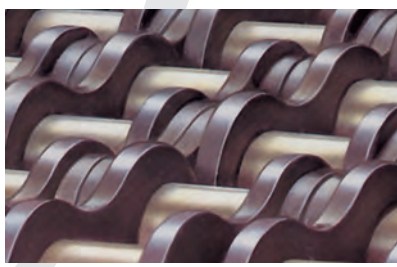
Engineered Chain | Link-Belt® Oil Field Chains

(English-Inch)

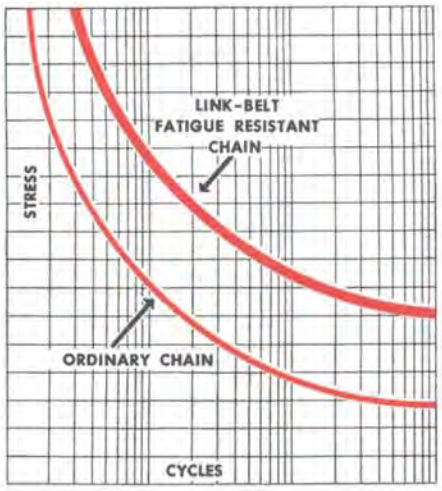
The world's most specified oil field chains – engineered for longer service life in drilling rig applications

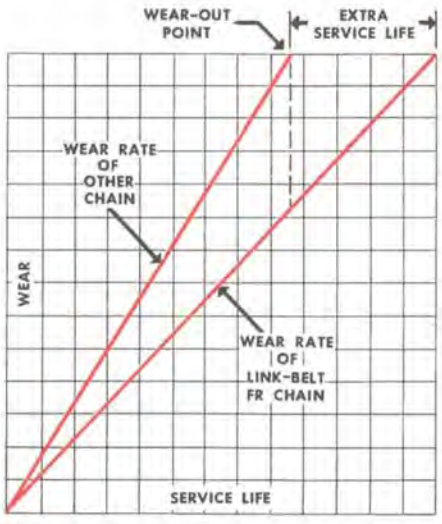


REXNORD

LINK-BELT® FR® FATIGUE RESISTANT ROLLER CHAIN

Advanced engineering and longer service life add up to a tough, reliable roller chain for the oil field industry.





Becoming the world's number one roller chain in oil field application was no accident.

After all, high productivity demands highly reliable equipment. And because Link-Belt® FR® roller chain is designed and engineered to surpass current ANSI standard requirements, it delivers performance you can count on in the harsh conditions usually encountered in the oil fields.

Wherever possible, we combine a series of cold-working operations with advanced heat-treating processes. This results in added strength and longer service life for Link-Belt roller chains – including sidebars, pins, rollers and bushings. And that translates to more load carrying capability, as well as lower cost per day of service life.

What's more, Link-Belt® FR® roller chain includes many other quality features which contribute to superior performance and ease of maintenance. Like fatigue resistant Shepherds Crook™ cotters. E-Z Assembly® design facilitates on-site coupling and uncoupling. And a proven prelubrication process substantially reduces wear during the initial operating period.

That's why, wherever wells are drilled, the first choice in roller chain is Link-Belt® FR® roller chain.

The Rexnord Corporation, Link-Belt Roller Chain Operation is licensed to use The American Petroleum Institute monogram on roller chain and transmission chain manufactured in accordance with API specification 7F.

Cold-working of pitch holes by FR® process resists sidebar fatigue.

The Link-Belt® FR® process treats the critical areas around sidebar holes where cracks most often develop. After heat-treatment, precision-ground carbide balls are pressed through the pitch holes to induce controlled residual compressive stress. This process, which helps fight fatigue, results in holes of exacting dimension with a life-extending finish and greater bearing area.

Shot-peening for extended roller life.

To help FR® roller chain resist the effects of sprocket tooth impact, each roller is shot-peened. In this process, thousands of small, specific diameter steel pellets bombard the roller surface at high velocity, cold-working the metal and increasing fatigue resistance.

Pre-stressed bearing surfaces for uniform loading.

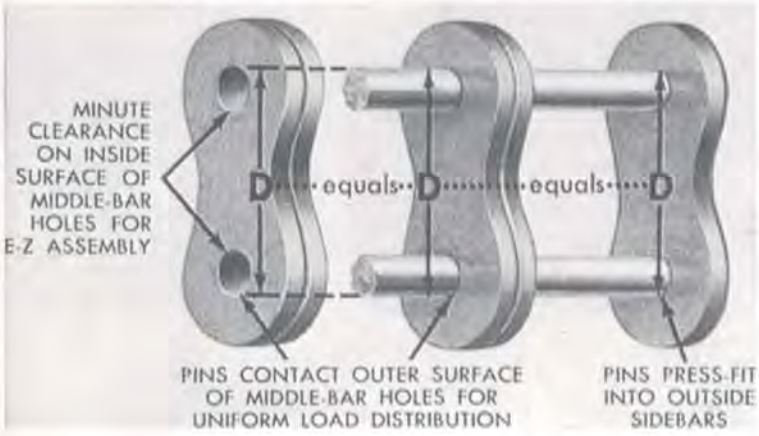
To assure uniform load distribution and minimize initial elongation, all bearing surfaces of multiple-strand Link-Belt FR roller chain are pre-stressed under precisely controlled conditions. This cold-works the joint bearing surfaces. Plus it establishes a balance of stresses throughout all chain members. Pre-stressing also imparts residual stresses to significantly improve fatigue resistance.

Precise heat-treat control for optimum uniformity and reliability.

Using advanced computer controlled furnaces, Link-Belt roller chain components undergo individually tailored heat-treating processes. This assures each component will display optimum resistance to the assaults of bending, shear, wear, impact and tensile loads. Each joint part is heat-treated to achieve precise control of through hardening or case hardness, case depth and core strength.

Each joint part is then precision ground to exacting cylindrical tolerance. The result is the industry's toughest chain with the uniformity and reliabilty that heavy-duty service demands.

HIGHER MANUFACTURING AND LUBRICATION STANDARDS.



Most bushings, rollers, rivets and pins for the Link-Belt® FR® chain are manufactured using a cold forming process. Cold forming imparts to the metal a more refined and homogeneous grain structure. Combined with specific heat-treating processes, this results in improved mechanical and fatigue properties, as well as higher wear resistance.

What's more, cold forming helps us reduce scrap and improve dimensional consistency. That eliminates the need for many secondary manufacturing operations, resulting in better components at overall lower costs to you.

As for lubrication, each oil field roller chain assembly is submerged in a hot oil bath, assuring thorough penetration of lubricant to all working surfaces and improved chain protection during storage.

Patented "E-Z Assembly®" feature speeds assembly and disassembly.

Downtime can be disastrous on a drilling rig. Which is why our exclusive "E-Z Assembly" feature rates so high with rig operators on shore and off. It's easy to cut or connect chain at any pin link. Yet there's no sacrifice in load distribution or measurable loss in performance or durability. You get full load carrying capacity across the entire width of the chain.

Exclusive "Shepherd's Crook™" cotters stay snug, last longer.

Heat-treated Shepherd's Crook cotters feature increased shear strength over standard non-heat-treated cotters. The unique contour is specifically designed to stay firmly in place. Plus, they resist fatigue failure, even under conditions of severe vibration, impact or shock.

Single Strand Chain

Multiple Strand Chain

Chain Parts

Roller link

Press-fit connecting link for RC80 and larger

Offset link

Slip-fit connecting link for chains thru RC60

Two-pitch offset assembly

! WARNING

To avoid personal injury or property damage, persons connecting or disconnecting chain and other personnel in the vicinity must:

- Always lock out equipment power switches before removing or installing chains
- Always use safety glasses to protect eyes
- Wear protective clothing, gloves and safety shoes
- Support the chain to prevent uncontrolled movement of the chain and parts
- *Maintain tools in proper condition and* assure their proper use. Use of pressing equipment is recommended
- Do not attempt to connect or disconnect chain unless chain construction is clearly known and understood, including the correct direction for pin/rivet removal or insertion
- Use subassemblies from the original *chain manufacturer only* for rework and not individual components
- Damaged chain may have been overloaded and yielded, and therefore it should not be reworked

APPLICATION OF ROLLER CHAIN

Roller chain is a versatile and efficient *means of power transmission if it is main*tained and selected properly. Its life, however, could be shortened greatly if the chain is repaired in the field and/or improperly installed. In fact, in certain maintenance and repair operations, there can be physical injury incurred by personnel if they do not follow certain safety precautions.

Although we show average ultimate strength data for roller chain in this catalog, chains are never applied at their ultimate strength. Instead, they are applied at working loads based on horsepower tables, and these are usually much less than half the ultimate strength.

Unusual operating environments and conditions, lubrication requirements, loading supports and other external influences can materially affect the proper application of the roller chains represented. It is recommended that designs and requirements be reviewed with the Rexnord Corporation, Link-Belt Chain Division, wherever roller chain applications require a high level of performance, operating conditions are difficult, or where there is a potential hazard involved in the case of a malfunction of the equipment on which the product is applied.

Rexnord Corporation, Link-Belt Chain Division, application engineering services are available to help ensure proper selection or to review any areas where users of Link-Belt roller chain may have questions or concern.

