

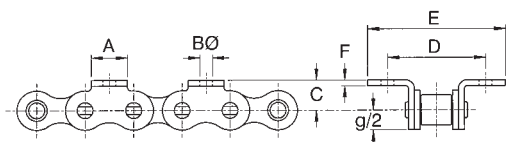
# British Standard Roller Chain Attachments



The attachments below are available on 72 hour service built into the base roller chain at spacings to suit the application, K & M attachments can be fitted to only one side of the chain or both sides (as illustrated). Attachments of different types can be fitted in one chain assembly. In addition to these standard attachments, specials to suit customers' specific requirements can be supplied. Attachments can be assembled into Duplex and Triplex Chains, as well as standard Simplex. Nickel Plated chains can also be supplied to order. All Standard Attachments are made basically to ISO 606 Standard to ensure full interchangeability.

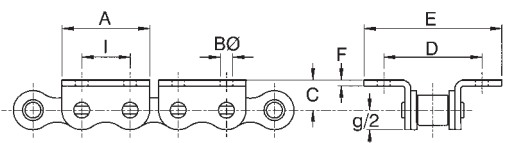
## Bent Attachments

### K1 - Single Hole Bent Attachment



Base Chain Ref.	Pitch P	Attach Width A	Hole Dia B	Plate Height C	Transverse Pitch D	Overall Width E	Plate Thick F
08B-1	1/2"	11.5	4.2	8.9	23.8	36	1.5
10B-1	5/8"	12.8	5.3	10.3	31.8	45	1.5
12B-1	3/4"	16.6	7.1	13.5	38.1	58	1.8
16B-1	1"	20.0	6.7	15.9	50.8	73	3.2

### K2 - Two Hole Bent Attachment

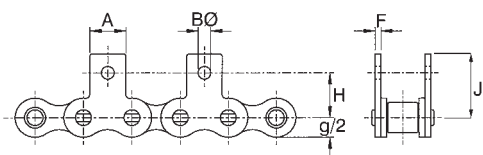


Base Chain Ref.	Pitch P	Attach Width A <sub>1</sub>	Hole Dia B	Plate Height C	Transverse Pitch D	Overall Width E	Plate Thick F	Hole Pitch I
08B-1	1/2"	23.4	4.9	8.9	25.4	40	1.5	12.7
10B-1	5/8"	28.6	5.3	10.3	31.8	49	1.5	15.9
12B-1	3/4"	34.0	6.5	13.5	38.1	52	1.8	19.1
16B-1	1"	46.0	6.7	15.9	50.8	73	3.2	25.4

Note:- If required plates can be supplied without holes, or with position/diameter of holes of non-standard sizes on short delivery.

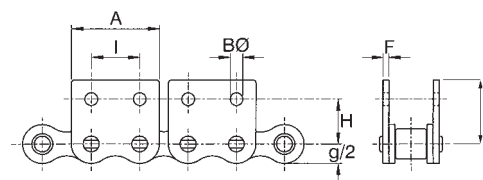
## Straight Attachments

### M1 - Single Hole Straight Attachment



Base Chain Ref.	Pitch P	Attach Width A	Hole Dia B	Hole Height H	Plate Height J	Plate Thick F
08B-1	1/2"	11.5	4.2	12.7	19.0	1.5
10B-1	5/8"	12.8	5.3	15.9	22.6	1.5
12B-1	3/4"	16.6	7.1	22.2	31.9	1.8
16B-1	1"	20.0	6.7	23.0	34.0	3.2

### M2 - Two Hole Straight Attachment



Base Chain Ref.	Pitch P	Attach Width A <sub>1</sub>	Hole Dia B	Hole Height H	Hole Pitch I	Plate Height J	Plate Thick F
08B-1	1/2"	23.4	4.9	13.0	12.7	20.8	1.5
10B-1	5/8"	28.6	5.3	16.5	15.9	24.9	1.5
12B-1	3/4"	34.0	6.5	21.0	19.1	28.2	1.8
16B-1	1"	46.0	6.7	23.0	25.4	34.0	3.2

All K & M attachments can be supplied without holes, or with the holes of different diameters and positions to standard. Also special shape attachments can be provided to customers drawings.

