

HKKChain



**GENERAL
CATALOG**

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Company Profile

Since being founded in 1916, HKK Chain has concentrated its efforts on the manufacturing of roller chain

HKK Chain quality starts with an aggressive approach to research and development along with our state-of-the-art manufacturing facility. All HKK Chain is manufactured in our plant, allowing for the strictest of quality control measures that only a single source manufacturer can offer. All our chains are made using only the highest quality materials and most modern heat treating methods.

HKK Chain value doesn't end with superior quality products. Our corporate size allows us the luxury of providing the best personalized customer service in the business, while maintaining all the advantages of our knowledgeable and experienced staff of over 250 people world-wide. HKK Chain also pursues an unrelenting ambition to keep prices as low as possible while

maintaining on time deliveries and helping our customer increase productivity and profitability.

Customers around the world in many industries such as agriculture, material handling, mining, construction, and all types of industrial manufacturing count on HKK Chain to supply quality roller chain at an unsurpassed value. HKK Chain is poised for even greater achievements in the new millennium. The first includes higher working loads from standard ANSI series chains, an accomplishment unequalled by any other manufacture in the world.

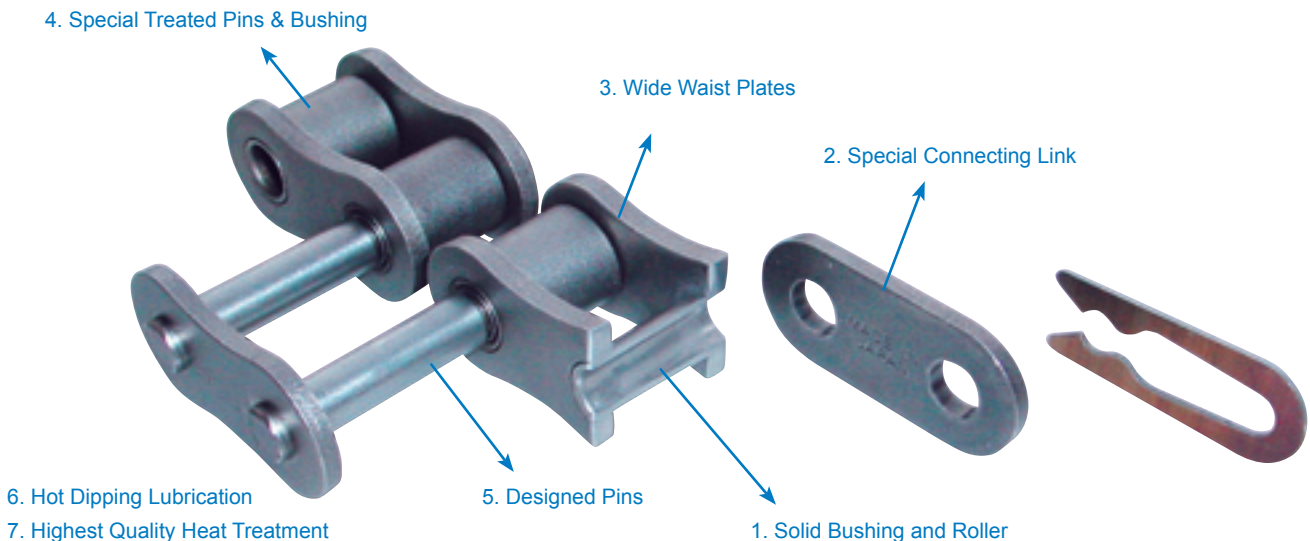
HKK Chain is continually striving to make new breakthroughs in roller chain design. Combining quality, convenience, reliability, and cost with new technology, improved materials, and an expanded application base, HKK is ready to provide the highest quality chain worldwide well into the next century.

Quality Features

When it comes to quality our unique 25% higher load capacity is just the "tip of the iceberg". HKK Chains are backed by many other quality advantages such as solid bushings and solid rollers, full strength connecting links, precision tolerance press-fit parts, and state-of-the-art heat treatment. These advantages have made the name HKK synonymous with quality around the world.

The HKK Features :

1. **Solid Bushing & Roller**
2. **Special Connecting Link**
3. **Wide Waist Plates**
4. **Special Treated Pins & Bushing**
5. **Designed Pins**
6. **Hot Dipping Lubrication**
7. **Highest Quality Heat treatment**

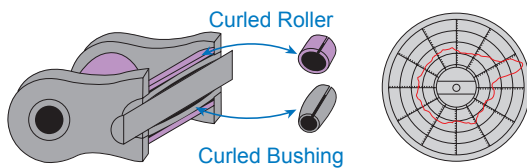


Quality Features

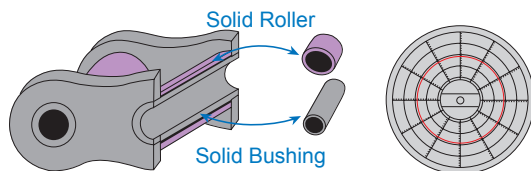
1. Solid Bushing & Roller

- HKK's cold-forged solid bushings and rollers retain their cylindrical inside and outside walls even after side plates are pressed on, resulting in better pin bushing contact for longer chain life. Conventional split bushings deform into a barrel shape when side plates are pressed on, leaving only small contact areas between pins and split bushings. These small contact areas build more friction and heat, that causes premature wear.

Conventional Chain



Silver SBR Chain



2. Special Connecting Link

Patent pending

- HKK's full strength connecting links (slip it type) have the same working load as the chain.
- This full strength connecting link is able to transmit the full power of the chain compared to 80% power transmission of conventional connecting links.

3. Wide Waist Plates

- HKK link plate centre heights are increased for greater fatigue strength and shock resistance.
- The holes of the link plate are double punched. This process provides true 90-degree holes for exact pin-plate, bushing-plate alignment.
- HKK link plates are also shot peened for greater fatigue strength.

4. Special Treated Pins & Bushing

- HKK pins and bushings are specially treated to reduce friction and corrosion in the critical bearing area of the pin and bushings. This treatment will also help increase chain life while running and prevent corrosion during shut down.
 - Specially treated pins provide much higher fatigue strength
 - Working load improvement
 - 15% Size under # 50
 - 25% Size # 60 through #160
 - 22% Size # 180
 - 15% Size # 200 and # 240

5. Designed Pins

- HKK pins are specially designed for each size of chain.
- Exclusively selected steel and superior heat treatment provides strength and toughness for higher wear resistance and load capacity.
- Larger size chain pins are ground after heat treatment to ensure straightness

6. Hot Dipping Lubrication

- HKK chains are pre-lubricated by a hot dipping process that ensures total lubrication of all component parts to prolong chain life.

7. Highest Quality Heat treatment

- Proper heat treatment of all chain component parts is essential for long chain life. HKK's heat treatment process is done with a technologically advanced furnace specially designed for HKK. Consistently meeting HKK's highest standards of heat treatment, HKK chain has been trusted to be dependable, consistent and durable.

Chain Performance & Fatigue Strength

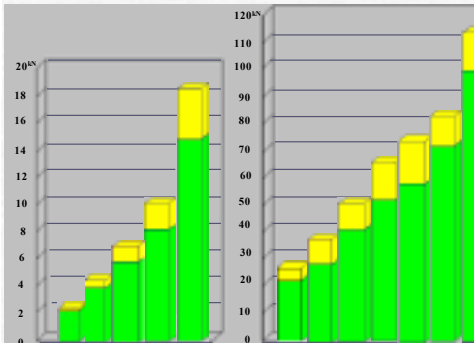
The failure of properly engineered and maintained roller chain is most commonly caused by one of two factors : Wear (elongation) or Fatigue. Roller chain quality and life expectancy is directly related to its resistance to wear and fatigue.