DESIGNS, DIMENSIONS AND WEIGHTS

Because we are constantly improving our products, the designs, dimensions and weights shown in our catalogs, while sufficiently accurate for most purposes, are subject to variation. When extreme accuracy is required, additional information and certification will be provided upon request, after receipt of order.

LINK-BELT® FR® OIL FIELD ROLLER CHAIN

Single and double strand chains

Chain Ordering Information

The following description of Link-Belt roller chain nomenclature will assist you when ordering.

RC 80 SU FR EW

(SU) Super Ultimate: SU series chains differ from standard roller chains in increased sidebar thickness, through hardened pin material and heat treatment. The result: greater average ultimate tensile strength ratings. Capable of withstanding higher operating and intermittent shock loading without reduction of pin bushing wear life.

(FR) Fatigue Resistant: FR series chains incorporate a series of cold working operations with advanced heat-treating processes resulting in added strength and longer service life for sidebars, pins, rollers and bushings.

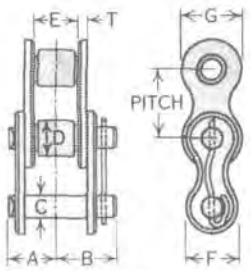
(EW) Shepherd's Crook Cotter: EW designates those chains equipped with the exclusive Link-Belt Shepherd's Crook Cotter. Uniquely engineered to stay firmly in place with increased shear strength over standard non-heat-treated cotters.

Note: Dimensions shown are typical. Consult Link-Belt engineering when applications require close tolerances.

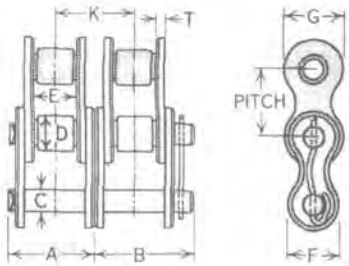
English measure

Link-Belt chain number †	Pitch, inches	Average ultimate strength, pounds	Weight per foot, pounds	Dimensions, inches								
				A	B	C	D	E	F	G	K	T
Single Strand												
RC 35*	.375	2,100	.22	.24	.32	.141	.20‡	.19	.29	.34		.05
RC 40*	.500	4,100	.41	.32	.39	.156	.31	.31	.39	.45		.06
RC 41*	.500	2,000	.27	.27	.35	.141	.31	.25	.31	.38		.05
RC 50*	.625	6,600	.66	.40	.47	.200	.40	.38	.51	.59		.08
RC 60	.750	9,100	1.03	.50	.57	.234	.47	.50	.60	.71		.09
RC 80FR EW	1.000	15,200	1.69	.63	.74	.312	.63	.63	.75	.91		.13
RC 100FR EW	1.250	26,500	2.58	.76	.89	.375	.75	.75	.97	1.13		.16
RC 120FR EW	1.500	38,100	3.75	.96	1.13	.437	.88	1.00	1.13	1.38		.19
RC 121FR EW	1.500	38,100	3.00	.83	1.00	.437	.88	.75	1.13	1.38		.19
RC 140FR EW	1.750	50,000	4.66	1.02	1.21	.500	1.00	1.00	1.31	1.56		.22
RC 160FR EW	2.000	68,500	6.50	1.23	1.41	.562	1.13	1.25	1.56	1.81		.25
RC 180FR EW	2.250	86,000	9.06	1.39	1.56	.687	1.41	1.41	1.75	2.06		.28
RC 200FR	2.500	106,000	11.10	1.54	1.89	.781	1.56	1.50	1.94	2.31		.31
RC 240FR	3.000	132,200	16.70	1.85	2.20	.937	1.88	1.88	2.44	2.81		.38
RC 60H	.750	9,600	1.20	.56	.64	.234	.47	.50	.60	.71		.13
RC 80SUFR EW	1.000	17,500	1.90	.69	.81	.312	.63	.63	.75	.91		.16
RC 100SUFR EW	1.250	29,000	2.80	.83	.95	.375	.75	.75	.97	1.13		.19
RC 120SUFR EW	1.500	41,000	4.00	1.02	1.19	.437	.88	1.00	1.13	1.38		.22
RC 140SUFR EW	1.750	56,000	5.40	1.08	1.27	.500	1.00	1.00	1.31	1.56		.25
RC 160SUFR EW	2.000	70,000	7.00	1.29	1.47	.562	1.13	1.25	1.56	1.81		.28
RC 264SUFR	2.500	115,000	12.40	1.67	2.01	.875	1.56	1.50	1.94	2.31		.38
Double Strand												
RC 35-2*	.375	4,200	.43	.43	.51	.141	.20‡	.19	.29	.34	.399	.05
RC 40-2*	.500	8,200	.80	.60	.67	.156	.31	.31	.39	.45	.566	.06
RC 50-2*	.625	13,200	1.29	.76	.83	.200	.40	.38	.51	.59	.713	.08
RC 60-2*	.750	18,200	2.02	.94	1.03	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-2	1.000	30,400	3.32	1.21	1.30	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-2	1.250	53,000	5.09	1.46	1.59	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-2	1.500	76,200	7.40	1.84	2.02	.437	.88	1.00	1.13	1.38	1.789	.19
RC 121FR EW-2	1.500	76,200	6.00	1.60	1.77	.437	.88	.75	1.13	1.38	1.539	.19
RC 140FR EW-2	1.750	100,000	9.20	1.98	2.17	.500	1.00	1.00	1.31	1.56	1.924	.22
RC 160FR EW-2	2.000	137,000	12.85	2.38	2.56	.562	1.13	1.25	1.56	1.81	2.305	.25
RC 180FR EW-2	2.250	172,000	17.97	2.69	2.86	.687	1.41	1.41	1.75	2.06	2.592	.28
RC 200FR-2	2.500	212,000	21.81	2.96	3.31	.781	1.56	1.50	1.94	2.31	2.817	.31
RC 240FR-2	3.000	264,400	33.04	3.58	3.93	.937	1.88	1.88	2.44	2.81	3.458	.38
RC 60H-2	.750	19,200	2.40	1.07	1.15	.234	.47	.50	.60	.71	1.028	.13
RC 80SUFR EW-2	1.000	35,000	3.80	1.34	1.43	.312	.63	.63	.75	.91	1.283	.16
RC 100SUFR EW-2	1.250	58,000	5.60	1.59	1.72	.375	.75	.75	.97	1.13	1.539	.19
RC 120SUFR EW-2	1.500	82,000	8.00	1.97	2.16	.437	.88	1.00	1.13	1.38	1.924	.22
RC 140SUFR EW-2	1.750	112,000	10.80	2.11	2.30	.500	1.00	1.00	1.31	1.56	2.055	.25
RC 160SUFR EW-2	2.000	140,000	14.00	2.50	2.68	.562	1.13	1.25	1.56	1.81	2.436	.28
RC 264SUFR-2	2.500	270,000	24.80	3.22	3.57	.866	1.56	1.50	1.94	2.31	3.083	.38

* Furnished in riveted type only. ‡ Rollerless chain. Dimension shown is bushing diameter.
† All chains normally carried in stock are cottered type unless otherwise noted. Riveted chains also available.