All dimensions in mm except where stated.

# British Standard Roller Chain Attachments

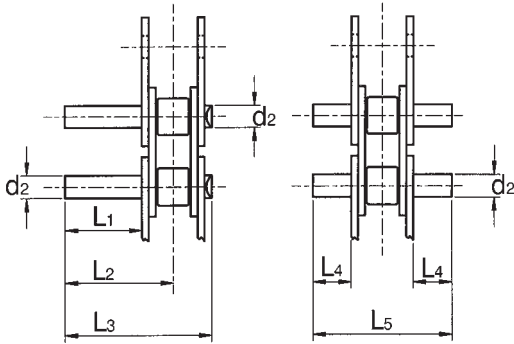


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## Extended Pin Attachments

The extended pins can be assembled into the chain at positions to suit customers applications, or supplied loose as rivetting outers or connecting links. Normally used in pairs to support transverse tubes (when chain should be ordered as matched pairs) or sometimes in single strands to support or attach other attachments.

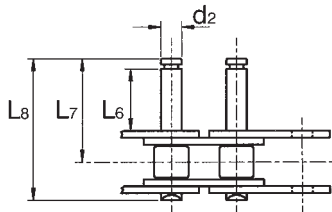
**Straight Parallel Pins extended one side only E1, or equally extended both sides of chain E2. Attachments available with short or long pins.**



Attachment Ref.		E1 Short			E1 Long		E2 Short		E2 Long		
Chain Ref	Pitch	Pin to Ø	Extension	Pin $\phi$	Pin Length	Extension	Pin Length	Extension	Pin Length	Extension	Pin Length
	P	d <sub>2</sub>	L <sub>1</sub>	L <sub>2</sub>	L <sub>3</sub>	L <sub>1</sub>	L <sub>3</sub>	L <sub>4</sub>	L <sub>5</sub>	L <sub>4</sub>	L <sub>5</sub>
06B-1	3/8"	3.28	11.1	16.7	22.9	21.3	33.2	5.9	22.9	11.0	33.2
08B-1	1/2"	4.45	14.5	21.8	30.0	28.4	43.9	7.7	30.0	14.7	43.9
10B-1	5/8"	5.08	17.8	26.1	35.3	34.4	51.9	9.4	35.3	17.7	51.9
12B-1	3/4"	5.72	20.7	30.5	41.3	40.2	60.8	10.9	41.3	20.6	60.8
16B-1	1"	8.28	33.8	49.9	67.4	65.7	99.3	17.6	67.4	33.6	99.3
20B-1	1 1/4"	10.19	38.3	57.2	77.6	75.6	114.8	20.0	77.6	38.6	114.8
24B-1	1 1/2"	14.63	50.3	74.7	101.3	-	-	26.3	101.3	-	-
32B-1	2"	17.78	61.0	90.5	122.9	-	-	31.9	122.9	-	-

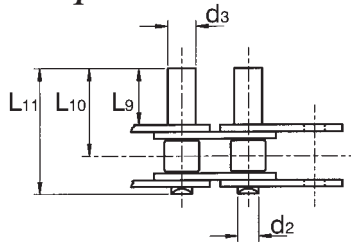
Single pin extensions can be assembled projecting on alternate sides of chain. Special length pins available on short delivery time.