Fatigue

When used in roller chain terminology, fatigue is the endurance of a roller chain when a load is applied under recurring cycles. During a complete cycle, chain will go through a period of tension and slack. The greater the load applied, the fewer cycles the chain can endure. The point at which a constantly applied load will not cause fatigue breakage is called the endurance limit or fatigue strength.

Resistance To Fatigue

HKK Chain's newest advancement targets fatigue strength. This new patent pending generation of roller chain possesses ultra high fatigue strength and increased horsepower capacity. As fatigue strength increases, so does the working load. In fact, this new generation of chain has working loads that are 15% to 25% higher than conventional chains. That means HKK Chain's new working loads are higher than most heavy series chains. As with solid bushings and rollers, this increased strength will be standard on HKK Chain.



Wear

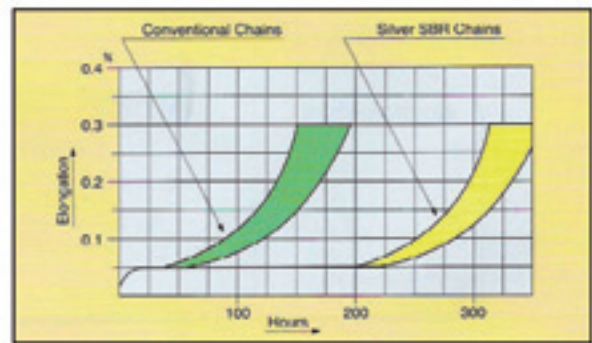
When used in roller chain terminology, elongation is the result of wear due to the erosion of metal in the bearing area of the chain (pins and bushings) caused by friction. The oscillation and contact of the moving chain parts will cause roller chain to elongate. Elongation causes improper chain and sprocket tooth contact requiring chain replacement.

Resistance To Wear

HKK Chain has been the leader in solid bushing and solid roller technology over the past 20 years. Our cold forged solid bushings and solid rollers are the single best resource available when combating the problem of chain elongation. This advanced feature has been standard on HKK Chain for over a decade.

Tensile Strength

This is the point at which roller chain will break with a load applied one single time. Tensile strength is not an indicator of roller chain quality. Choosing a roller chain based on tensile strength and tensile strength calculations is not the best way of selecting roller chain.



Fatigue vs. Tensile Strength

Conventional chains with both higher and lower tensile strengths than HKK quickly drop off when a load is being applied. In real life applications, fatigue strength is far more important than tensile strength. When selecting a roller chain, calculating from Maximum Allowable Loads is much more accurate than calculating from Tensile Strength.

Fatigue Strength

This is the point when the load applied will no longer cause fatigue breakage. This point is called the endurance limit or fatigue strength. The load is applied to the chain over 5 million times to find the actual fatigue strength. HKK's chain has up to 50% higher fatigue strength than conventional chain.

Higher Working Loads

Once the fatigue strength is known, accurate Maximum Allowable Loads can be calculated. HKK's new chains have up to 25% higher Maximum Allowable Loads. Our new increased working load is not only higher than our competitors' standard chains, but higher than their heavy series chains too. Never has there been such a significant increase in roller chain capacity while maintaining ANSI dimensional standards.

HKK's advanced research and development



DIES AND OTHERS

Improved, sophisticated dies are studied and developed in our factory shop.



MODERNIZED HEAT TREATMENT EQUIPMENT

Our heat treatment equipments have been updated for severe control on heated parts.
Also, extreme attention is given to the quality control of the heat treated parts.



ADVANCED FULLY AUTOMATIC ASSEMBLY MACHINE

Our newly designed advanced automatic assembly machines provide greater uniformity and closer tolerance of the products.



QC DEPARTMENT

Your ordered chains are carefully and closely inspected at each production process by our QC-oriented specialists.



AUTOMATIC STORAGE AND HANDLING SYSTEM

Handling of many different parts and semi-finished products are effectively controlled for production.



COLD FORGING MACHINES

Main frame for SBR Solid Bushing and SBR Solid Roller are made with these machines.



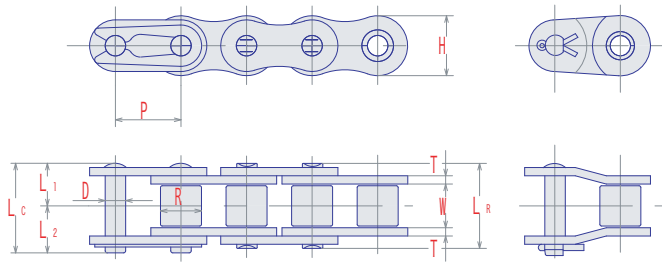
FATIGUE TEST MACHINE

Very important for the quality evaluation for further improvement of the chain life.

ANSI Standard Roller Chains

HKK'S precision power transmission roller chains are manufactured for high strength and long life. HKK solid bushings and rollers, specially treated pins and bushings, and stringently controlled heat treatment are only a few of the many features built into HKK Chain.

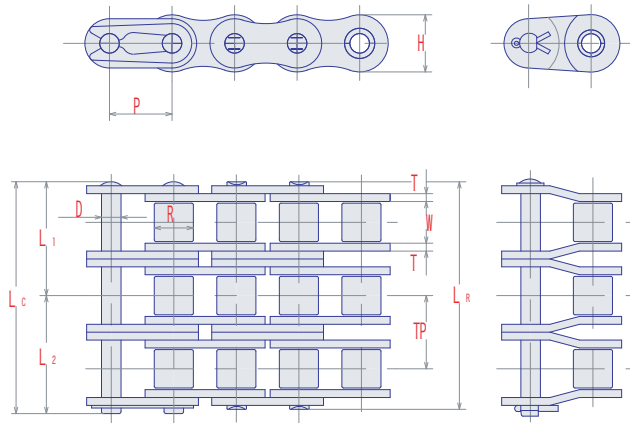
HKK meets or exceeds ANSI standard B29.1, making HKK the most suitable selection for almost any application. For more advantages of HKK chain see pages 2-4