Single strand



Double strand

Metric measure

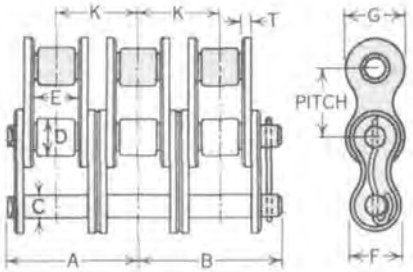
Link-Belt chain number †	Pitch, millimeters	Average ultimate strength, newtons	Weight per meter, kilograms	Dimensions, millimeters								
				A	B	C	D	E	F	G	K	T
Single Strand												
RC 35*	9.53	9,341	.3	6.1	8.1	3.58	5.1‡	4.8	7.4	8.6	....	1.3
RC 40*	12.70	18,238	.6	8.1	9.9	3.96	7.9	7.9	9.9	11.4	....	1.5
RC 41*	12.70	8,896	.4	6.9	8.9	3.58	7.9	6.4	7.9	9.7	....	1.3
RC 50*	15.88	29,358	1.0	10.2	11.9	5.08	10.2	9.7	13.0	15.0	....	2.0
RC 60	19.05	40,479	1.5	12.7	14.5	5.94	11.9	12.7	15.2	18.0	....	2.3
RC 80FR EW	25.40	67,613	2.5	16.0	18.8	7.93	16.0	16.0	19.1	23.1	....	3.3
RC 100FR EW	31.75	117,878	3.8	19.3	22.6	9.53	19.1	19.1	24.6	28.7	....	4.1
RC 120FR EW	38.10	169,477	5.6	24.4	28.7	11.10	22.4	25.4	28.7	35.1	....	4.8
RC 121FR EW	38.10	169,477	4.5	21.1	25.4	11.10	22.4	19.1	28.7	35.1	....	4.8
RC 140FR EW	44.45	222,411	6.9	25.9	30.7	12.70	25.4	25.4	33.3	39.6	....	5.6
RC 160FR EW	50.80	304,703	9.7	31.2	35.8	14.28	28.7	31.8	39.6	46.0	....	6.4
RC 180FR EW	57.15	382,547	13.5	35.3	39.6	17.45	35.8	35.8	44.5	52.3	....	7.1
RC 200FR	63.50	471,512	16.5	39.1	48.0	19.84	39.6	38.1	49.3	58.7	....	7.9
RC 240FR	76.20	588,055	24.9	47.0	55.9	23.80	47.8	47.8	62.0	71.4	....	9.7
RC 60H	19.05	42,703	1.8	14.2	16.3	5.94	11.9	12.7	15.2	18.0	....	3.3
RC 80SUFR EW	25.40	77,844	2.8	17.5	20.6	7.93	16.0	16.0	19.1	23.1	....	4.1
RC 100SUFR EW	31.75	128,998	4.2	21.1	24.1	9.53	19.1	19.1	24.6	28.7	....	4.8
RC 120SUFR EW	38.10	182,377	6.0	25.9	30.2	11.10	22.4	25.4	28.7	35.1	....	5.6
RC 140SUFR EW	44.45	249,100	8.0	27.4	32.3	12.70	25.4	25.4	33.3	39.6	....	6.4
RC 160SUFR EW	50.80	311,376	10.4	32.8	37.3	14.28	28.7	31.8	39.6	46.0	....	7.1
RC 264SUFR	63.50	600,510	18.5	42.4	51.1	22.00	39.6	38.1	49.3	58.7	....	9.7
Double Strand												
RC 35-2*	9.53	18,682	.6	10.9	13.0	3.58	5.1‡	4.8	7.4	8.6	10.14	1.3
RC 40-2*	12.70	36,475	1.2	15.2	17.0	3.96	7.9	7.9	9.9	11.4	14.38	1.5
RC 50-2*	15.88	58,717	1.9	19.3	21.1	5.08	10.2	9.7	13.0	15.0	18.11	2.0
RC 60-2*	19.05	80,958	3.0	23.9	26.2	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-2	25.40	135,226	4.9	30.7	33.0	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-2	31.75	235,756	7.6	37.1	40.4	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-2	38.10	338,955	11.0	46.7	51.3	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 121FR EW-2	38.10	338,955	8.9	40.6	45.0	11.10	22.4	19.1	28.7	35.1	39.09	4.8
RC 140FR EW-2	44.45	444,822	13.7	50.3	55.1	12.70	25.4	25.4	33.3	39.6	48.87	5.6
RC 160FR EW-2	50.80	609,406	19.1	60.5	65.0	14.28	28.7	31.8	39.6	46.0	58.55	6.4
RC 180FR EW-2	57.15	765,094	26.7	68.3	72.6	17.45	35.8	35.8	44.5	52.3	65.84	7.1
RC 200FR-2	63.50	943,023	32.5	75.2	84.1	19.84	39.6	38.1	49.3	58.7	71.55	7.9
RC 240FR-2	76.20	1,176,110	49.2	90.9	99.8	23.80	47.8	47.8	62.0	71.4	87.83	9.7
RC 60H-2	19.05	85,406	3.6	27.2	29.2	5.94	11.9	12.7	15.2	18.0	26.11	3.3
RC 80SUFR EW-2	25.40	155,688	5.7	34.0	36.3	7.93	16.0	16.0	19.1	23.1	32.84	4.1
RC 100SUFR EW-2	31.75	257,997	8.3	40.4	43.7	9.53	19.1	19.1	24.6	28.7	39.09	4.8
RC 120SUFR EW-2	38.10	364,754	11.9	50.0	54.9	11.10	22.4	25.4	28.7	35.1	48.87	5.6
RC 140SUFR EW-2	44.45	498,201	16.1	53.6	58.4	12.70	25.4	25.4	33.3	39.6	52.20	6.4
RC 160SUFR EW-2	50.80	622,751	20.8	63.5	68.1	14.28	28.7	31.8	39.6	46.0	61.87	7.1
RC 264SUFR-2	63.50	1,201,020	36.9	81.8	90.7	22.00	39.6	38.1	49.3	58.7	78.31	9.7

* Furnished in riveted type only. ‡ Rollerless chain. Dimension shown is bushing diameter.
† All chains normally carried in stock are cottered type unless otherwise noted. Riveted chains also available.

LINK-BELT® FR® OIL FIELD ROLLER CHAIN

Triple and quadruple strand chains

Note: Dimensions shown are typical. Consult Link-Belt engineering when applications require close tolerances.

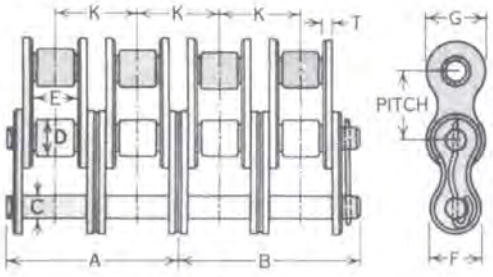


Triple strand

English measure

Link-Belt chain number †	Pitch, inches	Average ultimate strength, pounds	Weight per foot, pounds	Dimensions, inches								
				A	B	C	D	E	F	G	K	T
Triple Strand												
RC 35-3*	.375	6,300	.64	.63	.71	.141	.20‡	.19	.29	.34	.399	.05
RC 40-3*	.500	12,300	1.19	.89	.95	.156	.31	.31	.39	.45	.566	.06
RC 50-3*	.625	19,800	1.91	1.12	1.19	.200	.40	.38	.51	.59	.713	.08
RC 60-3	.750	27,300	3.02	1.39	1.47	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-3	1.000	45,600	4.95	1.78	1.87	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-3	1.250	79,500	7.61	2.16	2.29	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-3	1.500	114,300	11.05	2.74	2.91	.437	.88	1.00	1.13	1.38	1.789	.19
RC 121FR EW-3	1.500	114,300	9.00	2.37	2.53	.437	.88	.75	1.13	1.38	1.539	.19
RC 140FR EW-3	1.750	150,000	13.75	2.94	3.13	.500	1.00	1.00	1.31	1.56	1.924	.22
RC 160FR EW-3	2.000	205,500	19.20	3.52	3.71	.562	1.13	1.25	1.56	1.81	2.305	.25
RC 180FR EW-3	2.250	258,000	26.88	3.98	4.15	.687	1.41	1.41	1.75	2.06	2.592	.28
RC 200FR-3	2.500	318,000	32.51	4.38	4.73	.781	1.56	1.50	1.94	2.31	2.817	.31
RC 240FR-3	3.000	396,600	49.37	5.31	5.65	.937	1.88	1.88	2.44	2.81	3.458	.38
RC 60H-3	.750	28,800	3.60	1.57	1.65	.234	.47	.50	.60	.71	1.028	.13
RC 80SUFR EW-3	1.000	52,500	5.70	1.97	2.06	.312	.63	.63	.75	.91	1.283	.16
RC 100SUFR EW-3	1.250	87,000	8.40	2.36	2.49	.375	.75	.75	.97	1.13	1.539	.19
RC 120SUFR EW-3	1.500	123,000	12.00	2.94	3.11	.437	.88	1.00	1.13	1.38	1.924	.22
RC 140SUFR EW-3	1.750	168,000	16.20	3.13	3.32	.500	1.00	1.00	1.31	1.56	2.055	.25
RC 160SUFR EW-3	2.000	210,000	21.00	3.71	3.89	.562	1.13	1.25	1.56	1.81	2.436	.28
RC 264SUFR-3	2.500	405,000	37.20	4.78	5.12	.866	1.56	1.50	1.94	2.31	3.083	.38
Quadruple Strand												
RC 35-4*	.375	8,400	.85	.83	.91	.141	.20‡	.19	.29	.34	.399	.05
RC 40-4*	.500	16,400	1.58	1.17	1.23	.156	.31	.31	.39	.45	.566	.06
RC 50-4*	.625	26,400	2.53	1.47	1.54	.200	.40	.38	.51	.59	.713	.08
RC 60-4	.750	36,400	4.02	1.84	1.92	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-4	1.000	60,800	6.58	2.35	2.44	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-4	1.250	106,000	10.13	2.86	2.99	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-4	1.500	152,400	14.70	3.63	3.81	.437	.88	1.00	1.13	1.38	1.789	.19
RC 121FR EW-4	1.500	152,400	12.00	3.14	3.30	.437	.88	.75	1.13	1.38	1.539	.19
RC 140FR EW-4	1.750	200,000	18.28	3.90	4.09	.500	1.00	1.00	1.31	1.56	1.924	.22
RC 160FR EW-4	2.000	274,000	25.55	4.67	4.86	.562	1.13	1.25	1.56	1.81	2.305	.25
RC 180FR EW-4	2.250	344,000	35.79	5.28	5.45	.687	1.41	1.41	1.75	2.06	2.592	.28
RC 200FR-4	2.500	424,000	43.21	5.80	6.14	.781	1.56	1.50	1.94	2.31	2.817	.31
RC 240FR-4	3.000	528,800	65.70	7.04	7.38	.937	1.88	1.88	2.44	2.81	3.458	.38
RC 60H-4	.750	38,400	4.80	2.08	2.16	.234	.47	.50	.60	.71	1.028	.13
RC 80SUFR EW-4	1.000	70,000	7.60	2.61	2.70	.312	.63	.63	.75	.91	1.283	.16
RC 100SUFR EW-4	1.250	116,000	11.20	3.13	3.26	.375	.75	.75	.97	1.13	1.539	.19
RC 120SUFR EW-4	1.500	164,000	16.00	3.90	4.07	.437	.88	1.00	1.13	1.38	1.924	.22
RC 140SUFR EW-4	1.750	224,000	21.60	4.15	4.34	.500	1.00	1.00	1.31	1.56	2.055	.25
RC 160SUFR EW-4	2.000	280,000	28.00	4.92	5.11	.562	1.13	1.25	1.56	1.81	2.436	.28
RC 264SUFR-4	2.500	540,000	49.60	6.33	6.67	.866	1.56	1.50	1.94	2.31	3.083	.38

* Furnished in riveted type only. ‡ Rollerless chain. Dimension shown is bushing diameter.
† All chains normally carried in stock are cottered type unless otherwise noted. Riveted chains also available.



