41 ÷ 1,00	4

Number of return sprockets

For uni-directional conveyors 2 sprockets for every 304,8 mm of chain width.



End module. We suggest symmetrical sprocket positioning with minimum distance 152,5.

Chains 4809

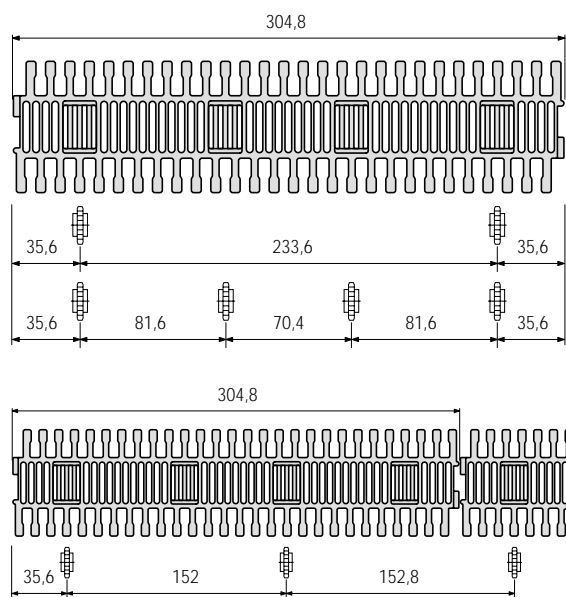
Number of drive sprockets

The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/F_{max} .

Factor $\frac{F}{F_{max}}$	Qty. sprockets
0 ÷ 0,40	2
0,41 ÷ 1,00	4

Number of return sprockets

For uni-directional conveyors 2 sprockets for every 304,8 mm of chain width.



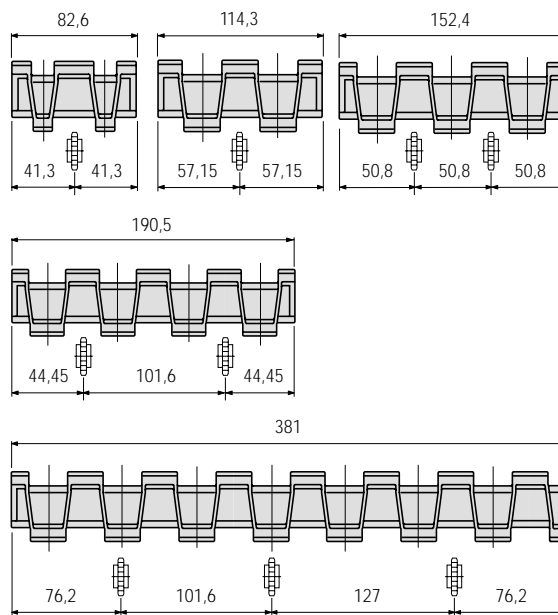
End module. We suggest symmetrical sprocket positioning with minimum distance 152.

Chains 5705 - 5706

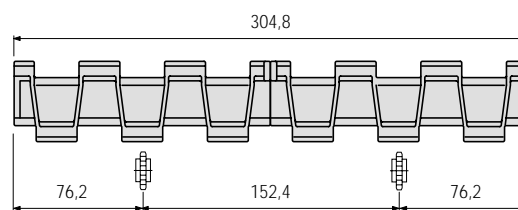
Number of drive and return sprockets

With sprockets N 4700 - NS 5700 - KU 4700

Chains with modules moulded to width



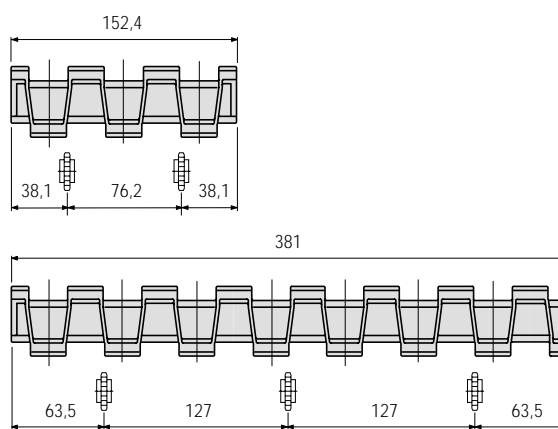
Chainwidth assembled with multi modules (brick assembly)



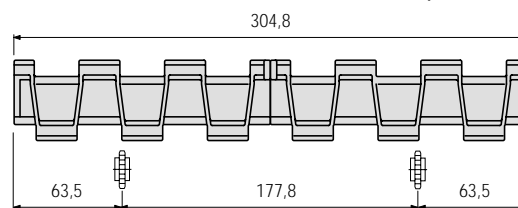
Number of drive and return sprockets

With sprockets NS 4700 - KU 4700 with centre groove

Chains with modules moulded to width



Chainwidth assembled with multi modules (brick assembly)



* F = Chain pull. See step 1, page 70

* F_{max} = max. recommended chain pull. See diagram on page of selected chain.

DRIVE
SPROCKETS

**DRIVE
SPROCKETS**

■ **Chains 5935 - 5936 - 5935 vacuum**

Number of drive sprockets

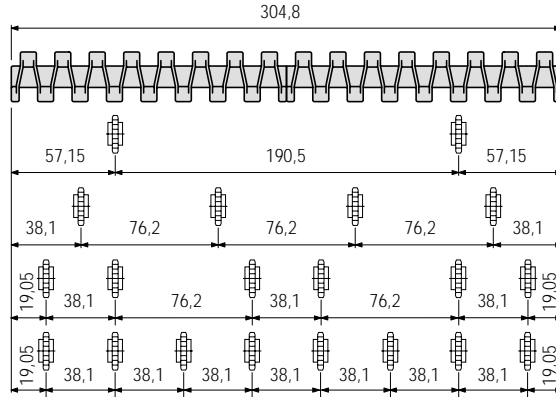
The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/Fmax.