HKK Chain No. (ANSI)	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin		Plate		Trans. Pitch TP				
		Width W	Dia. R	Dia. D	Length L1 L2		Height H		Thick. T			
HKK 35 *	9.525	4.78	5.08	3.58	6.0	6.9	9.0	1.25	-	10.8	2.48	0.34
HKK 35-2 *					11.1	11.9		10.1	21.6	3.67	0.63	
HKK 35-3 *					16.1	17.0		32.4	5.40	0.92		
HKK 35-4 *					21.2	22.0		43.2	7.13	1.22		
HKK 40	12.70	7.95	7.92	3.96	8.3	9.6	11.7	1.5	-	19.1	4.17	0.60
HKK 40-2					15.4	16.8		14.4	38.2	6.17	1.22	
HKK 40-3					22.5	24.1		57.3	9.08	1.85		
HKK 40-4					30.0	30.8		76.4	12.0	2.46		
HKK 50	15.875	9.53	10.16	5.08	10.2	11.8	14.6	2.0	-	31.9	7.22	0.98
HKK 50-2					19.2	20.8		18.1	63.8	10.7	2.00	
HKK 50-3					28.4	29.8		95.7	15.7	3.07		
HKK 50-4					37.5	38.2		128	20.7	3.97		
HKK 60	19.05	12.70	11.91	5.95	12.8	14.1	17.5	2.4	-	43.1	10.7	1.46
HKK 60-2					24.0	25.7		22.8	86.2	14.7	2.95	
HKK 60-3					35.2	37.4		129	21.6	4.43		
HKK 60-4					47.2	48.2		172	28.5	5.92		
HKK 60-5					58.5	59.7		216	33.7	7.41		
HKK 60-6					70.1	70.8		259	39.7	8.90		
HKK 60-8					92.5	94.1		345	53.5	13.36		
HKK 80					25.40	15.88		15.88	7.93	16.4	19.1	23.4
HKK 80-2	30.8	33.7	29.3	157			25.0			5.10		
HKK 80-3	45.5	48.6	236	36.8			7.68					
HKK 80-4	60.2	63.3	314	48.5			10.25					
HKK 80-5	74.9	77.9	393	57.3			12.84					
HKK 80-6	89.6	92.5	471	67.6			15.42					
HKK 80-8	118.8	121.8	628	91.1			20.58					
HKK 100	31.75	19.05	19.05	9.53			19.7			23.3	29.3	
HKK 100-2					37.6	41.2	35.8	236	38.4	7.74		
HKK 100-3					55.5	59.1	354	56.5	11.58			
HKK 100-4					73.7	77.1	472	74.6	15.40			
HKK 100-5					91.5	95.1	590	88.1	19.26			
HKK 100-6					109.4	113.0	708	104	23.10			
HKK 100-8					145.2	148.9	944	140	30.81			

* Rollerless Chain : Roller Diameter 'B' is identical to the bushing diameter, as these chains have no rollers

ANSI Standard Roller Chains



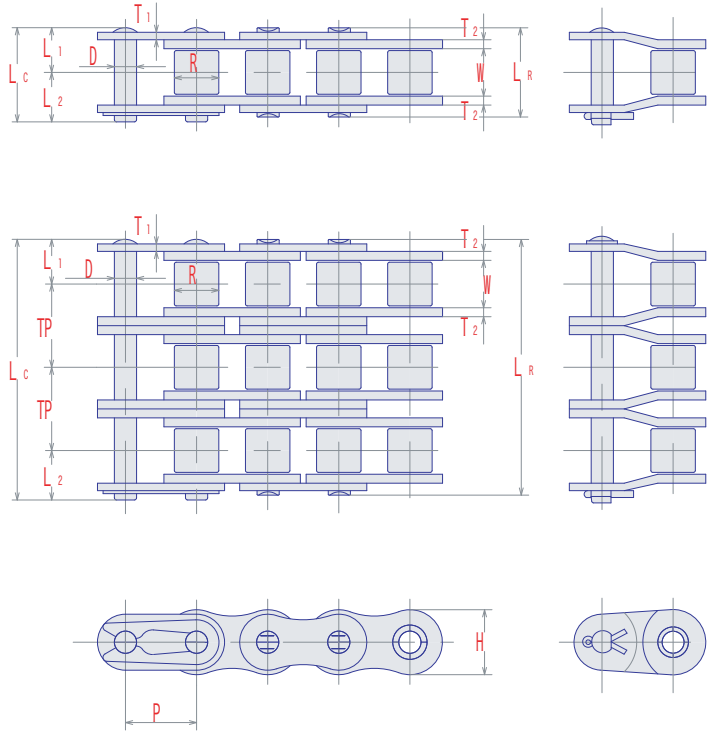
Standard Length Packaging

Chain no	Pitch	Standard Box	20' Box	50' Reel	100' Reel	200' Reel	250' Reel	500 Reel
25	6.35	480 Links	-	-	-	-	-	X
35	9.525	320 Links	X	X	-	-	X	-
40	12.70	240 Links	X	X	X	X	-	-
41	12.70	240 Links	-	-	-	-	X	-
50	15.875	192 Links	X	X	X	-	-	-
60	19.05	160 Links	X	X	X	-	-	-
80	25.40	120 Links	-	X	-	-	-	-
100	31.75	96 Links	-	X	-	-	-	-
120	38.10	80 Links	-	-	-	-	-	-
140	44.45	68 Links	-	-	-	-	-	-
160	50.80	60 Links	-	-	-	-	-	-
180	57.15	54 Links	-	-	-	-	-	-
200	63.50	48 Links	-	-	-	-	-	-
240	76.20	40 Links	-	-	-	-	-	-

HKK Chain No. (ANSI)	Dimensions - mm									Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate		Trans. Pitch				
		Width	Dia.	Dia.	Length	Height	Thick.					
		P	W	R	D	L1	L2		H			
HKK 120	38.10	25.40	22.23	11.10	24.8	28.6	35.1	4.8	-	167	38.0	5.76
HKK 120-2					47.5	51.3			45.4	334	51.7	11.49
HKK 120-3					70.2	74.0				501	76.0	17.20
HKK 120-4					93.1	96.9				668	100	22.92
HKK 120-5					115.8	119.6				835	119	28.65
HKK 120-6					138.5	142.3				1002	140	34.36
HKK 120-8					183.8	187.9				1336	188	45.81
HKK 140	44.45	25.40	25.4	12.70	27.0	31.3	40.9	5.6	-	216	50.3	7.41
HKK 140-2					51.5	55.7			48.9	432	68.3	14.63
HKK 140-3					75.9	80.4				648	101	21.91
HKK 140-4					100.6	104.9				864	133	29.17
HKK 140-5					125.1	129.3				1080	157	36.45
HKK 140-6					149.5	153.8				1296	185	43.72
HKK 140-8					198.3	202.8				1728	249	58.28
HKK 160	50.80	31.75	28.58	14.28	32.2	36.5	46.7	6.4	-	275	66.3	9.79
HKK 160-2					61.4	65.8			58.5	550	90.1	19.45
HKK 160-3					90.7	95.0				825	133	29.17
HKK 160-4					120.2	124.5				1100	175	38.77
HKK 160-5					149.4	153.9				1375	207	48.43
HKK 160-6					178.7	183.0				1650	244	58.08
HKK 160-8					237.2	214.6				2200	329	77.39
HKK 180	57.15	35.70	35.70	17.45	36.3	42.1	52.5	7.2	-	353	70.6	13.39
HKK 180-2					69.1	74.9			65.8	706	98.4	26.62
HKK 180-3					102.3	107.9				1059	145	39.85
HKK 180-4					135.1	140.8				1412	191	53.08
HKK 180-5					173.6	173.7				1765	226	66.31
HKK 180-6					200.9	206.4				2118	266	79.54
HKK 200	63.50	38.10	39.67	19.83	39.3	47.7	59.8	8.0	-	451	82.3	16.93
HKK 200-2					75.1	83.6			71.6	902	122	33.73
HKK 200-3					110.9	119.3				1353	179	50.53
HKK 200-4					146.7	155.7				1804	236	67.34
HKK 200-5					182.8	191.2				2255	279	84.14
HKK 200-6					218.6	227.0				2706	329	100.94
HKK 240	76.20	47.63	47.63	23.78	48.2	55.9	70.3	9.5	-	677	112.8	23.64
HKK 240-2					92.1	99.7			87.8	1354	167	47.13
HKK 240-3					136.0	143.6				2031	245	70.61
HKK 240-4					179.9	187.5				2708	324	94.09