Quadruple strand

Metric measure

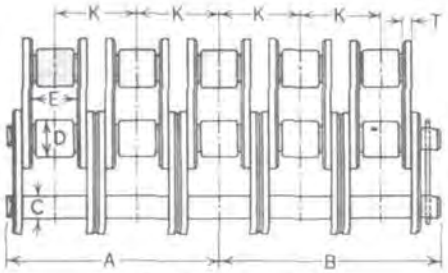
Link-Belt chain number †	Pitch, millimeters	Average ultimate strength, newtons	Weight per meter, kilograms	Dimensions, millimeters								
				A	B	C	D	E	F	G	K	T
Triple Strand												
RC 35-3*	9.53	28,022	1.0	16.0	18.0	3.58	5.1‡	4.8	7.4	8.6	10.14	1.3
RC 40-3*	12.70	54,713	1.8	22.6	24.1	3.96	7.9	7.9	9.9	11.4	14.38	1.5
RC 50-3*	15.88	88,075	2.8	28.5	30.2	5.08	10.2	9.7	13.0	15.0	18.11	2.0
RC 60-3	19.05	121,436	4.5	35.3	37.3	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-3	25.40	202,839	7.4	45.2	47.5	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-3	31.75	353,634	11.3	54.9	58.2	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-3	38.10	508,432	16.4	69.6	73.9	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 121FR EW-3	38.10	508,432	13.4	60.2	64.3	11.10	22.4	19.1	28.7	35.1	39.09	4.8
RC 140FR EW-3	44.45	667,233	20.5	74.7	79.5	12.70	25.4	25.4	33.3	39.6	48.87	5.6
RC 160FR EW-3	50.80	914,410	28.6	89.4	94.2	14.28	28.7	31.8	39.6	46.0	58.55	6.4
RC 180FR EW-3	57.15	1,147,641	40.0	101.1	105.4	17.45	35.8	35.8	44.5	52.3	65.84	7.1
RC 200FR-3	63.50	1,414,535	48.4	111.3	120.1	19.84	39.6	38.1	49.3	58.7	71.55	7.9
RC 240FR-3	76.20	1,764,165	73.5	134.9	143.5	23.80	47.8	47.8	62.0	71.4	87.83	9.7
RC 60H-3	19.05	128,109	5.4	39.9	41.9	5.94	11.9	12.7	15.2	18.0	26.11	3.3
RC 80SUFR EW-3	25.40	233,532	8.5	50.0	52.3	7.93	16.0	16.0	19.1	23.1	32.84	4.1
RC 100SUFR EW-3	31.75	386,955	12.5	59.9	63.3	9.53	19.1	19.1	24.6	28.7	39.09	4.8
RC 120SUFR EW-3	38.10	547,131	17.9	74.7	79.0	11.10	22.4	25.4	28.7	35.1	48.87	5.6
RC 140SUFR EW-3	44.45	747,301	24.1	79.5	84.3	12.70	25.4	25.4	33.3	39.6	52.20	6.4
RC 160SUFR EW-3	50.80	934,127	31.3	94.2	98.8	14.28	28.7	31.8	39.6	46.0	61.87	7.1
RC 264SUFR-3	63.50	1,801,530	55.4	121.4	130.1	22.00	39.6	38.1	49.3	58.7	78.31	9.7
Quadruple Strand												
RC 35-4*	9.53	37,363	1.3	21.1	23.1	3.58	5.1‡	4.8	7.4	8.6	10.14	1.3
RC 40-4*	12.70	72,951	2.4	29.7	31.2	3.96	7.9	7.9	9.9	11.4	14.38	1.5
RC 50-4*	15.88	117,433	3.8	37.3	39.1	5.08	10.2	9.7	13.0	15.0	18.11	2.0
RC 60-4	19.05	161,915	6.0	46.7	48.8	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-4	25.40	270,452	9.8	59.7	62.0	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-4	31.75	471,512	15.1	72.6	76.0	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-4	38.10	677,909	21.9	92.2	96.8	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 121FR EW-4	38.10	677,909	17.9	79.8	83.8	11.10	22.4	19.1	28.7	35.1	39.09	4.8
RC 140FR EW-4	44.45	889,644	27.2	99.1	103.9	12.70	25.4	25.4	33.3	39.6	48.87	5.6
RC 160FR EW-4	50.80	1,218,833	38.0	118.6	123.4	14.28	28.7	31.8	39.6	46.0	58.55	6.4
RC 180FR EW-4	57.15	1,530,188	53.3	134.1	138.4	17.45	35.8	35.8	44.5	52.3	65.84	7.1
RC 200FR-4	63.50	1,886,046	64.3	147.3	156.0	19.84	39.6	38.1	49.3	58.7	71.55	7.9
RC 240FR-4	75.20	2,352,220	97.8	178.8	187.5	23.80	47.8	47.8	62.0	71.4	87.83	9.7
RC 60H-4	19.05	170,812	7.1	52.8	54.9	5.94	11.9	12.7	15.2	18.0	26.11	3.3
RC 80SUFR EW-4	25.40	311,376	11.3	66.3	68.6	7.93	16.0	16.0	19.1	23.1	32.84	4.1
RC 100SUFR EW-4	31.75	515,994	16.7	79.5	82.8	9.53	19.1	19.1	24.6	28.7	39.09	4.8
RC 120SUFR EW-4	38.10	729,508	23.8	99.1	103.4	11.10	22.4	25.4	28.7	35.1	48.87	5.6
RC 140SUFR EW-4	44.45	996,402	32.1	105.4	110.2	12.70	25.4	25.4	33.3	39.6	52.20	6.4
RC 160SUFR EW-4	50.80	1,245,502	41.7	125.0	130.0	14.28	28.7	31.8	39.6	46.0	61.87	7.1
RC 264SUFR-4	63.50	2,402,040	73.8	160.8	169.4	22.00	39.6	38.1	49.3	58.7	78.31	9.7

* Furnished in riveted type only. ‡ Rollerless chain. Dimension shown is bushing diameter.
† All chains normally carried in stock are cottered type unless otherwise noted. Riveted chains also available.

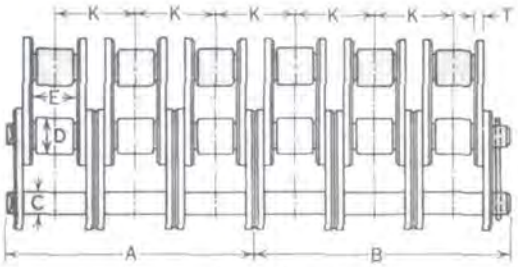
LINK-BELT® FR® OIL FIELD ROLLER CHAIN

Quintuple, sextuple, and octuple strand chains

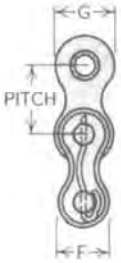
Note: Dimensions shown are typical. Consult Link-Belt engineering when applications require close tolerances.