Factor F/Fmax	*	Qty. sprockets
0 ÷ 0,25		2
0,26 ÷ 0,50		4
0,51 ÷ 0,75		6
0,76 ÷ 1,00		8

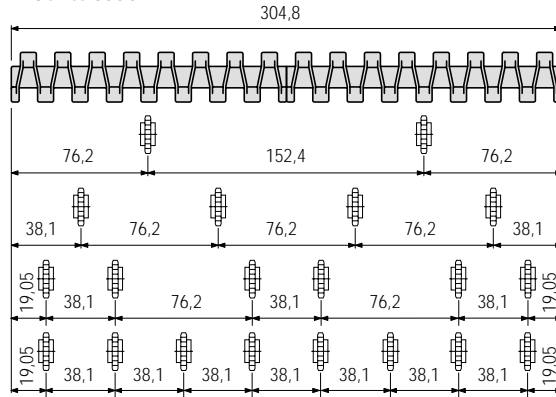
Number of return sprockets

For uni-directional conveyors 2 sprockets for every 304,8 mm of chain width.

■ **Series 5935 - 5935 vacuum**



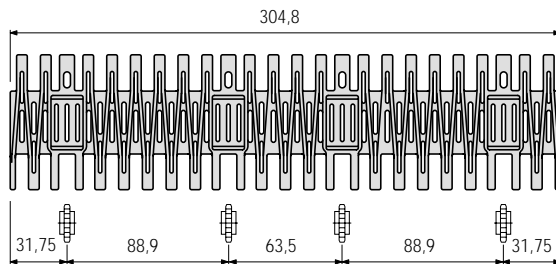
■ **Series 5936**



■ **Chains 5996 - 5997**

Number of drive and return sprockets

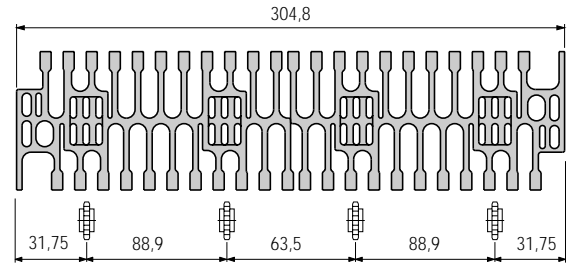
For every type of working load 4 sprockets for every 304,8 mm (12") of chain width.



■ **Chains 5998**

Number of drive and return sprockets

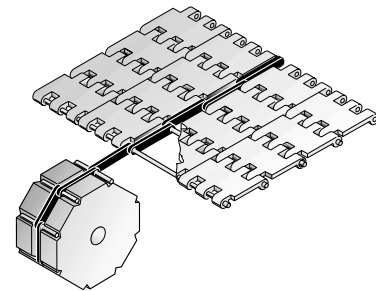
For every type of working load 4 sprockets for every 304,8 mm (12") of chain width.



■ **Chains 6390 - 6391 - 6392 with tension plates**

Number of drive and return sprockets

The sprockets (with exception of the central sprocket) must have the same position as the tension plates in the chain. The central sprocket serves as a support of the chain.



■ **Chains 6390 - 6391 - 6392 without tension plates**

Number of drive and return sprockets

For working loads up to 100% of the maximum working load the sprockets should be placed at a centre distance of 75 mm.

For working loads up to 50% of the maximum working load the sprockets should be placed at a centre distance of 150 mm.

All sprockets should be keyed on the shaft. The chain should be held in position by means of the wearstrips at the sides of the chain.

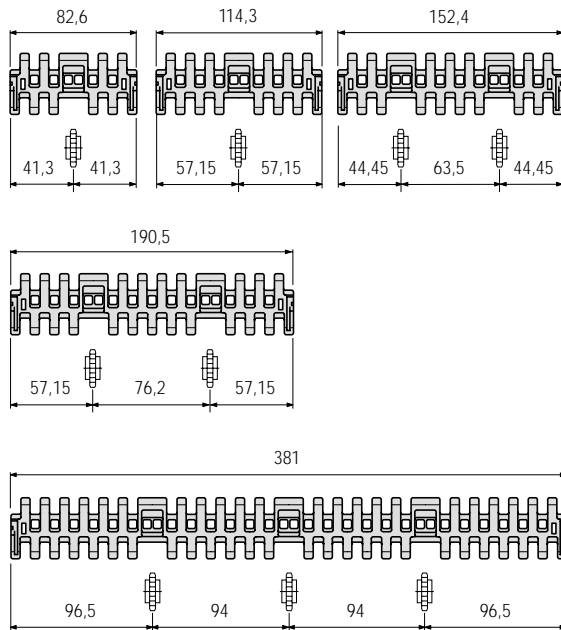
* **F** = Chain pull. See step 1, page 70

* **Fmax** = max. recommended chain pull. See diagram on page of selected chain.