British Standard Roller Chains

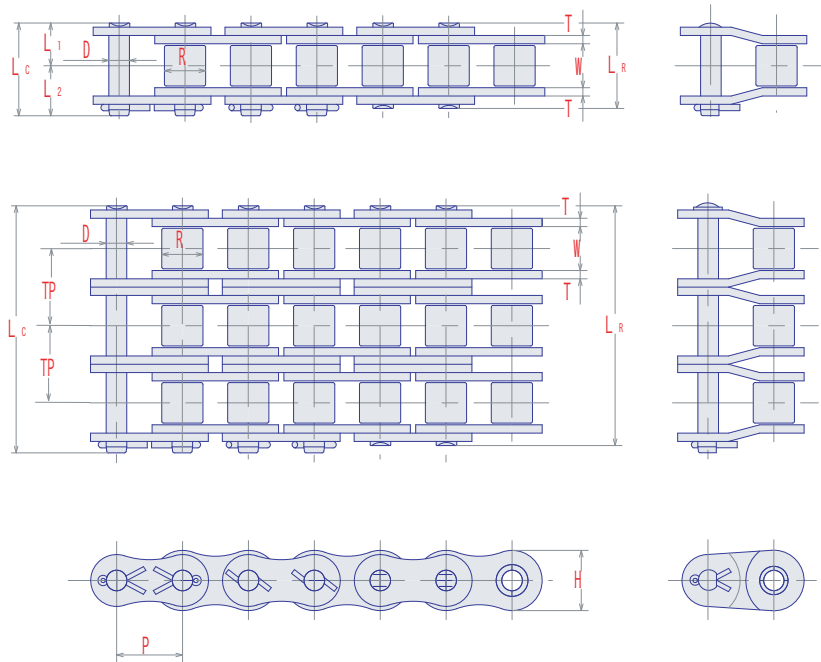
HKK British Standard chain is manufactured to the same high quality specifications as our ANSI chain. Solid bushings and solid rollers dramatically increase chain life. Manufactured in accordance with ISO R606, HKK British standard chains are compatible with British standard B.S. 228 and German standard DIN 8187. Attachment chains and stainless steel chains are available.



HKK British Chain No.	Dimensions - mm										Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin			Plate		Trans. Pitch				
		Width	Dia.	Dia.	Length		Height	Thick.					
	P	W	R	D	L1	L2	H	T1	T2	TP			
HKK 06B	9.525	5.72	6.35	3.28	6.3	7.1	8.2	1.0	1.25	10.24	8.92	1.7	0.41
HKK 06B-2											16.9	2.9	0.78
HKK 06B-3											24.9	4.2	1.18
HKK 08B	12.70	7.75	8.51	4.45	8.4	9.6	11.8	1.5	1.5	13.92	17.8	3.14	0.61
HKK 08B-2											31.1	5.35	1.26
HKK 08B-3											44.5	7.85	1.88
HKK 10B	15.875	9.65	10.16	5.08	9.5	11.2	14.7	1.65	1.65	16.59	22.2	4.90	0.89
HKK 10B-2											44.5	8.33	1.79
HKK 10B-3											66.7	12.2	2.66
HKK 12B	19.05	11.68	12.07	5.72	11.0	12.6	16.1	1.8	1.8	19.46	28.9	7.06	1.14
HKK 12B-2											57.8	12.0	2.28
HKK 12B-3											86.7	17.6	3.36
HKK 16B	25.40	17.02	15.88	8.26	17.6	20.6	21.0	3.2	4.0	31.88	60	12.6	2.59
HKK 16B-2											106	21.4	5.13
HKK 16B-3											160	31.5	7.68
HKK 20B	31.75	19.56	19.05	10.16	20.1	23.9	26.4	3.5	4.5	36.45	95	19.6	3.76
HKK 20B-2											170	33.3	7.26
HKK 20B-3											250	49.0	10.86
HKK 24B	38.10	25.40	25.40	14.63	26.7	31.4	33.4	4.9	5.9	48.36	160	27.5	7.29
HKK 24B-2											280	46.8	14.53
HKK 24B-3											425	68.8	21.76
HKK 28B	44.45	31.00	27.94	15.88	32.6	37.9	37.0	6.3	7.4	59.56	200	34.3	9.26
HKK 28B-2											360	58.3	18.45
HKK 28B-3											530	85.8	27.65
HKK 32B	50.80	31.00	29.21	17.81	32.5	38.6	42.2	6.3	6.9	58.55	250	39.2	9.92
HKK 32B-2											450	66.6	19.76
HKK 32B-3											670	98.0	29.61

Heavy Series Roller Chains

HKK Heavy series roller chains have increased link plate thickness to provide greater capacity without fatigue failure. Link plate thickness is that of the next larger size chain. The letter "H" following the number signifies the chain is of the Heavy series. Unlike many other brands, HKK single strand Heavy chains are manufactured with solid bushings, solid rollers, and through-hardened pins. Multiple strand Heavy series chains are also available.



HEAVY SERIES

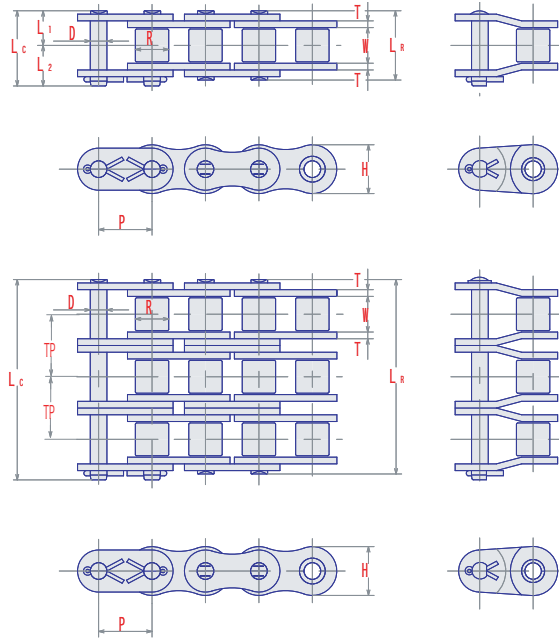
HKK Chain No.	Dimensions - mm									Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate		Trans. Pitch				
		Width	Dia.	Dia.	Length	Height	Thick.					
		P	W	R	D	L1	L2		H			
HKK 50H **	15.875	9.4	10.16	5.08	11.0	12.5	15.0	2.4	-	32.3	7.2	1.14
HKK 60H	19.05	12.70	11.91	5.95	14.4	16.4	17.5	3.2	-	54.9	10.7	1.80
HKK 60-2H					27.4	29.6			26.1	110	15.2	3.59
HKK 80H	25.40	15.88	15.88	7.93	17.9	20.8	23.4	4.0	-	90.2	18.4	2.81
HKK 80-2H					34.2	37.1			32.6	180	25.8	5.54
HKK 100H	31.75	19.05	19.05	9.53	21.2	24.7	29.3	4.8	-	137	28.3	4.14
HKK 100-2H					40.8	44.2			39.1	274	39.1	8.20
HKK 120H	38.10	25.40	22.23	11.10	26.4	30.8	35.1	5.6	-	186	38.0	5.83
HKK 120-2H					51.0	55.1			48.9	372	53.4	11.56
HKK 140H	44.45	25.40	25.40	12.70	28.6	33.2	40.9	6.4	-	241	50.3	8.41
HKK 140-2H					54.7	59.3			52.2	482	70.0	16.59
HKK 160H	50.80	31.75	28.58	14.28	34.0	39.0	46.7	7.2	-	306	66.3	10.86
HKK 160-2H					64.9	70.0			61.9	612	93.3	21.21
HKK 180H	57.15	35.70	35.70	17.45	37.8	43.7	52.5	8.0	-	373	70.6	15.18
HKK 180-2H					72.1	77.7			68.6	746	102	31.06
HKK 200H	63.50	38.10	39.67	19.83	42.4	51.0	59.8	9.5	-	520	82.3	17.85
HKK 200-2H					81.6	90.4			78.3	1040	127	35.20
HKK 240H	76.20	47.63	47.63	23.78	54.9	63.3	70.3	12.7	-	726	112.8	32.29
HKK240H-2					105.5	113.9			1452	173	62.06	