Quintuple strand



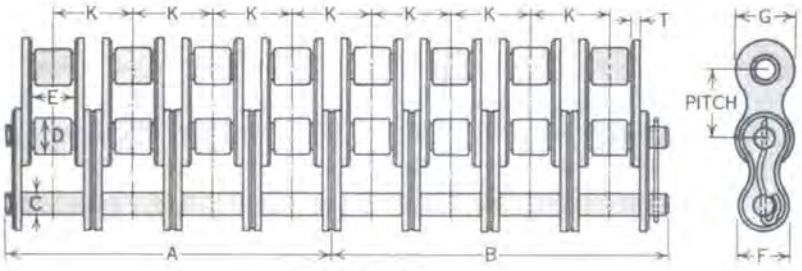
Sextuple strand



English measure

Link-Belt chain number †	Pitch, inches	Average ultimate strength, pounds	Weight per foot, pounds	Dimensions, inches								
				A	B	C	D	E	F	G	K	T
Quintuple Strand												
RC 60-5	.750	45,500	5.02	2.28	2.36	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-5	1.000	76,000	8.21	2.92	3.03	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-5	1.250	132,500	12.65	3.56	3.69	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-5	1.500	190,500	18.35	4.52	4.70	.437	.88	1.00	1.13	1.38	1.789	.19
RC 140FR EW-5	1.750	250,000	22.85	4.86	5.05	.500	1.00	1.00	1.31	1.56	1.924	.22
RC 160FR EW-5	2.000	342,500	31.90	5.82	6.00	.562	1.13	1.25	1.56	1.81	2.305	.25
RC 120 SUFR EW-5	1.500	205,500	20.00	4.86	5.03	.437	.88	1.00	1.13	1.38	1.924	.22
Sextuple Strand												
RC 60-6	.750	54,600	6.02	2.69	2.85	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-6	1.000	91,200	9.84	3.50	3.61	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-6	1.250	159,000	15.17	4.26	4.39	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-6	1.500	228,600	22.00	5.42	5.59	.437	.88	1.00	1.13	1.38	1.789	.19
RC 121FR EW-6	*1.500*	*228,600*	*18.00*	4.68	4.83	.437	.88	.75	*1.13*	1.38	1.539	.19
RC 140FR EW-6	1.750	300,000	27.40	5.82	6.01	.500	1.00	1.00	1.31	1.56	1.924	.22
RC 160FR EW-6	2.000	411,000	38.25	6.97	7.15	.562	1.13	1.25	1.56	1.81	2.305	.25
RC 120SUFR EW-6	1.500	246,000	24.00	5.81	6.00	.437	.88	1.00	1.13	1.38	1.924	.22
RC 140SUFR EW-6	1.750	336,000	32.40	6.20	6.39	.500	1.00	1.00	1.31	1.56	2.055	.25
RC 160SUFR EW-6	2.000	420,000	42.00	7.35	7.54	.562	1.13	1.25	1.56	1.81	2.436	.28
Octuple Strand												
RC 60-8	.750	72,800	8.30	3.62	3.70	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-8	1.000	121,600	13.50	4.65	4.71	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-8	1.250	212,000	21.60	5.66	5.79	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-8	1.500	304,800	29.80	7.20	7.38	.437	.88	1.00	1.13	1.38	1.789	.19
RC 140FR EW-8	1.750	400,000	37.20	7.74	7.95	.500	1.00	1.00	1.31	1.56	1.924	.22
RC 160FR EW-8	2.000	548,000	50.50	9.28	9.45	.562	1.13	1.25	1.56	1.81	2.305	.25
RC 120SUFR EW-8	1.500	328,000	32.00	7.74	7.93	.437	.88	1.00	1.13	1.38	1.924	.22
RC 140SUFR EW-8	1.750	448,000	43.20	8.25	8.44	.500	1.00	1.00	1.31	1.56	2.055	.25
RC 160SUFR EW-8	2.000	560,000	56.00	9.78	9.98	.562	1.13	1.25	1.56	1.81	2.436	.28

† All chains normally carried in stock are cottered type. Riveted chains also available.



Octuple strand

Metric measure

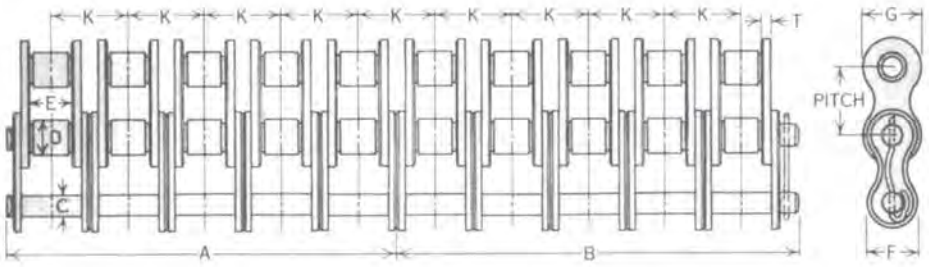
Link-Belt chain number †	Pitch, millimeters	Average ultimate strength, newtons	Weight per meter, kilograms	Dimensions, millimeters								
				A	B	C	D	E	F	G	K	T
Quintuple Strand												
RC 60-5	19.05	202,394	7.5	57.9	59.9	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-5	25.40	338,065	12.2	74.2	77.0	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-5	31.75	589,389	18.8	90.4	93.7	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-5	38.10	847,386	27.3	114.8	119.4	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 140FR EW-5	44.45	1,112,056	34.0	123.4	128.3	12.70	25.4	25.4	33.3	39.6	48.87	5.6
RC 160FR EW-5	50.80	1,523,516	47.5	147.8	152.4	14.28	28.7	31.8	39.6	46.0	58.55	6.4
RC 120SUFR EW-5	38.10	911,886	29.8	123.4	127.8	11.10	22.4	25.4	28.7	35.1	48.87	5.6
Sextuple Strand												
RC 60-6	19.05	242,873	9.0	68.3	72.4	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-6	25.40	405,678	14.6	88.9	91.7	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-6	31.75	707,267	22.6	108.2	111.5	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-6	38.10	1,016,864	32.7	137.7	142.0	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 121FR EW-6	38.10	1,016,864	26.8	118.9	122.7	11.10	22.4	19.1	28.7	35.1	39.09	4.8
RC 140FR EW-6	44.45	1,334,467	40.8	147.8	152.7	12.70	25.4	25.4	33.3	39.6	48.87	5.6
RC 160FR EW-6	50.80	1,828,219	56.9	177.0	181.6	14.28	28.7	31.8	39.6	46.0	58.55	6.4
RC 120SUFR EW-6	38.10	1,094,263	35.7	147.6	152.4	11.10	22.4	25.4	28.7	35.1	48.87	5.6
RC 140SUFR EW-6	44.45	1,494,603	48.2	157.5	162.3	12.70	25.4	25.4	33.3	39.6	52.20	6.4
RC 160SUFR EW-6	50.80	1,868,253	62.5	186.7	191.5	14.28	28.7	31.8	39.6	46.0	61.87	7.1
Octuple Strand												
RC 60-8	19.05	323,831	12.4	92.0	94.0	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-8	25.40	540,904	20.1	118.1	119.6	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-8	31.75	943,023	32.1	143.8	147.1	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-8	38.10	1,355,818	44.3	182.9	187.5	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 140FR EW-8	44.45	1,779,289	55.4	196.6	201.9	12.70	25.4	25.4	33.3	39.6	48.87	5.6
RC 160FR EW-8	50.80	2,437,626	75.1	235.7	240.0	14.28	28.7	31.8	39.6	46.0	58.55	6.4
RC 120SUFR EW-8	38.10	1,459,017	47.6	196.6	201.4	11.10	22.4	25.4	28.7	35.1	48.87	5.6
RC 140SUFR EW-8	44.45	1,992,803	64.3	209.6	214.4	12.70	25.4	25.4	33.3	39.6	52.20	6.4
RC 160SUFR EW-8	50.80	2,491,004	83.3	248.4	253.5	14.28	28.7	31.8	39.6	46.0	61.87	7.1

† All chains normally carried in stock are cottered type. Riveted chains also available.

LINK-BELT® FR® OIL FIELD ROLLER CHAIN

Decuple strand chain

Note: Dimensions shown are typical. Consult Link-Belt engineering when applications require close tolerances.



English measure

Link-Belt chain number †	Pitch, inches	Average ultimate strength, pounds	Weight per foot, pounds	Dimensions, inches								
				A	B	C	D	E	F	G	K	T
RC 60-10	.750	91,000	10.60	4.52	4.60	.234	.47	.50	.60	.71	.897	.09
RC 80FR EW-10	1.000	152,000	17.20	5.81	5.87	.312	.63	.63	.75	.91	1.153	.13
RC 100FR EW-10	1.250	265,000	26.10	7.07	7.20	.375	.75	.75	.97	1.13	1.408	.16
RC 120FR EW-10	1.500	381,000	37.60	8.99	9.16	.437	.88	1.00	1.13	1.38	1.789	.19
RC 140FR EW-10	1.750	500,000	47.00	9.67	9.85	.500	1.00	1.00	1.31	1.56	1.924	.22

† All chains normally carried in stock are cottered type. Riveted chains also available.

Metric measure

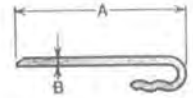
Link-Belt chain number †	Pitch, millimeters	Average ultimate strength, newtons	Weight per meter, kilograms	Dimensions, millimeters								
				A	B	C	D	E	F	G	K	T
RC 60-10	19.05	404,788	15.8	114.8	116.8	5.94	11.9	12.7	15.2	18.0	22.78	2.3
RC 80FR EW-10	25.40	676,130	25.6	147.6	149.1	7.93	16.0	16.0	19.1	23.1	29.29	3.3
RC 100FR EW-10	31.75	1,178,779	38.8	179.6	182.9	9.53	19.1	19.1	24.6	28.7	35.76	4.1
RC 120FR EW-10	38.10	1,694,773	56.0	228.4	232.7	11.10	22.4	25.4	28.7	35.1	45.44	4.8
RC 140FR EW-10	44.45	2,224,111	69.9	245.6	250.2	12.70	25.4	25.4	33.3	39.6	48.87	5.6

† All chains normally carried in stock are cottered type. Riveted chains also available.