Chains 7705 - 7706

Chains with modules moulded to width

Number of drive and return sprockets

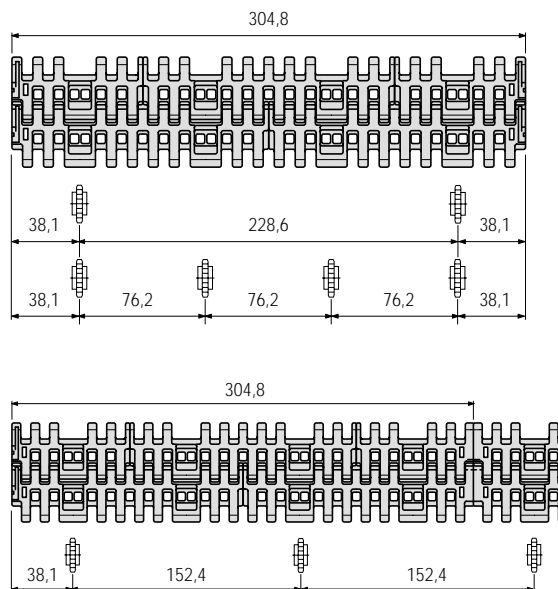


Chainwidth assembled with multi modules (brick assembly)

Number of drive and return sprockets

The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/Fmax.

Factor F/Fmax	Qty. sprockets
0 ÷ 0,50	2
0,51 ÷ 1,00	4

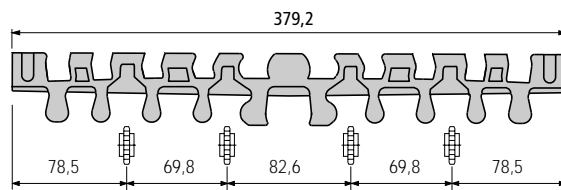


End module. We suggest simmetrical sprocket positioning with minimum distance 152,4.

Chains RexFlex® 7956

Number of drive and return sprockets

For every type of working load 4 sprockets for every 381 mm (15") of chain width.



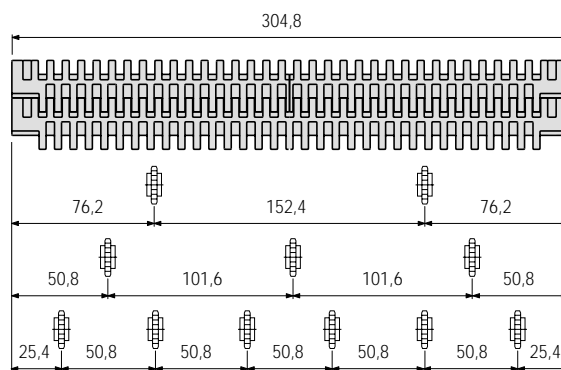
Chains 8505 - 8506

Chainwidth assembled with multi modules (brick assembly)

Number of drive and return sprockets

The drawing indicates the different positions of sprockets for every 304,8 mm (12") width of chain. The quantity varies with the factor F/Fmax.

Factor F/Fmax	Qty. sprockets
0 ÷ 0,30	2
0,31 ÷ 0,60	3
0,61 ÷ 1,00	6



* F = Chain pull. See step 1, page 70
 * Fmax = max. recommended chain pull. See diagram on page of selected chain.

TRANSFER COMBS

MATERIAL CHARACTERISTICS

LF Acetal (brown/white)

Low coefficient of friction. Wear resistant. FDA approved for direct contact with food.
Operating temperature:
in air (-40 a +80°C) / in hot water (+65°C)

Acetal (white)

Mechanical characteristics equal to LF acetal, however with a higher coefficient of friction and reduced wear resistance.
Operating temperature:
in air (-40 a +80°C) / in hot water (+65°C)

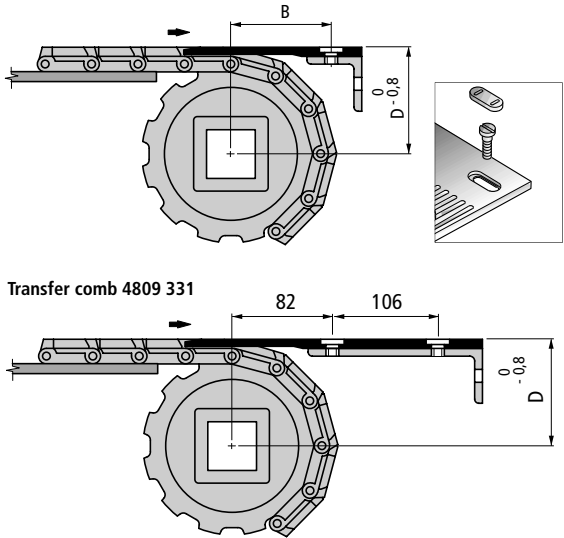
PA FV reinforced Polyamid (black)

High rigidity and dimensional stability, also at elevated temperatures. Good chemical resistance.
Operating temperature:
in air (-5 a +120°C) / in hot water (+100°C)

HT Polypropylene (beige)

Suitable for high temperatures. High chemical resistance FDA approved for contact with food.
Operating temperatures:
in air (+5 a +105°C) / in hot water (+105°C)

Transfer comb position



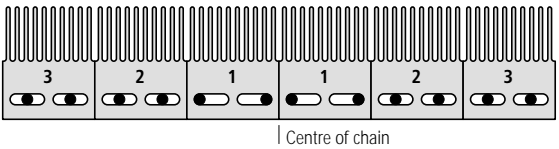
Chain	Transfer comb	B (mm)	D (mm)
4707	4707 146	82	$\frac{Dp}{2} + 12,7$
	4707 190	82	
	4707 216	82	
	4707 157 R	116	
	4707 187 R	116 to 140	
4803	4803 152	82	$\frac{Dp}{2} + 12,7$
4809	4809 221	130	$\frac{Dp}{2} + 15,9$
	4809 146	82	
	4809 216	82	
	4809 331	-	
5997	4707 146	82	$\frac{Dp}{2} + 15,5$
	4707 190	82	
	4707 216	82	
	4707 157 R	116	
	4707 187 R	116 to 140	

Dp = Pitch diameter - mm

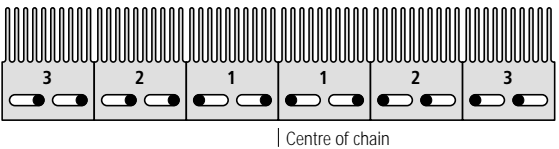
System of installation

The type of mounting transferplates depend on the operating temperatures. Transferplates must have the possibility to change lateral position in accordance with the thermal expansion/contraction of the chain as the teeth must stay between the ribs of the chain.