**Parallel Pins with grooves for circlip fixture location. Available short pins E3 attachment, or long pins - E4 attachment**



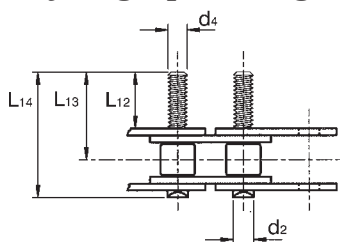
Attachment Ref.		E3 Short Groove Pin			E4 Long Groove Pin			
Chain Ref	Pitch	Pin to Ø	Attach Length	Pin $\phi$	Pin Length	Attach Length	Pin $\phi$	Pin Length
	P	d <sub>2</sub>	L <sub>6</sub>	L <sub>7</sub>	L <sub>8</sub>	L <sub>6</sub>	L <sub>7</sub>	L <sub>8</sub>
06B-1	3/8"	3.28	-	-	-	10.5	17.9	24.2
08B-1	1/2"	4.45	7.2	16.5	24.7	13.9	23.1	31.3
10B-1	5/8"	5.08	9.5	20.2	29.5	16.8	27.5	36.7
12B-1	3/4"	5.72	11.8	24.3	35.1	19.6	32.1	42.9
16B-1	1"	8.28	15.8	35.8	53.4	32.3	51.5	69.0

**Stepped Pins to provide additional bearing support area, ref. E5 and (08B-1 only) E6 and E8.**



Chain Size	Pitch P	Attach Ref.	Pin dia d <sub>2</sub>	Step Pin dia d <sub>3</sub>	Step Pin Length L <sub>9</sub>	Pin to $\phi$ L <sub>10</sub>	Overall Length L <sub>11</sub>
08B-1	1/2"	E8	4.45	6.00	8.0	15.3	23.8
08B-1	1/2"	E6	4.45	6.00	15.0	22.3	30.8
08B-1	1/2"	E5	4.45	6.00	34.0	41.3	49.4
10B-1	5/8"	E5	5.08	6.00	26.0	34.3	43.5
12B-1	3/4"	E5	5.72	8.00	25.0	34.8	45.5
16B-1	1"	E5	8.28	10.00	25.0	41.1	58.6

**Threaded Pins for rigidly attaching carriers, ref. E9, used in Gatherers in Book Binding machines**

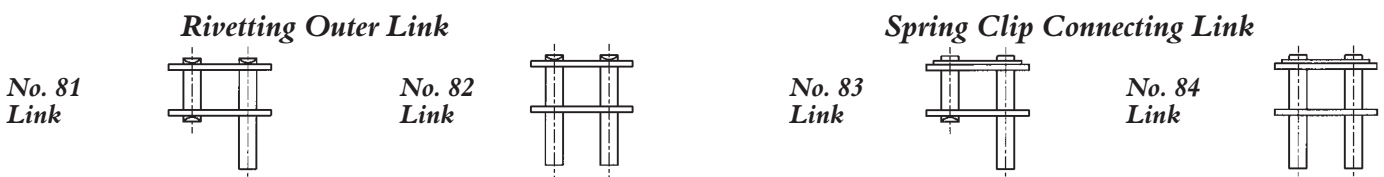


GATHERER CHAIN - 3/8" Pitch precision roller chain complete with an M4 threaded extended pin, one side every pitch. 'Gatherer Chain' is Synonymous with the book binding industry, this chain is manufactured to strict tolerances to produce a chain specifically for book binding applications.

Chain Size	Pitch P	Attach Ref.	Pin dia d <sub>2</sub>	Pin Thread dia d <sub>3</sub>	Step Pin Length L <sub>12</sub>	Pin to $\phi$ L <sub>13</sub>	Overall Length L <sub>14</sub>
12B-1	3/4"	E9	5.72	M4	10.0	19.8	30.8

All dimensions in mm except where stated.