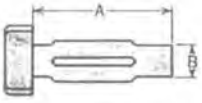
Cotters for FR oil field roller chain

Link-Belt chain number △		Type of cotter	Cotter number	Dimensions, inches		Dimensions, millimeters	
				A	B	A	B
RC 60	RC 60H	3		.38	.08	9.7	2.0
RC 80FR EW	RC 80SUFR EW	1	13 EH	1.63	.09	41.4	2.3
RC 100FR EW	RC 100SUFR EW	1	9 EH	2.00	.09	50.8	2.3
RC 120FR EW	RC 120SUFR EW	1	10 EH	2.25	.12	57.2	3.1
RC 121FR EW		1	10 EH	2.25	.12	57.2	3.1
RC 140FR EW	RC 140SUFR EW	1	11 EH	2.63	.12	66.8	3.1
RC 160FR EW	RC 160SUFR EW	1	12 EH	2.91	.15	73.9	3.8
RC 200FR		2	73 AD	1.25	.31	31.8	7.9
RC 240FR		2	73 AD	1.25	.31	31.8	7.9
RC 264SUFR		2	73 AD	1.25	.31	31.8	7.9

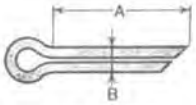
△ Smaller chain sizes are furnished in riveted type only.



SHEPHERD'S CROOK COTTER
TYPE 1



GROOVE PIN COTTER
TYPE 2



SPLIT COTTER
TYPE 3

CHAIN DRIVE LUBRICATION

Lubrication is the most important factor influencing the chain life of a properly designed and installed chain drive. Adequate lubrication can extend the life of a chain many times. Not just the quantity of oil, but the pressure and location of oil spray pipes or nozzles is also important.

To effectively lubricate the chain joints, oil must be directed to the clearances indicated in Fig. 7305 so it can reach all the bearing surfaces in the joint. Oil delivered at position B, Fig. 7302, will be most effective in reaching the bearing surfaces.

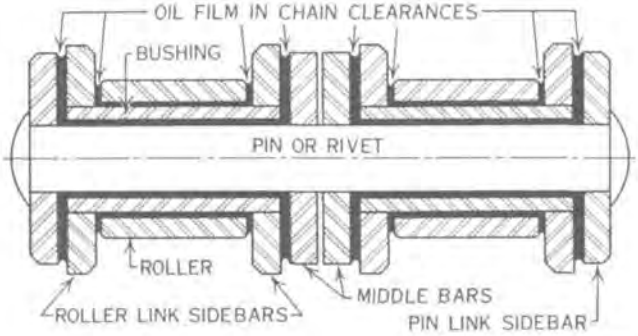


Fig. 7305

Methods of Lubrication

There are three basic methods for lubricating chain: (1) manual or drip, (2) oil-bath (splash) or slinger disc, and (3) pump or forced. Drip or splash lubrication is applicable to some relatively slow running drives found on oil field equipment. For example, the life of some drum drive and other chains on small drilling rigs, which in the past have been manually lubricated, has been extended by the application of drip or oil-bath lubrication. The majority of oil field chain drives are high speed or high load, or a combination of both, and oil pump lubrication is required.

Insufficient Lubrication

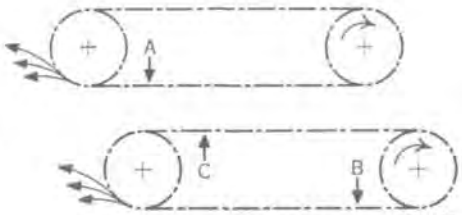
Although it is frequently difficult to measure the exact amount of oil reaching the chain, and to observe the actual oil spray in the area of the chain, it is relatively easy to tell when a chain has not had adequate lubrication.

Inadequate lubrication may be indicated in several ways. The appearance of a red oxide generally results from little or no lubrication. Discoloration of the chain joint also indicates inadequate lubrication. This discoloration is caused by heating of the parts due to increased friction, resulting from inadequate lubrication. In extreme cases, galling or seizing between the pin and bushing may occur. In many cases, proper lubrication will correct these conditions. However, there is a combination of load and speed beyond which it does not seem possible to improve lubrication sufficiently to reduce galling or seizing.

Cooling Effect

An important function of lubrication in high speed drives is the cooling effect of the oil on the chain. The lubricating oil effectively transfers heat from the chain drive to the oil sump and casing where it can be radiated to the surrounding air. In some cases a heat exchanger may be necessary to maintain proper oil temperature.

When oil is introduced close to the point of sprocket entry (Position A, Fig. 7302), it is thrown off almost immediately when the chain passes around the sprocket and very little heat can be absorbed by the oil.



PREFERRED
Fig. 7306

When the oil is introduced farthest from the point of sprocket entry (Position B, Fig. 7302), it remains on the chain the maximum length of time and considerable heat is absorbed by the oil. The chain temperature may be further reduced if a second oil lead is located over or under the top strand of chain (Position C, Fig. 7302).

Oil Viscosity

SAE-30 oil has been found to be adequate for most high speed chain drives with normal ambient temperatures. If the ambient temperature is extremely high and temperatures inside the casing higher than normal, a heavier weight oil should be used. See table below. Although it is important to have the oil fluid enough to get into the chain joints, it has also been shown that too thin an oil does not do an adequate job of lubricating the chain.

Ambient Air Temperature, degrees F	Ambient Air Temperature, degrees C	S.A.E. Viscosity Number	ISO Viscosity System Grade Identification, ISO VG
20 to 40	-5 to 5	20	46 or 68
40 to 100	5 to 40	30	100
100 to 120	40 to 50	40	150
120 to 140	50 to 60	50	220

Rate of Oil Flow

The volume of oil required to lubricate a chain drive depends largely on chain speed. It is also influenced by the amount of heat which must be transferred from the chain to the casing. This heat is a function of the losses which occur in the chain, and is proportional to the amount of power being transferred by the chain drive. In oil field applications where speeds of 1,000 RPM to 1,200 RPM are common with 28 to 32 tooth sprockets, approximately one-half gallon per minute (1.895 litres per minute) per strand of chain is considered a minimum, and larger amounts are frequently used.

Although the oil viscosity and circulation rate are extremely important, it is necessary for the oil to reach the articulating surfaces of the chain. Oil which is dripping gently over a high speed chain drive will not reach the chain joints, it will be blown off onto the casing wall. Obviously, it is necessary that the oil have sufficient pressure and velocity leaving the spray pipe for adequate lubrication. Not only must this oil reach the chain, but it must find its way into the chain joints. A stream of oil that is directed onto the chain roller is not likely to find its way into the joint. Two basic methods of distributing oil across the width of a multiple strand chain have proved successful. One method consists of a pipe with appropriately spaced holes so that the oil is directed to the clearances shown in Fig. 7305. The other method uses a spray nozzle for distributing the oil. If the latter method is used, a flat fishtail spray pattern without excessive atomization of the oil is preferred.

Oil Cleanliness

Oil cleanliness is another important factor in chain lubrication. Frequent oil changes will assure a clean lubricant and long chain life. Obviously, an adequate supply of contaminated oil would not give proper chain life. For this reason, filters are frequently included in the oil line for removing foreign contaminants. Frequently, filters removing any particles larger than 20 mesh (approximately 835 microns) are used either as a full flow or bypass filter. The hazard of a full flow system is that if adequate maintenance is not provided, the filter may become clogged and reduce the amount of oil delivered to the chain. There is evidence that in some locations which are particularly dusty, more adequate filtering of the lubricating oil may be desirable. In such cases, it is quite likely that filters should be provided which would remove particles much finer than 20 mesh. In addition, magnetic filters have been used for removing wear products or other magnetic particles from the oil. If adequate maintenance is available, thorough filtering of the oil would seem to be a very worthwhile investment in terms of extending chain life.