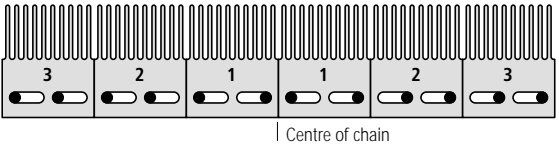
- Installation at ambient temperature (20°C). Combs 2 and 3 must have screws in the middle of the slotted holes.



- Installation at low temperature. Combs 2 and 3 compensate the contraction, caused by the low temperature.



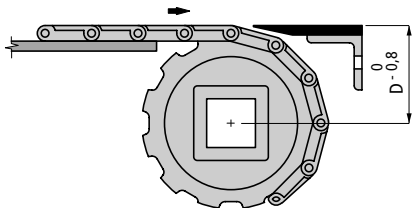
- Installation at high temperature. Combs 2 and 3 compensate the expansion, caused by the high temperature.



All transfercombs are designed to safeguard the chain. In case something comes between the Raised Rib chain and combs the combs will break.

TRANSFER PLATE

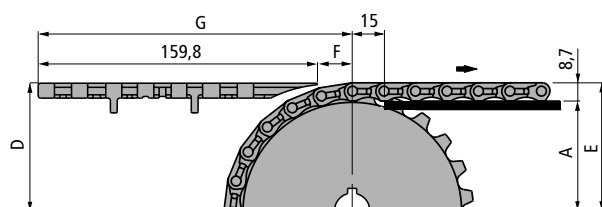
Sprocket position



Chain type	1505-1506	2100-5935 5936-8506 8506	4705-4706 5705-5706 7705-7706	4812	5996-5998	6390-6391 6392
D (mm)	$\frac{Dp}{2} + 3,75$	$\frac{Dp}{2} + 4,35$	$\frac{Dp}{2} + 6,35$	$\frac{Dp}{2} + 5,2$	$\frac{Dp}{2} + 9,1$	$\frac{Dp}{2} + 7,0$

Dp = Pitch diameter - mm

1505 Single Module Dynamic Transfer System

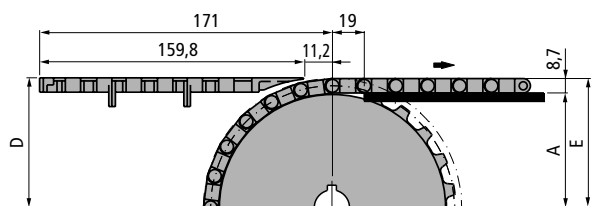


Nr. teeth Z	A mm	D mm	E mm	F mm	G mm
24	52,6	62,1	61,3	10,3	170,1
32	71,8	81,4	80,5	12,7	172,5

The values are indications only. When installing the chain adjustments should be permitted, depending on the type of conveyed product and situation.

The flights are designed to carry the product only in the area of transfer.

5936 Single Module Dynamic Transfer System

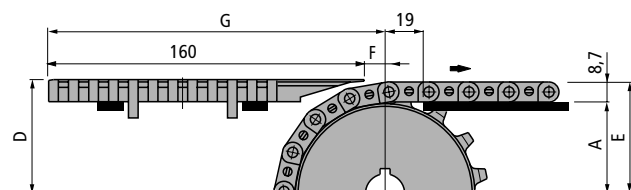


Nr. teeth Z	A mm	D mm	E mm
24	69,3	78,5	78
25	72,4	81,6	81,1

The values are indications only. When installing the chain adjustments should be permitted, depending on the type of conveyed product and situation.

The flights are designed to carry the product only in the area of transfer.

8505 Single Module Dynamic Transfer System

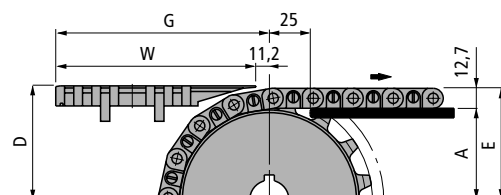


Nr. teeth Z	A mm	D mm	E mm	F mm	G mm
17	48	57,2	56,7	12	172
21	60,2	69,4	68,9	13,2	173,2
24	69,3	78,5	78	14	174
25	72,4	81,6	81,1	14,3	174,3

The values are indications only. When installing the chain adjustments should be permitted, depending on the type of conveyed product and situation.

The flights are designed to carry the product only in the area of transfer.

7705 Single Module Dynamic Transfer System



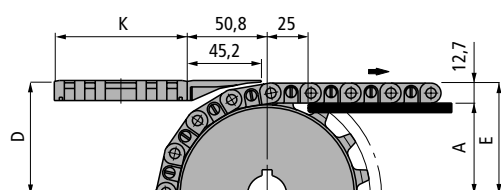
Nr. teeth Z	A mm	D mm	E mm	G mm
16	58,7	72,1	71,4	W*+11,2
18	66,8	80,2	79,5	W*+11,2
21	79	92,4	91,7	W*+11,2

The values are indications only. When installing the chain adjustments should be permitted, depending on the type of conveyed product and situation.