** Split Bushing & Case Hardened Pins

Oil-Field Chains (E Series)

HKK Oil-field chains are manufactured in accordance with ANSI, API standards, and officially approved by The American Petroleum Institute for high quality, reliability and long trouble-free service life. Used in oil-field drilling and producing operations such as hoisting, pumping and drawworks.

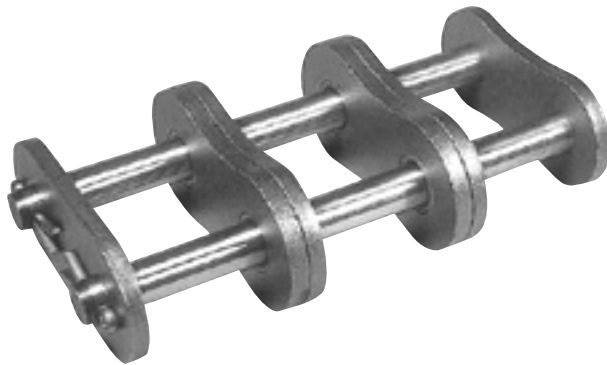
HKK E & HE-series roller chains are manufactured in the same standards as oil-field chains.



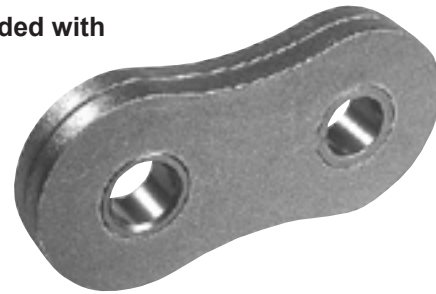
E TYPE

HKK Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin		Plate		Trans. Pitch TP				
		Width W	Dia. R	Dia. D	Length L1 L2	Height H	Thick. T					
HKK 80E	25.4	15.88	15.88	7.93	16.4	19.1	23.4	3.2	29.3	79.4	18.4	2.52
HKK 80E-2					30.8	33.7				159	26.7	5.10
HKK 80E-3					45.5	48.6				238	39.3	7.68
HKK 80E-4					60.2	63.3				318	51.8	10.25
HKK 80E-5					74.9	77.9				397	61.2	12.84
HKK 80E-6					89.6	92.5				476	72.2	15.42
HKK 80E-8					118.8	121.8				635	97.3	20.58
HKK 100E					31.75	19.05				19.05	9.53	19.7
HKK 100E-2	37.6	41.2	238	40.8			7.74					
HKK 100E-3	55.5	59.1	357	60.0			11.58					
HKK 100E-4	73.7	77.1	476	79.2			15.40					
HKK 100E-5	91.5	95.1	595	93.6			19.26					
HKK 100E-6	109.4	113.0	714	110			23.10					
HKK 100E-8	145.2	148.9	952	149			30.81					
HKK 100E-10	181.0	184.7	1190	180			38.54					
HKK 120E	38.10	25.40	22.23	11.10	24.8	28.6	35.1	4.8	45.4	174	38.0	5.76
HKK 120E-2					47.5	51.3				348	54.2	11.49
HKK 120E-3					70.2	74.0				522	79.8	17.20
HKK 120E-4					93.1	96.9				696	105	22.92
HKK 120E-5					115.8	119.6				870	124	28.65
HKK 120E-6					138.5	142.3				1044	147	34.36
HKK 120E-8					183.8	187.9				1392	198	45.81
HKK 120E-10					229.2	233.3				1740	239	57.38

Oil-Field Chains (E Series)



BCL Connecting Links provided with press-fit type chains

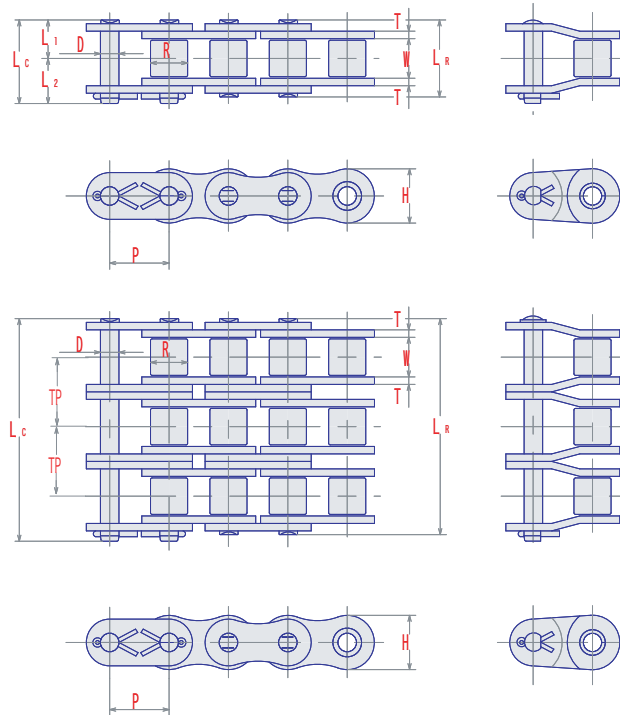


E TYPE

HKK Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Pin		Plate		Trans. Pitch				
		Width	Dia.	Dia.	Length		Height		Thick.			
	P	W	R	D	L1	L2	H	T	TP			
HKK 140E	44.45	25.40	25.40	12.70	27.0	31.3	40.9	5.6	-	227	50.3	7.41
HKK 140E-2					51.5	55.7			48.9	454	73.2	14.63
HKK 140E-3					75.9	80.4			681	108	21.91	
HKK 140E-4					100.6	104.9			908	142	29.17	
HKK 140E-5					125.1	129.3			1135	168	36.45	
HKK 140E-6					149.5	153.8			1362	198	43.72	
HKK 140E-8					198.3	202.8			1816	267	58.28	
HKK 160E	50.80	31.75	28.58	14.28	32.2	36.5	46.7	6.4	-	294	66.3	9.79
HKK 160E-2					61.4	65.8			58.5	588	95.0	19.45
HKK 160E-3					90.7	95.0			882	140	29.17	
HKK 160E-4					120.2	124.5			1176	184	38.77	
HKK 160E-6					149.4	153.9			1764	257	58.08	
HKK 180E	57.15	35.70	35.70	17.45	36.3	42.1	52.5	7.2	-	363	70.6	13.39
HKK 180E-2					69.1	74.9			65.8	726	102	26.62
HKK 180E-3					102.3	107.9			1089	150	39.85	
HKK 180E-4					135.1	140.8			1452	197	53.08	
HKK 200E	63.50	38.10	39.67	19.83	39.3	47.7	59.8	8.0	-	470	82.3	16.93
HKK 200E-2					75.1	83.6			71.6	940	130	33.73
HKK 200E-3					110.9	119.3			1410	191	50.53	
HKK 200E-4					146.7	155.7			1880	252	67.34	
HKK 240E	76.20	47.63	47.63	23.78	48.2	55.9	70.3	9.5	-	677	112.8	23.64
HKK 240E-2					92.1	99.7			87.8	1354	179	47.13
HKK 240E-3					136.0	143.6			2031	263	70.61	
HKK 240E-4					179.9	187.5			2708	347	94.09	