Chain length conversion

Number of Pitches	CHAIN PITCH INCHES											Number of Pitches
	35	40	50	60	80	100	120	140	160	200	240	
	375	.500	.625	.750	1.000	1.250	1.500	1.750	2.000	2.500	3.000	
	CHAIN LENGTH, FEET											
1	0.0313	0.0417	0.0521	0.0625	0.0833	0.1042	0.125	0.1458	0.1667	0.2083	0.25	1
2	.0625	.0833	.1042	.1250	.1667	.2083	.250	.2917	.3333	.4167	0.50	2
3	.0938	.1250	.1563	.1875	.2500	.3125	.375	.4375	.5000	.6250	0.75	3
4	.1250	.1667	.2083	.2500	.3333	.4167	.500	.5833	.6667	.8333	1.00	4
5	.1563	.2083	.2604	.3125	.4167	.5208	.625	.7292	.8333	1.0417	1.25	5
6	.1875	.2500	.3125	.3750	.5000	.6250	.750	.8750	1.0000	1.2500	1.50	6
7	.2188	.2917	.3646	.4375	.5833	.7292	.875	1.0208	1.1667	1.4583	1.75	7
8	.2500	.3333	.4167	.5000	.6667	.8333	1.000	1.1667	1.3333	1.1667	2.00	8
9	.2813	.3750	.4688	.5625	.7500	.9375	1.125	1.3125	1.5000	1.8750	2.25	9
10	.3125	.4167	.5208	.6250	.8333	1.0417	1.250	1.4583	1.6667	2.0833	2.50	10
11	.3438	.4584	.5729	.6875	.9167	1.1459	1.375	1.6041	1.8333	2.2917	2.75	11
12	.3750	.5000	.6250	.7500	1.0000	1.2500	1.500	1.7500	2.0000	2.5000	3.00	12
13	.4063	.5417	.6771	.8125	1.0833	1.3542	1.625	1.8958	2.1667	2.7083	3.25	13
14	.4375	.5833	.7292	.8750	1.1667	1.4583	1.750	2.0417	2.3333	2.9167	3.50	14
15	.4688	.6250	.7813	.9375	1.2500	1.5625	1.875	2.1875	2.5000	3.1250	3.75	15
16	.5000	.6667	.8333	1.0000	1.3333	1.6667	2.000	2.3333	2.6667	3.3333	4.00	16
17	.5313	.7084	.8854	1.0625	1.4167	1.7709	2.125	2.4791	2.8333	3.5417	4.25	17
18	.5625	.7500	.9375	1.1250	1.5000	1.8750	2.250	2.6250	3.0000	3.7500	4.50	18
19	.5938	.7917	.9896	1.1875	1.5833	1.9792	2.375	2.7708	3.1667	3.9583	4.75	19
20	.6250	.8333	1.0417	1.2500	1.6667	2.0833	2.500	2.9167	3.3333	4.1667	5.00	20
21	.6563	.8750	1.0938	1.3125	1.7500	2.1875	2.625	3.0625	3.5000	4.3750	5.25	21
22	.6875	.9167	1.1458	1.3750	1.8333	2.2917	2.750	3.2083	3.6667	4.5833	5.50	22
23	.7188	.9584	1.1979	1.4375	1.9166	2.3958	2.875	3.3541	3.8333	4.7917	5.75	23
24	.7500	1.0000	1.2500	1.5000	2.0000	2.5000	3.000	3.5000	4.0000	5.0000	6.00	24
25	.7813	1.0417	1.3021	1.5625	2.0833	2.6042	3.125	3.6458	4.1667	5.2083	6.25	25
26	.8125	1.0833	1.3541	1.6250	2.1667	2.7083	3.250	3.7917	4.3333	5.4167	6.50	26
27	.8438	1.1250	1.4062	1.6875	2.2500	2.8125	3.375	3.9375	4.5000	5.6250	6.75	27
28	.8750	1.1667	1.4583	1.7500	2.3333	2.9167	3.500	4.0833	4.6667	5.8333	7.00	28
29	.9063	1.2084	1.5104	1.8125	2.4167	3.0209	3.625	4.2291	4.8333	6.0417	7.25	29
30	.9375	1.2500	1.5625	1.8750	2.5000	3.1250	3.750	4.3750	5.0000	6.2500	7.50	30
31	.9688	1.2917	1.6146	1.9375	2.5833	3.2292	3.875	4.5208	5.1667	6.4583	7.75	31
32	1.0000	1.3333	1.6667	2.0000	2.6667	3.3333	4.000	4.6667	5.3333	6.6667	8.00	32
33	1.0313	1.3750	1.7188	2.0625	2.7500	3.4375	4.125	4.8125	5.5000	6.8750	8.25	33
34	1.0625	1.4167	1.7708	2.1250	2.8333	3.5417	4.250	4.9583	5.6667	7.0833	8.50	34
35	1.0938	1.4584	1.8229	2.1875	2.9167	3.6459	4.375	5.1041	5.8333	7.2917	8.75	24
36	1.1250	1.5000	1.8750	2.2500	3.0000	3.7500	4.500	5.2500	6.0000	7.5000	9.00	36
37	1.1563	1.5417	1.9271	2.3125	3.0833	3.8542	4.625	5.3958	6.1667	7.7083	9.25	37
38	1.1875	1.5833	1.9791	2.3750	3.1667	3.9583	4.750	5.5417	6.3333	7.9167	9.50	38
39	1.2188	1.6250	2.0312	2.4375	3.2500	4.0625	4.875	5.6875	6.5000	8.1250	9.75	39
40	1.2500	1.6667	2.0833	2.5000	3.3333	4.1667	5.000	5.8333	6.6667	8.3333	10.00	40
41	1.2813	1.7084	2.1354	2.5625	3.4167	4.2709	5.125	5.9791	6.8333	8.5417	10.25	41
42	1.3125	1.7500	2.1875	2.6250	3.5000	4.3750	5.250	6.1250	7.0000	8.7500	10.50	42
43	1.3438	1.7917	2.2396	2.6875	3.5833	4.4792	5.375	6.2708	7.1667	8.9583	10.75	43
44	1.3750	1.8333	2.2917	2.7500	3.6667	4.5833	5.500	6.4167	7.3333	9.1667	11.00	44
45	1.4063	1.8750	2.3437	2.8125	3.7500	4.6875	5.625	6.5625	7.5000	9.3750	11.25	45
46	1.4375	1.9167	2.3958	2.8750	3.8333	4.7917	5.750	6.7083	7.6667	9.5833	11.50	46
47	1.4688	1.9584	2.4479	2.9375	3.9167	4.8959	5.875	6.8541	7.8333	9.7917	11.75	47
48	1.5000	2.0000	2.5000	3.0000	4.0000	5.0000	6.000	7.0000	8.0000	10.0000	12.00	48
49	1.5313	2.0417	2.5521	3.0625	4.0833	5.1042	6.125	7.1458	8.1667	10.2083	12.25	49
50	1.5625	2.0833	2.6042	3.1250	4.1667	5.2083	6.250	7.2917	8.3333	10.4167	12.50	50
52	1.6250	2.1667	2.7083	3.2500	4.3333	5.4167	6.500	7.5833	8.6667	10.8333	13.00	52
54	1.6875	2.2500	2.8125	3.3750	4.5000	5.6250	6.750	7.8750	9.0000	11.2500	13.50	54
56	1.7500	2.3333	2.9167	3.5000	4.6667	5.8333	7.000	8.1667	9.3333	11.6667	14.00	56
58	1.8125	2.4167	3.0208	3.6250	4.8333	6.0417	7.250	8.4583	9.6667	12.0833	14.50	58
60	1.8750	2.5000	3.1250	3.7500	5.0000	6.2500	7.500	8.7500	10.0000	12.5000	15.00	60
62	1.9375	2.5833	3.2292	3.8750	5.1667	6.4583	7.750	9.0417	10.3333	12.9167	15.50	62
54	2.0000	2.6667	3.3333	4.0000	5.3333	6.6667	8.000	9.3333	10.6667	13.3333	16.00	64
66	2.0625	2.7500	3.4375	4.1250	5.5000	6.8750	8.250	9.6250	11.0000	13.7500	16.50	66
68	2.1250	2.8333	3.5417	4.2500	5.6667	7.0833	8.500	9.9167	11.3333	14.1667	17.00	68
70	2.1875	2.9167	3.6458	4.3750	5.8333	7.2917	8.750	10.2083	11.6667	14.5833	17.50	70
72	2.2500	3.0000	3.7500	4.5000	6.0000	7.5000	9.000	10.5000	12.0000	15.0000	18.00	72
74	2.3125	3.0833	3.8541	4.6250	6.1667	7.7083	9.250	10.7917	12.3333	15.4167	18.50	74
76	2.3750	3.1667	3.9583	4.7500	6.3333	7.9167	9.500	11.0833	12.6667	15.8333	19.00	76
78	2.4375	3.2500	4.0625	4.8750	6.5000	8.1250	9.750	11.3750	13.0000	16.2500	19.50	78
80	2.5000	3.3333	4.1667	5.0000	6.6667	8.3333	10.000	11.6667	13.3333	16.6667	20.00	80
82	2.5625	3.4167	4.2708	5.1250	6.8333	8.5417	10.250	11.9583	13.6667	17.0833	20.50	82
84	2.6250	3.5000	4.3750	5.2500	7.0000	8.7500	10.500	12.2500	14.0000	17.5000	21.00	84
86	2.6875	3.5833	4.4792	5.3750	7.1667	8.9583	10.750	12.5417	14.3333	17.9167	21.50	86
88	2.7500	3.6667	4.5833	5.5000	7.3333	9.1667	11.000	12.8333	14.6667	18.3333	22.00	88
90	2.8125	3.7500	4.6875	5.6250	7.5000	9.3750	11.250	13.1250	15.0000	18.7500	22.50	90
92	2.8750	3.8333	4.7917	5.7500	7.6667	9.5833	11.500	13.4167	15.3333	19.1667	23.00	92
94	2.9375	3.9167	4.8958	5.8750	7.8333	9.7917	11.750	13.7083	15.6667	19.5833	23.50	94
96	3.0000	4.0000	5.0000	6.0000	8.0000	10.0000	12.000	14.0000	16.0000	20.0000	24.00	96
98	3.0625	4.0833	5.1042	6.1250	8.1667	10.2083	12.250	14.2917	16.3333	20.4167	24.50	98
100	3.1250	4.1667	5.2083	6.2500	8.3333	10.4167	12.500	14.5833	16.6667	20.8333	25.00	100