* = Chain widths W = 160,1 - 236,3 mm

The flights are designed to carry the product only in the area of transfer.

7700 Two-Piece Dynamic Transfer System



Nr. teeth Z	A mm	D mm	E mm
16	58,7	72,1	71,4
18	66,8	80,2	79,5
21	79	92,4	91,7

The values are indications only. When installing the chain adjustments should be permitted, depending on the type of conveyed product and situation.

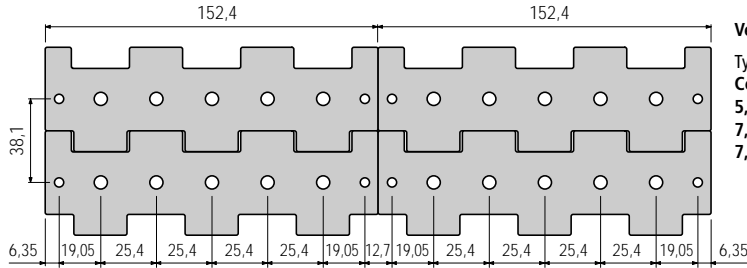
The flights are designed to carry the product only in the area of transfer.

Chain widths K = 82,6
114,3 - 152,4
190,5 - 381 mm.

VACUUM
CHAINS

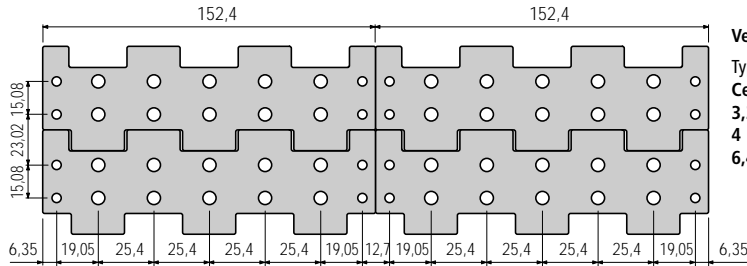
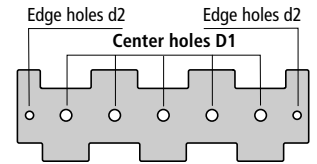
Series 4705 Vacuum

Version of hole pattern



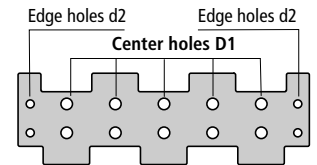
Version E7 (holes in line)

Type of holes (mm):	
Center D1	Edge d2
5,6	5,6
7,1	4,8
7,9	7,9



Version E14 (holes in line)

Type of holes (mm):	
Center D1	Edge d2
3,2	3,2
4	4
6,4	4



NOTE: Series 4705 vacuum chains are assembled with the modules in line (brick assembly is not possible).

How to order the chain

- Specify:
- Chain material
 - Chain series
 - Chain width K
 - Pin material
 - Version of hole pattern (E7 or E14)
 - Center holes diameter D1

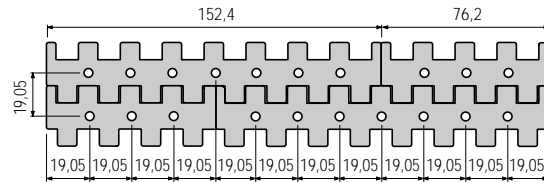
Example of codenumber:
LF 4705 K24 Acetal pin E14/3.2

Chain material	Series	K	Pin material	Version of hole pattern	Center holes diameter D1 mm	Edge holes diameter d2 mm	Open area
LF / HT	4705 Vacuum	Chain width in mm / inch (See page 57)	Acetal (black)	Version E7	5,6	5,6	5,0 %
					7,1	4,8	6,2 %
					7,9	7,9	8,1 %
				Version E14	3,2	3,2	4,0 %
					4	4	5,1 %
					6,4	4	8,4 %

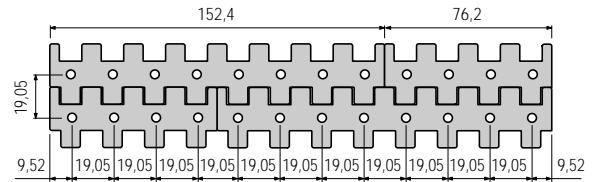
Series 5935 Vacuum

Version of hole pattern

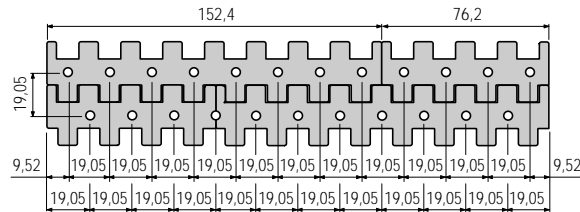
Version E7 (holes in line) Holes diameter: 3,2 - 4 - 5,1 mm.



Version E8 (holes in line) Holes diameter: 3,2 - 4 - 5,1 mm.



Version E78 (holes in "diamond" pattern) Holes diameter: 3,2 - 4 - 5,1 mm.