Oil-Field Chains (HE Series)

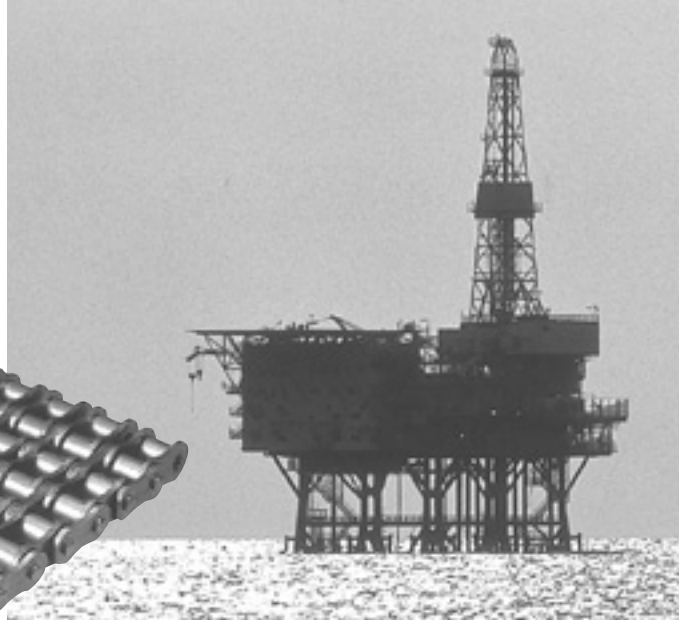
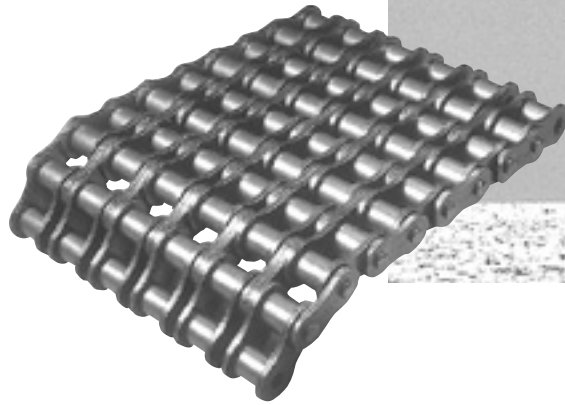
HKK Heavy series roller chains are designed with thicker side plates to insure greater capacity for absorbing shock loads without fatigue failure of side plates. Also manufactured to close tolerances in accordance with ANSI specifications and are mainly used for applications where space and design limitations prohibit the use of a large size roller chain, and yet greater load carrying capacities are needed in oil-filled drilling operations.



HE TYPE

HKK Chain No.	Dimensions - mm									Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate		Trans. Pitch				
		Width	Dia.	Dia.	Length	Height	Thick.					
P	W	R	D	L1	L2	H	T	TP	kN	kN	kg/m	
HKK 80HE	25.4	15.88	15.88	7.93	17.8	21.1	23.4	4.0	-	93.2	18.4	2.80
HKK 80HE-2					34.2	37.1			32.6	186	28.4	5.54
HKK 80HE-3					50.5	53.5				280	41.8	8.26
HKK 80HE-4					66.8	69.9				373	55.1	10.98
HKK 80HE-5					83.1	86.2				466	65.1	13.71
HKK 80HE-6					99.4	102.5				559	76.8	16.43
HKK 80HE-8					132.0	135.1				746	104	21.88
HKK 100HE	31.75	19.05	19.05	9.53	21.1	24.6	29.3	4.8	-	142	28.3	4.14
HKK 100HE-2					40.8	44.2			39.1	284	45.1	8.20
HKK 100HE-3					60.4	64.0				426	66.3	12.26
HKK 100HE-4					79.7	83.5				568	87.5	16.33
HKK 100HE-5					99.3	103.0				710	103	20.39
HKK 100HE-6					119.1	122.7				852	122	24.45
HKK 100HE-8					158.2	161.8				1136	164	32.58
HKK 100HE-10					197.3	200.9				1420	199	40.70
HKK 120HE	38.10	25.40	22.23	11.10	26.3	30.7	35.1	5.6	-	191	38.0	5.83
HKK 120HE-2					51.0	55.1			48.9	382	58.3	11.56
HKK 120HE-3					75.3	79.3				573	85.8	17.29
HKK 120HE-4					99.6	104.1				764	113	23.02
HKK 120HE-5					123.9	128.7				955	134	28.75
HKK 120HE-6					148.8	152.7				1146	158	34.48
HKK 120HE-8					197.7	202.0				1528	213	45.94
HKK 120HE-10					246.6	250.9				1910	257	57.40

Oil-Field Chains (HE Series)