**Loose Link Assemblies for Standard Chain 06B to 16B Chains. Use chain size and extended pin ref. to identify.**



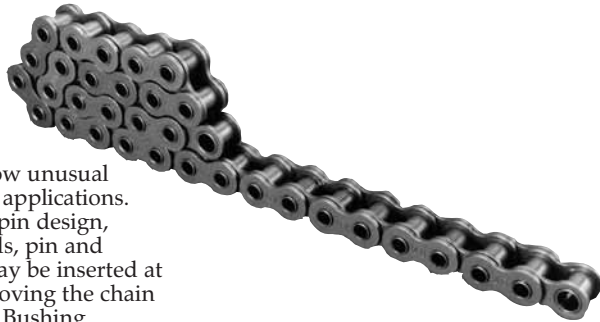
Many designs of special extended pins are manufactured for customer specific applications. Please consult Cross+Morse Engineering with your requirements.

Email sales@crossmorse.com

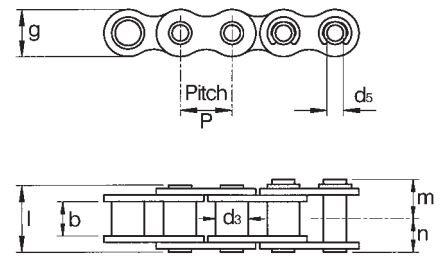
# American Standard Attachment Chains and Corrosion Resistance Chains



## Rollerless Hollow Pin Chains to ANSI Dimensions



Hollow Pin Chains allow unusual flexibility for conveyor applications. Because of the hollow pin design, many types of crossrods, pin and custom attachments may be inserted at any point without removing the chain from the drive system. Bushing diameters are the same as comparable chain rollers. These chains operate on standard sprockets. Standard packages contain two matched 10' lengths. When used on parallel strand conveyors, these strands should be installed directly opposite each other. A two-pitch offset section can be ordered to accommodate applications where an odd number of link is required.

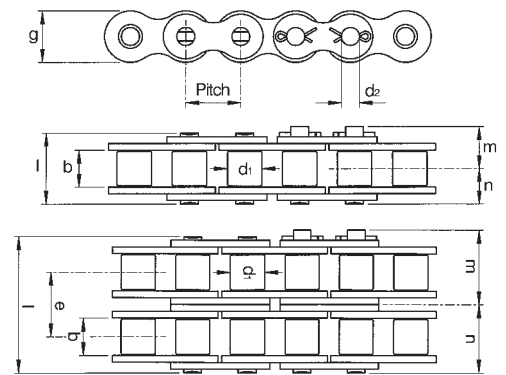


Cat. No.	Pitch P inches	Inside Width b min. mm	Bush Ø d3 max. mm	Bore Ø d5 max. mm	Plate Depth g mm	Rivet Pin Length l max. mm	Length to Cotter Pin m mm	Length to Rivet Pin n mm	Tensile Strength N	Weight Approx. kg/m
40HP	1/2	7.85	7.95	4.01	11.8	16.6	9.4	8.3	10,000	0.57
50HP	5/8	9.40	10.16	5.15	15.0	20.2	11.7	10.1	14,800	0.94
60HP	3/4	12.60	11.91	6.02	18.0	24.7	14.5	12.4	24,000	1.31
80HP	1	15.80	15.88	8.07	24.0	31.0	17.8	15.5	34,000	2.32

## ANSI Stainless Steel Roller Chains

Standard chains are manufactured from 18-8 (304) stainless steel. These chains can be used in corrosive environments, and at temperatures up to 500°C. They are well suited to the high moisture, high temperature conditions found in many food preparation and packaging applications. For improved wear life chains with round parts manufactured from precipitation hardened 400 Series steels can be supplied. These chains have slightly less corrosion resistance, and can only operate up to 325°C.

Extended pin, K1 and M1 attachments in 18-8 materials can be provided assembled into chains, against specific order.