How to order the chain

- Specify:
- Chain material
 - Chain series
 - Chain width K
 - Pin material
 - Version of hole pattern (E7, E8 or E78)
 - Holes diameter

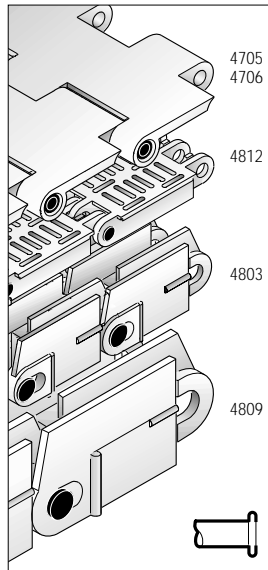
Example of codenumber:
HT 5935 K30 WHT pin E8/5.1

Chain material	Series	K	Pin material	Version of hole pattern	Holes diameter(mm)	Open area
LF / HT	5935 Vacuum	Chain width in mm / inch (See page 61)	Acetal (black) WHT polypropylene(white)	Version E7	3,2	6,9 %
					4	8,0 %
					5,1	9,9 %
				Version E8	3,2	7,2 %
					4	8,5 %
					5,1	10,6 %
				Version E78	3,2	7,1 %
					4	8,2 %
					5,1	10,3 %

Chains 4705-4706-4803-4809-4812

■ Pin retention systems

The pins are axially locked by pins with hot formed heads.



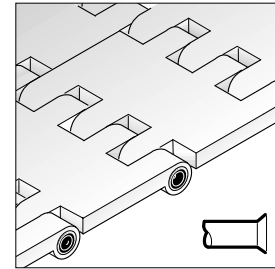
■ Replacement of modules

- 1 - With help of a drill the pin head must be removed.
- 2 - Remove the pin and replace the module in the chain. To reassemble a new pin is required.
- 3 - The pin head can be obtained by hot forming using a soldering iron.

Chains 6390-6391-6392

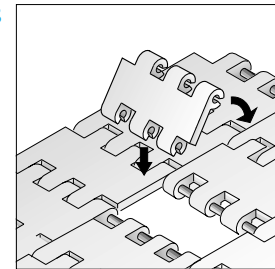
■ Pin retention system

The pins are riveted on both sides and can be used only once



■ Replacement of modules

For these chains special replacement modules are available. These modules can be inserted without disassembling the chain.

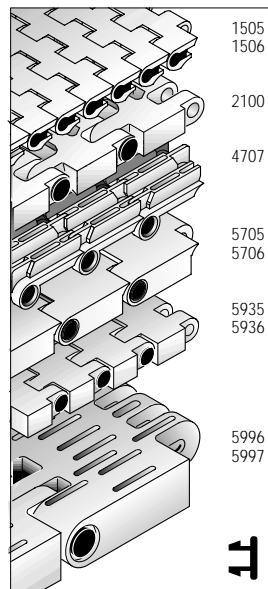


INSTALLATION
AND
MAINTENANCE
OF CHAIN

Chains 1505/6-2100-4707-5705/6-5935/6-5996/7

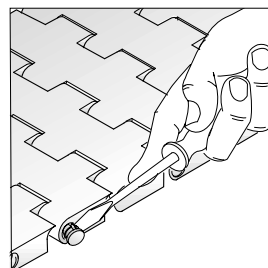
■ Pin retention system

The pins are axially locked in the modules by means of removable plugs. The chain 2100 has plugs on both sides. The other types have plugs on one side only. These plugs have a press fit. Pins can be used again.

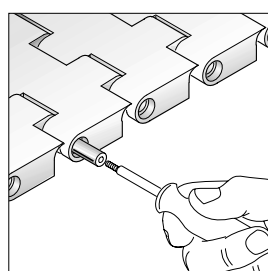


■ Replacement of modules

Use a screwdriver to remove the plug.



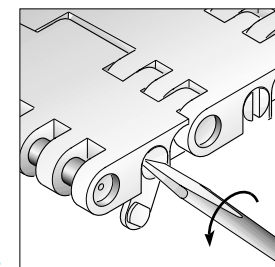
Use a special tool with selftapping tip to pull out the pin. The pins are hollow. Also a long selftapping screw can be used.



Chains 7705-7706-8505-8506

■ Pin retention system

The pins are axially locked on both sides with a rotating lock, patented by Rexnord called "Twist Lock™". This system is an integral part of the modules and cannot fall out.



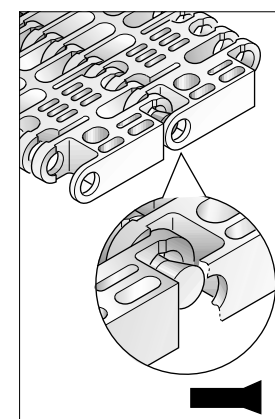
■ Replacement of modules

To pull out or insert the pin turn the Twist Lock with a screwdriver.

Chains 5998

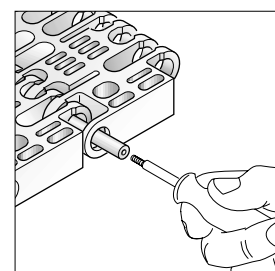
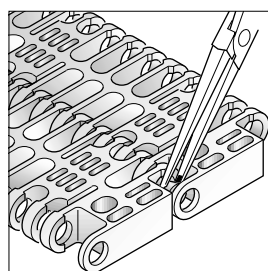
■ Pin retention system

Rex® 5998 chain features a unique pin retention design, with special plugs, therefore the pins are completely reusable.



■ Replacement of modules

To disassemble chain, grasp pin with needle nose pliers and twist to line up the pin with the offset hole.