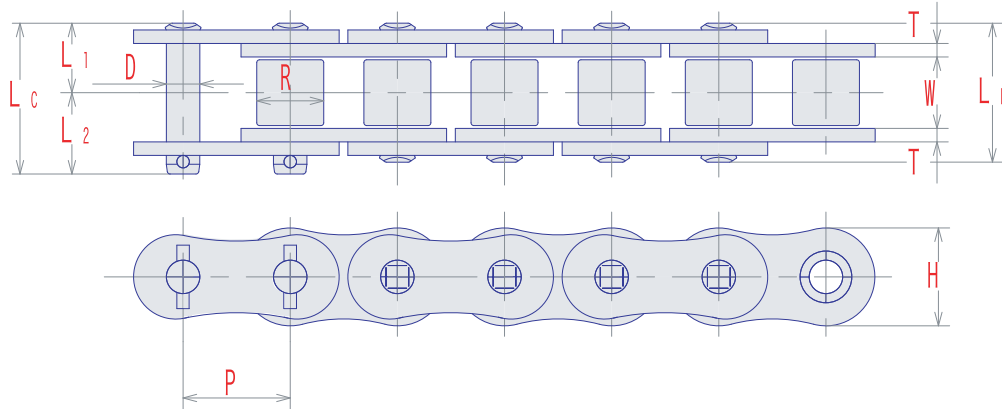
HE TYPE

HKK Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Pin		Plate		Trans. Pitch				
		Width	Dia.	Dia.	Length	Height	Thick.					
	P	W	R	D	L1	L2	H	T	TP			
HKK 140HE	44.45	25.40	25.40	12.70	28.5	33.1	40.9	6.4	-	252	50.3	8.41
HKK 140HE-2					54.7	59.3			52.2	504	76.7	16.59
HKK 140HE-3					80.9	85.5			756	113	24.77	
HKK 140HE-4					107.0	111.7			1008	149	32.96	
HKK 140HE-5					133.1	137.8			1260	176	41.15	
HKK 140HE-6					159.2	163.9			1512	207	49.33	
HKK 140HE-8					211.4	216.1			2016	280	65.78	
HKK 160HE					50.80	31.75			28.58	14.28	33.9	39.1
HKK 160HE-2	64.9	70.0	61.9	638			100	21.21				
HKK 160HE-3	95.9	100.9	957	147			31.54					
HKK 160HE-4	126.9	131.9	1276	194			41.89					
HKK 160HE-6	188.8	193.8	1914	270			62.58					
HKK 180HE	57.15	35.70	35.70	17.45			37.9	43.5			52.5	8.0
HKK 180HE-2					72.1	77.7	68.6	882	121	30.06		
HKK 180HE-3					106.4	112.3	1323	179	44.94			
HKK 180HE-4					140.7	146.7	1764	236	59.83			
HKK 200HE	63.50	38.10	39.67	19.83	42.5	50.8	59.8	9.5	-	559	82.3	17.85
HKK 200HE-2					81.6	90.4			78.3	1118	138	35.20
HKK 200HE-3					120.7	129.6			1677	204	52.53	
HKK 200HE-4					159.9	168.7			2236	269	69.94	
HKK 240HE	76.20	47.63	47.63	23.78	55.6	62.0	70.3	12.7	-	883	112.8	32.29
HKK 240HE-2					105.8	113.1			101.2	1766	192	62.06
HKK 240HE-3					156.3	163.8			2649	283	91.82	
HKK 240HE-4					207.0	214.3			3532	373	121.58	

Super Roller Chains

HKK Super & Super Heavy series chains are designed to provide longer chain life under severe loads. Enhanced plate configuration and ball milling plate holes ensure greater tensile strength and resistance to fatigue failure. High-grade alloy steel and four point riveting provide higher shock load capacities.

Super Heavy series chains have side plate thickness of the next larger chain size. Both Super and Super Heavy run on standard sprockets.



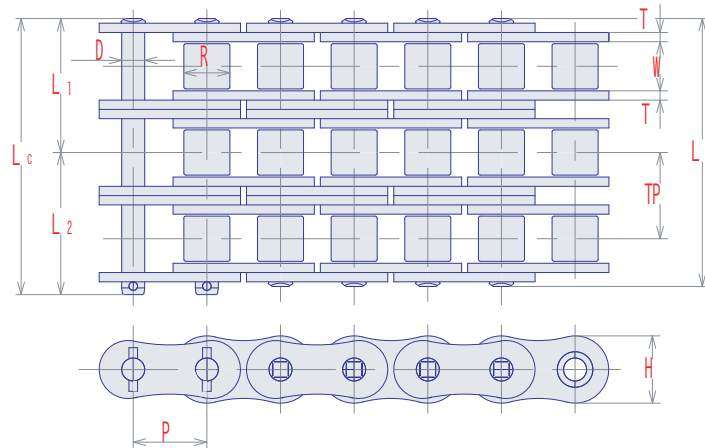
SUPER STANDARD

HKK Chain No. ANSI	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate					
		Width	Dia.	Dia.	Length	Height	Thick.				
		P	W	R	D	L1	L2	H			
HKK Super Standard Chain											
HKK 80 Super	25.40	15.88	15.88	7.93	16.3	19.2	24.1	3.2	84.3	18.6	2.81
HKK 80-2 Super					31.0	33.9			169	31.6	5.63
HKK 80-3 Super					45.7	48.5			253	46.5	8.41
HKK 80-4 Super					60.3	63.2			337	61.4	11.18
HKK 100 Super	31.75	19.05	19.05	9.53	19.9	23.1	30.1	4.0	127	30.4	4.26
HKK 100-2 Super					37.7	41.3			254	41.7	8.38
HKK 100-3 Super					55.6	59.2			381	76.0	12.57
HKK 100-4 Super					73.5	77.1			508	100	16.77
HKK 120 Super	38.10	25.40	22.23	11.10	29.9	28.8	36.2	4.8	186	39.2	6.30
HKK 120-2 Super					47.7	51.7			372	66.6	12.44
HKK 120-3 Super					70.4	74.4			558	98.0	18.65
HKK 120-4 Super					93.1	97.1			744	129	24.85
HKK 140 Super	44.45	25.40	25.40	12.70	27.0	31.3	42.2	5.6	245	53.9	8.04
HKK 140-2 Super					51.7	55.9			490	91.6	15.92
HKK 140-3 Super					76.1	80.4			735	135	23.84
HKK 140-4 Super					100.6	104.8			980	178	30.72
HKK 160 Super	50.80	31.75	28.58	14.28	32.2	36.8	48.2	6.4	314	70.6	10.8
HKK 160-2 Super					61.6	66.2			628	120	21.44
HKK 160-3 Super					90.9	95.4			942	177	32.10
HKK 160-4 Super					120.1	124.7			1256	233	42.84
HKK 200 Super	63.50	38.10	39.67	19.83	39.3	46.9	60.3	8.0	490	94.1	17.6
HKK 200-2 Super					75.3	82.9			980	160	34.91
HKK 200-3 Super					111.1	118.7			1470	235	52.44
HKK 200-4 Super					146.9	154.5			1960	311	69.74
HKK 240-2 Super	76.20	47.63	47.63	23.78	48.2	55.2	72.4	9.5	726	132	25.6
HKK 240-2 Super					92.1	99.1			1452	224	50.88
HKK 240-3 Super					136.0	143.0			2178	330	76.12
HKK 240-4 Super					179.9	186.9			2904	436	101.40

Super Roller Chains

HKK Super & Super Heavy series chains are designed to provide longer chain life under severe loads. Enhanced plate configuration and ball milling plate holes ensure greater tensile strength and resistance to fatigue failure. High-grade alloy steel and four point riveting provide higher shock load capacities.

Super Heavy series chains have side plate thickness of the next larger chain size. Both Super and Super Heavy run on standard sprockets.



SUPER HEAVY

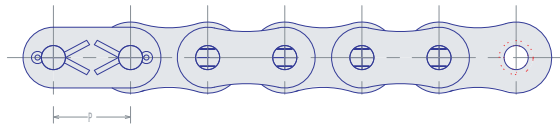
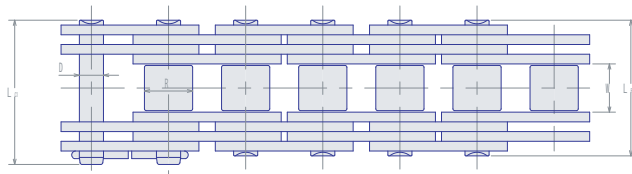
HKK Chain No. ANSI	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate					
		Width	Dia.	Dia.	Length	Height	Thick.				
P	W	R	D	L1	L2	H	T	kN	kN	kg/m	
HKK Super Heavy Chain											
HKK 80 Super H	25.40	15.88	15.88	7.93	18.0	20.9	24.1	4.0	98.1	20.6	3.33
HKK 80-2 Super H					34.3	365.1			196.2	35.02	6.67
HKK 80-3 Super					50.6	381.4			294.3	51.5	9.96
HKK 100 Super H	31.75	19.05	19.05	9.53	21.3	24.9	30.1	4.8	145	32.4	4.88
HKK 100-2 Super H					40.8	44.6			290	55.08	9.6
HKK 100-3 Super					60.4	64.1			435	81.0	14.4
HKK 120 Super H	38.10	25.40	22.23	11.10	26.4	30.9	36.2	5.6	196	42.2	6.94
HKK 120-2 Super H					51.0	122.4			392	71.74	13.71
HKK 120-3 Super					75.5	79.6			588	105.5	20.55
HKK 140 Super H	44.45	25.40	25.40	12.70	28.6	33.3	42.2	6.4	255	56.9	8.87
HKK 140-2 Super H					54.8	219.7			510	96.73	17.56
HKK 140-3 Super					80.9	245.8			765	142.25	26.3
HKK 160 Super H	50.80	31.75	28.58	14.28	34.0	38.8	48.2	7.1	324	73.5	11.7
HKK 160-2 Super H					111.9	276.8			648	124.95	23.15
HKK 160-3 Super					142.8	100.7			972	183.75	34.67