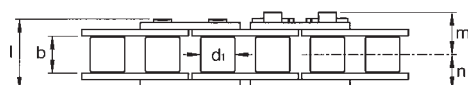
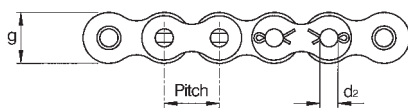


Chain No.	Pitch P inches	Inside Width mm	Roller Diameter mm	Pin Diameter mm	Plate Depth mm	Pin Lengths				Transverse Pitch mm	Bearing Area cm2	Ultimate Tensile kN	Max Allowable kN	Approx. Weight kg/m
						l max. mm	m2 max. mm	m mm	n mm					
American Standard Simplex Chains														
ANSI 25 1)	1/4	3.18	3.30	2.29	5.9	7.8	8.8	4.9	3.9	-	0.11	2.8	0.11	0.13
ANSI 35 1)	3/8	4.78	5.08	3.58	9.0	12.2	13.7	7.6	6.1	-	0.27	5.7	0.26	0.34
ANSI 40	1/2	7.95	7.92	3.96	11.7	17.0	18.5	10.0	8.5	-	0.44	11.1	0.66	0.62
ANSI 50	5/8	9.53	10.16	5.08	14.6	20.8	22.3	11.9	10.4	-	0.70	17.6	1.02	1.01
ANSI 60	3/4	12.70	11.91	5.95	17.5	26.0	27.9	14.9	13.0	-	1.06	24.5	1.54	1.48
ANSI 80	1	15.88	15.88	7.93	23.4	32.8	35.5	19.1	16.4	-	1.79	42.3	2.65	2.52
ANSI 100	1 1/4	19.05	19.05	9.53	29.3	40.0	43.3	23.3	20.0	-	2.62	51.0	3.82	3.91
ANSI 120	1 1/2	25.40	22.23	11.10	35.1	50.4	54.2	29.0	25.2	-	3.94	68.6	4.66	5.76
ANSI 160	2	31.75	28.58	14.28	46.7	64.4	68.7	36.5	32.2	-	6.50	109.8	6.37	9.79
American Standard Duplex Chains														
ANSI 35-2 1)	3/8	4.78	5.08	3.58	9.0	22.33	23.8	12.7	11.2	10.13	0.54	10.4	0.52	0.65
ANSI 40-2	1/2	7.95	7.92	3.96	11.7	31.38	32.9	17.2	15.7	14.38	0.88	22.2	0.88	1.22
ANSI 50-2	5/8	9.53	10.16	5.08	14.6	38.91	40.4	21.0	19.5	18.11	1.40	35.2	1.36	2.00
ANSI 60-2	3/4	12.70	11.91	5.95	17.5	48.78	50.7	26.3	24.4	22.78	2.12	48.8	2.06	2.85
ANSI 80-2	1	15.88	15.88	7.93	23.4	62.09	64.8	33.7	31.0	29.29	3.58	84.5	3.55	5.00
ANSI 100-2	1 1/4	19.05	19.05	9.53	29.3	75.76	79.1	41.2	37.9	35.76	5.24	101.8	5.10	7.60

• Bush Chains. 1) Bush Diameter. **Bold Type** – Chains from Stock, other chains to order.

## Nickel Plated Roller Chains to ANSI Standards

Chain components are electroless nickel plated to provide protection for mildly corrosive areas. Chain retains all physical properties of base chain. Attachments can be supplied to special order.



Aat. No.	Pitch P inches	Inside Width b min. mm	Roller Ø d1 max. mm	Pin Ø d2 max. mm	Plate Depth g mm	Length to Cotter Pin m mm	Length to Rivet Pin n mm	Bearing Area cm²	Tensile Strength N	Weight Approx. kg/m
•35N	3/8	4.77	5.08 <sup>1)</sup>	3.58	9.0	8.7	6.0	0.27	8,400	0.31
40N	1/2	7.85	7.95	3.96	11.8	10.7	8.3	0.44	14,800	0.62
50N	5/8	9.40	10.16	5.08	15.0	14.3	10.1	0.70	24,400	1.01
60N	3/4	12.60	11.91	5.94	18.0	16.3	12.5	1.06	34,400	1.48

• Bush Chains.  
1) Bush Diameter.  
Chains available rivetted construction only.

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