CHEMICAL
RESISTANCE

CHEMICAL AGENT	WEARSTRIP MATERIAL					CHAIN MATERIAL				
	Steel	Stainless steel austenitic AISI 304 (18/8)	Stainless steel ferritic AISI 430	Polyamide Nylatron	Polyethylene UHMWPE	Acetal D - LF HP - WHP	Polypropylene HT - WHT	Polyethylene WLT		
	% 23°C	% 23°C	% 23°C	% 23°C	% 23°C	% 23°C	% 23°C	% 23°C	% 23°C	% 23°C
Acetone	–	50 +	50 +	100 +	+	/	+	+		+
Acetic acid	50 –	20 +	20 –	10 –	10 +	5 –	40 +	10 +		+
Ammonia	/	50 +	50 +	10 +	+	+	30 +	+		+
Aniline		3 +	3 +		3 +	3 +		3 +		+
Beer	+	+	+	+	+	+	+	+		+
Benzene	+	70 /	70 /		/	+	+	/		/
Benzol	+	+	+	100 +	/	+	/	/		/
Boric acid		100 /	100 /	10 +	+		+	+		+
Brine	–		–	/	+	/		+		+
Butter		+	+	+	+	+	+	+		+
Butyric acid	+	5 +	5 +	–	+	–		+		+
Calcium chloride		10 –	10 –	10 +	+		50 +	+		+
Carbon sulfide		+	/	100 +		+	+	+		+
Carbon tetrachloride	/	10 –	10 –	+	/	+	–	/		/
Caustic soda	–	+	+	10 +	25 +	25 –	52 +	25 +		+
Chlorinated water	–	–	–		–	–	–	–		–
Chlorine	–	–	–	–	+	–	+	+		+
Chloroform		100 +	100 /	100 –	–	–	/	–		–
Citric acid	–	5 +	5 +	10 /	+	/	10 +	+		+
Cyclohexane					–	+	–	–		–
Cupric sulfate		5 +	5 +	10 +						
Diethyl ether				100 +			+	+		
Distilled water				+	+	+	+	+		+
Ethanol		10 +	10 /	96 +		+	96 +	+		+
Ethyl chloride		+	+	100 +	/		–	/		/
Food fats		+	+	+	+			+		+
Food oils		+	+	+	+	+	+	+		+
Formaldehyde	+	100 +	100 /	30 +	/	+	40 +	/		/
Formic acid	–	5 /	5 –	10 –	10 +	10 –		10 +		+
Fresh water	–	+	+	+	+	+	+	+		+
Fruit juices	+		/	+	+	+	+	+		+
Gasoline	+	+	+	+	/	+	/	/		/
Glycerol		+	/	+	+	+	+	+		+
Hexane		+	+		–	+	+	–		–
Hydrochloric acid	2 –	–	–	10 –	37 +	37 –	30 +	37 +		+
Hydrofluoric acid		–	–	40 –	70 +		40 +	70 +		+
Hydrogen peroxide	–	30 +	30 +	3 –	+	–	30 +	+		+
Iodine	–	–	–	–	/	–	/	/		/
Lactic acid	–	5 +	5 /	10 +	+	+	20 +	+		+
Methyl alcohol		100 /	100 /	100 +		+	+			+
Methylene chloride		/		100 +	/	–	/	/		/
Mercury		100 /	100 /	+	+			+		+
Milk	+	+	+	+	+	+	+	+		+
Mineral oils	+	+	+	+	+	+	+	+		+
Nitric acid	–	10 +	10 /	10 –	5 /	5 –	+	5 /		+
Non alcoholic drinks	+	+	+	+	+	+	+	+		+
Oleic acid		100 /	100 /	100 +	/		+	/		/
Paraffin	+	+	+	+	+	+		+		+
Petroleum	+	+	+	+	–	+		–		–
Petroleum ether		+		+		+	+			+
Phosphoric acid	10 –	10 –	10 –	10 –	95 +	10 –	85 +	95 +		+
Seawater	–	+	–	+	+	/	+	+		+
Soap and water	/	+	+	+	+	+	+	+		+
Sodium carbonate		5 +	5 +	10 +	+	+	+	+		+
Sodium chloride	–	5 +	5 /	10 +	+	+	+	+		+
Sodium hydroxide	25 –	25 +	25 +	25 –	25 +	25 –	25 +	25 +		+
Sodium hypochlorite	–	–	–	+	+	–	+	+		+
Sodium sulfate		5 +	5 +	+			+			+
Stearic acid	–	+	+	+	+	/	+	+		+
Sulfuric acid	40 –	10 –	10 –	–	40 /	40 –	98 +	40 /		/
Tartaric acid		10 +	10 +	+	+	30 /	10 +	+		+
Tincture of iodine				–	+		10 +	+		+
Toluene (Toluol)	+	+	+	+	–	/	+	–		–
Trichloro-ethylene		+	+	/			/			
Turpentine		+	+		–	–		–		–
Vaseline				+	/			/		/
Vegetable juices	/	+	+	+	+	+	+	+		+
Vegetable oils	+	+	+	+	+	+	+	+		+
Vinegar	–	+	+	+	+	+	+	+		+
Whisky	+	+	/	+			+			+
Wine	+	+	+	+	+	+	+	+		+
Xylene	+	+	+	+	/	+	–	/		/

Legend
 Good = +
 resistance
 Reasonable = /
 resistance
 (limited use,
 depending
 on operating
 conditions).
 Poor = –
 resistance
 (not
 recommended
 for use).

The values
 indicated in the
 table refer to lab
 tests on unstressed
 samples. They
 should be
 considered purely
 indicative as the
 behaviour of
 materials in real
 operating
 conditions will
 depend on a
 variety of factors:
 temperature,
 concentration of
 chemical agent,
 short-term of
 continuous action
 of the chemical
 agent, etc.