Chain length conversion

Number of Pitches	CHAIN PITCH, MILLIMETERS											Number of Pitches
	35 9.525	40 12.7	50 15.875	60 19.05	80 25.4	100 31.75	120 38.1	140 44.45	160 50.8	200 63.5	240 76.2	
	CHAIN LENGTH, METERS											
1	0.095	0.127	0.159	0.191	0.254	0.318	0.381	0.445	0.508	0.635	0.762	1
2	0.381	0.254	0.318	0.381	0.508	0.635	0.762	0.889	1.016	1.270	1.524	2
3	0.286	0.381	0.476	0.572	0.762	0.953	1.143	1.334	1.524	1.905	2.286	3
4	0.381	0.508	0.635	0.762	1.016	1.270	1.524	1.778	2.032	2.540	3.048	4
5	0.476	0.635	0.794	0.953	1.270	1.588	1.905	2.223	2.540	3.175	3.810	5
6	0.572	0.762	0.953	1.143	1.524	1.905	2.286	2.667	3.048	3.810	4.572	6
7	0.667	0.889	1.111	1.334	1.778	2.223	2.667	3.112	3.556	4.445	5.334	7
8	0.762	1.016	1.270	1.524	2.032	2.540	3.048	3.556	4.064	5.080	6.096	8
9	0.857	1.143	1.429	1.715	2.286	2.858	3.429	4.001	4.572	5.715	6.858	9
10	0.953	1.270	1.588	1.905	2.540	3.175	3.810	4.445	5.080	6.350	7.620	10
11	1.048	1.397	1.746	2.096	2.794	3.493	4.191	4.890	5.588	6.985	8.382	11
12	1.143	1.524	1.905	2.286	3.048	3.810	4.572	5.334	6.096	7.620	9.144	12
13	1.238	1.651	2.064	2.477	3.302	4.128	4.953	5.779	6.604	8.255	9.906	13
14	1.334	1.778	2.223	2.667	3.556	4.445	5.334	6.223	7.112	8.890	10.668	14
15	1.429	1.905	2.381	2.858	3.810	4.763	5.715	6.668	7.620	9.525	11.430	15
16	1.524	2.032	2.540	3.048	4.064	5.080	6.096	7.112	8.128	10.160	12.192	16
17	1.619	2.159	2.699	3.239	4.318	5.398	6.477	7.557	8.636	10.795	12.954	17
18	1.715	2.286	2.858	3.429	4.572	5.715	6.858	8.001	9.144	11.430	13.716	18
19	1.810	2.413	3.016	3.620	4.826	6.033	7.239	8.446	9.652	12.065	14.478	19
20	1.905	2.540	3.175	3.810	5.080	6.350	7.620	8.890	10.160	12.700	15.240	20
21	2.000	2.667	3.334	4.001	5.334	6.668	8.001	9.335	10.668	13.335	16.002	21
22	2.096	2.794	3.493	4.191	5.588	6.985	8.382	9.779	11.176	13.970	16.764	22
23	2.191	2.921	3.651	4.382	5.842	7.303	8.763	10.224	11.684	14.605	17.526	23
24	2.286	3.048	3.810	4.572	6.096	7.620	9.144	10.668	12.192	15.240	18.288	24
25	2.381	3.175	3.969	4.763	6.350	7.938	9.525	11.113	12.700	15.875	19.050	25
26	2.477	3.302	4.128	4.953	6.604	8.255	9.906	11.557	13.208	16.510	19.812	26
27	2.572	3.429	4.286	5.144	6.858	8.573	10.287	12.002	13.716	17.145	20.574	27
28	2.667	3.556	4.445	5.334	7.112	8.890	10.668	12.446	14.224	17.780	21.336	28
29	2.762	3.683	4.604	5.525	7.366	9.208	11.049	12.891	14.732	18.415	22.098	29
30	2.858	3.810	4.763	5.715	7.620	9.525	11.430	13.335	15.240	19.050	22.860	30
31	2.953	3.937	4.921	5.906	7.874	9.843	11.811	13.780	15.748	19.685	23.622	31
32	3.048	4.064	5.080	6.096	8.128	10.160	12.192	14.224	16.256	20.320	24.384	32
33	3.143	4.191	5.239	6.287	8.382	10.478	12.573	14.669	16.764	20.955	25.146	33
34	3.239	4.318	5.398	6.477	8.636	10.795	12.954	15.113	17.272	21.590	25.908	34
35	3.334	4.445	5.556	6.668	8.890	11.113	13.335	15.558	17.780	22.225	26.670	35
36	3.429	4.572	5.715	6.858	9.144	11.430	13.716	16.002	18.288	22.860	27.432	36
37	3.524	4.699	5.874	7.049	9.398	11.748	14.097	16.447	18.796	23.495	28.194	37
38	3.620	4.826	6.033	7.239	9.652	12.065	14.478	16.891	19.304	24.130	28.956	38
39	3.715	4.953	6.191	7.430	9.906	12.383	14.859	17.336	19.812	24.765	29.718	39
40	3.810	5.080	6.350	7.620	10.160	12.700	15.240	17.780	20.320	25.400	30.480	40
41	3.905	5.207	6.509	7.811	10.414	13.018	15.621	18.225	20.828	26.035	31.242	41
42	4.001	5.334	6.668	8.001	10.668	13.335	16.002	18.669	21.336	26.670	32.004	42
43	4.096	5.461	6.826	8.192	10.922	13.653	16.383	19.114	21.844	27.305	32.766	43
44	4.191	5.588	6.985	8.382	11.176	13.970	16.764	19.558	22.352	27.940	33.528	44
45	4.286	5.715	7.144	8.573	11.430	14.288	17.145	20.003	22.860	28.575	34.290	45
46	4.382	5.842	7.303	8.763	11.684	14.605	17.526	20.447	23.368	29.210	35.052	46
47	4.477	5.969	7.461	8.954	11.938	14.923	17.907	20.892	23.876	29.845	35.814	47
48	4.572	6.096	7.620	9.144	12.192	15.240	18.288	21.336	24.384	30.480	36.576	48
49	4.667	6.223	7.779	9.335	12.446	15.558	18.669	21.781	24.892	31.115	37.338	49
50	4.763	6.350	7.938	9.525	12.700	15.875	19.050	22.225	25.400	31.750	38.100	50
52	4.953	6.604	8.255	9.906	13.208	16.510	19.812	23.114	26.416	33.020	39.624	52
54	5.144	6.858	8.573	10.287	13.716	17.145	20.574	24.003	27.432	34.290	41.148	54
56	5.334	7.112	8.890	10.668	14.224	17.780	21.336	24.892	28.448	35.560	42.672	56
58	5.525	7.366	9.208	11.049	14.732	18.415	22.098	25.781	29.464	36.830	44.196	58
60	5.715	7.620	9.525	11.430	15.240	19.050	22.860	26.670	30.480	38.100	45.720	60
62	5.906	7.874	9.843	11.811	15.748	19.685	23.622	27.559	31.496	39.370	47.244	62
64	6.096	8.128	10.160	12.192	16.256	20.320	24.384	28.448	32.512	40.640	48.768	64
66	6.287	8.382	10.478	12.573	16.764	20.955	25.146	29.337	33.528	41.910	50.292	66
68	6.477	8.636	10.795	12.954	17.272	21.590	25.908	30.226	34.544	43.180	51.816	68
70	6.668	8.890	11.113	13.335	17.780	22.225	26.670	31.115	35.560	44.450	53.340	70
72	6.858	9.144	11.430	13.716	18.288	22.860	27.432	32.004	36.576	45.720	54.864	72
74	7.049	9.398	11.748	14.097	18.796	23.495	28.194	32.893	37.592	46.990	56.388	74
76	7.239	9.652	12.065	14.478	19.304	24.130	28.956	33.782	38.608	48.260	57.912	76
78	7.430	9.906	12.383	14.859	19.812	24.765	29.718	34.671	39.624	49.530	59.436	78
80	7.620	10.160	12.700	15.240	20.320	25.400	30.480	35.560	40.640	50.800	60.960	80
82	7.811	10.414	13.018	15.621	20.828	26.035	31.242	36.449	41.656	52.070	62.484	82
84	8.001	10.668	13.335	16.002	21.336	26.670	32.004	37.338	42.672	53.340	64.008	84
86	8.192	10.922	13.653	16.383	21.844	27.305	32.766	38.227	43.688	54.610	65.532	86
88	8.382	11.176	13.970	16.764	22.352	27.940	33.528	39.116	44.704	55.880	67.056	88
90	8.573	11.430	14.288	17.145	22.860	28.575	34.290	40.005	45.720	57.150	68.580	90
92	8.763	11.684	14.605	17.526	23.368	29.210	35.052	40.894	46.736	58.420	70.104	92
94	8.954	11.938	14.923	17.907	23.876	29.845	35.814	41.783	47.752	59.690	71.628	94
96	9.144	12.192	15.240	18.288	24.384	30.480	36.576	42.672	48.768	60.960	73.152	96
98	9.335	12.446	15.558	18.669	24.892	31.115	37.338	43.561	49.784	62.230	74.676	98
100	9.525	12.700	15.875	19.050	25.400	31.750	38.100	44.450	50.800	63.500	76.200	100

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