The % of
 concentration is
 based on a mixture
 of the specified
 chemical agent and
 distilled water.

For additional
 information about
 materials and
 chemical agents
 please contact our
 engineering
 department.

CONVERSION
FACTORS

TO CONVERT	INTO	MULTIPLY BY
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LENGTH

Inches (in.)	Millimetres (mm)	25,4
Inches (in.)	Metres (m)	0,0254
Feet (ft.)	Millimetres (mm)	304,8
Feet (ft.)	Metres (m)	0,3048
Millimetres (mm)	Inches (in.)	0,03937
Metres (m)	Inches (in.)	39,37
Millimetres (mm)	Feet (ft.)	0,0328
Metres (m)	Feet (ft.)	3,2808

WEIGHT

Pounds (lb)	Kilograms (Kg)	0,4536
Pounds / foot ² (lb/ft ²)	Kilograms / metre ² (Kg/m ²)	4,8824
Kilograms (Kg)	Pounds (lb)	2,2046
Kilograms / metre ² (Kg/m ²)	Pounds / foot ² (lb/ft ²)	0,2048

FORCE

Newton (N)	Kilograms - force (Kgf)	0,102
Pounds - force (lb)	Newton (N)	4,448
Pounds / foot (lb/ft)	Newton / metre (N/m)	14,59
Kilograms - force (Kgf)	Newton (N)	9,807
Newton (N)	Pounds - force (lb)	0,225
Newton / metre (N/m)	Pounds / foot (lb/ft)	0,0685

POWER

Horse power (CV)	Kilowatt (kW)	0,735
Horse power (HP)	Kilowatt (kW)	0,745
Kilowatt (kW)	Horse power (CV)	1,36
Kilowatt (kW)	Horse power (HP)	1,341

SPEED

Feet / minute (ft/min)	Metres / minute (m/min)	0,3048
Metres / minute (m/min)	Feet / minute (ft/min)	3,2808

TEMPERATURE

Conversion between degrees Fahrenheit (°F) and centigrade (°C)	$^{\circ}\text{C} = \frac{5}{9} \cdot (^{\circ}\text{F} - 32^{\circ})$
Conversion between degrees centigrade (°C) and Fahrenheit (°F)	$^{\circ}\text{F} = \frac{9 \cdot ^{\circ}\text{C}}{5} + 32^{\circ}$

CLEANING

■ General informations

Without the continual cleaning action of soap and water lubrication, dirt, debris, and spilled product, such as syrup, beer, soda, etc. May build up on the chain and in the conveyor tracks. This can result in increased wear of the chain, wear strips, and sprockets. This can also cause increased container backline pressures, and even damage containers. Therefore, a thorough and regular cleaning procedure is very important to the successful operation of any dry running conveyor line.

NOTE: if conveyors are going to sit idle for a long time before start-up, they should be covered with plastic or drop cloth to minimize dirt and debris than can settle into chain and tracks.

NOTE: before start up, remove any tools, fasteners, or other items that may have been left behind. Thoroughly clean chain, wear strips, and tracks (carry & return) with air hose or high pressure water spray.

■ Recommended cleaning frequency

■ Completely dry lines

These lines should be cleaned daily to obtain maximum sanitation and performance. At the very minimum, rinse daily and thoroughly sanitize weekly.

■ Partially lubricated lines

Thoroughly sanitize these lines weekly.

■ General guidelines for cleaning solutions

1. Recommended ph of 4,5 - 9.
2. Avoid chlorine (bleach), ammonia, and iodine.
3. With plastics chain, avoid phosphoric acid (found in many stainless steel cleaners).
4. Refer to pag. 86 to the determine compatibility of cleaners used on chain and other conveyor components.

■ Methods of cleaning

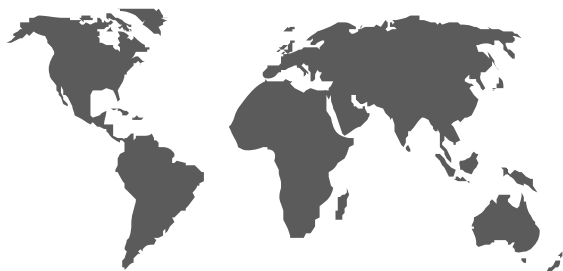
1. Periodic high pressure hot water rinse or steam cleaning should prove satisfactory. Spray the chain in place on each conveyor, both on the carry and in the return sections. This is usually done with the conveyors running, but the chain can be stationary. For easy access to the undersides of the chains in the carry and return ways, some manufacturers provide "clean-out" holes in the side frames.
2. Warm water and mild soap are commonly used to clean the conveyors.
3. Foaming agents or other chemical cleaners may be used if they are compatible with the conveyor materials (see page 86 for chemical compatibility). Carefully follow the instructions provided by the manufacturer to determine proper concentration of solutions and proper, safe use and disposal.

Note: keep water, steam, and chemicals away from electrical disconnects, motors, photo cells, etc.

4. In some cases, e.g. pet bottle lines, cleaners or combination "cleaner/lubricants" are applied continuously or intermittently. Several types of automatic application systems are available.
5. In extreme situations, it may be necessary to periodically clean the chains with a bristle brush. Clean the chain in place on the conveyor, both on the carry and in the return sections.

Note : the main objective is to clean the chain carrying surface and underside as well as the wear strips and tracks.

Note : inspect conveyors often. Remove broken or jammed containers or pieces of containers as soon as they are detected. Use cleaning solutions to clean away excessive spillage.



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