Double Capacity Chains

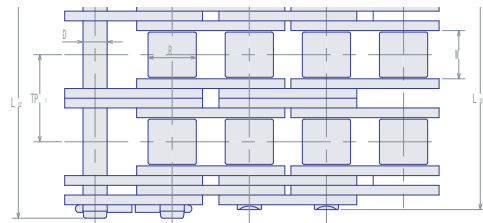
Double Capacity Chain is single strand chain that offers the same ultimate tensile strength as a double strand chain with a saving of 50%.

Double Capacity Chain consists of twice the amount of side plates as single strand chain.

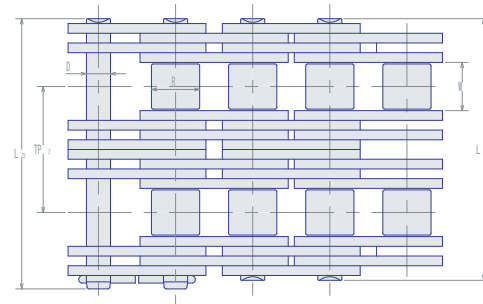
DC (x2)



TC (X3)



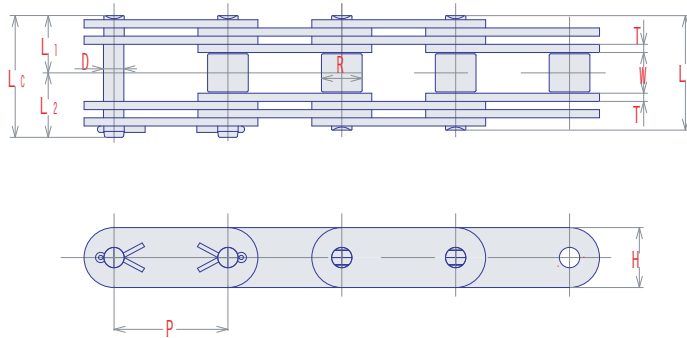
FC (X4)



DOUBLE CAPACITY

HKK Chain No.	Dimensions - mm								Average Ultimate Strength (kN)			Maximum Allowable Load (kN)
	Pitch	Roller		Pin			Transverse Pitch		DC	TC	FC	DC
		Width	Dia.	Dia.	Length		TP1	TP2				
	P	W	R	D	LR1	LC2	TP1	TP2	DC	TC	FC	DC
HKK 16BDC TC-FC	25.40	17.02	15.88	8.26	50.0	53.2	31.9	44.7	137	205	274	19.5
HKK 20BDC TC-FC	31.75	19.56	19.05	10.16	56.0	60.4	36.5	50.5	212	318	424	30.2
HKK 24BDC TC-FC	38.10	25.40	25.40	14.63	75.4	80.5	48.4	68.0	359	538	718	51.2
HKK 28BDC TC-FC	44.45	31.00	27.94	15.88	93.0	98.8	59.6	84.8	447	670	894	63.8
HKK 32BDC TC-FC	50.80	31.00	29.21	17.81	92.4	98.5	58.6	83.8	549	823	1098	78.4
HKK 80 DC TC-FC	25.40	15.88	15.88	7.93	45.6	48.7	29.3	42.1	157	235	314	22.4
HKK 100 DC TC-FC	31.75	19.05	19.05	9.53	55.8	59.5	35.8	51.8	235	352	470	33.5
HKK 120 DC TC-FC	38.10	25.40	22.23	11.10	69.0	73.3	45.4	64.2	343	514	686	49.0
HKK 140 DC TC-FC	44.45	25.40	25.40	12.70	76.4	81.1	48.9	71.3	451	676	902	64.4
HKK 160 DC TC-FC	50.80	31.75	28.58	14.28	90.0	95.1	58.5	84.1	559	838	1118	79.8
HKK 180 DC TC-FC	57.15	35.70	35.70	17.45	101.6	107.7	65.8	94.6	726	1089	1452	103.0
HKK 200 DC TC-FC	63.50	38.10	39.67	19.83	111.2	120.0	71.6	103.6	932	1398	1864	133.0
HKK 240 DC TC-FC	76.20	47.63	47.63	23.78	135.6	143.2	87.8	125.8	1353	2029	2706	193.0

Double Capacity Chains



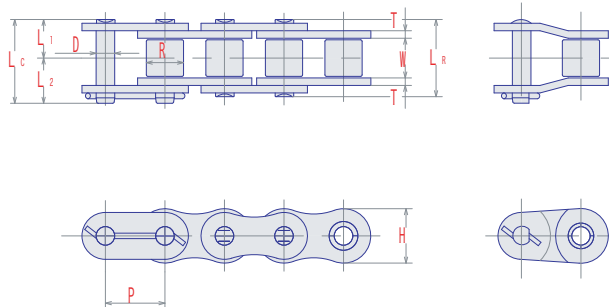
DOUBLE PITCH TYPE

HKK Chain No.	Dimensions - mm										Average Allowable Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Pin				Plate					
		Width	Dia.	Dia.	Length			Height	Thick.				
	P	W	R	D	LR	LC	L1	L2	H	T			
HKK 2040 DC	25.40	7.95	7.92	3.96	23.0	24.7	11.5	13.2	11.4	1.5	38.2	4.02	0.50
HKK 2050 DC	31.75	9.53	10.16	5.08	28.8	30.5	14.4	16.1	15.0	2.0	63.8	6.72	0.85
HKK 2060H DC	38.10	12.70	11.91	5.95	42.2	44.2	21.1	23.1	17.0	3.2	109.8	11.56	1.46
HKK 2080H DC	50.80	15.88	15.88	7.93	52.0	55.1	26.0	29.1	22.6	4.0	180.4	18.99	2.50
HKK 2100H DC	63.50	19.05	19.05	9.53	62.0	65.6	31.0	34.6	28.6	4.8	274.0	28.84	3.81
HKK 2120H DC	76.20	25.40	22.23	11.10	77.8	82.1	38.9	43.2	34.9	5.6	372.0	39.16	5.50
HKK 2160H DC	101.60	31.75	28.58	14.28	97.4	102.6	48.7	53.9	47.6	7.2	612.0	64.42	9.27

S-Series Roller Chains

S-Series roller chains are designed for high breaking strength and maximum endurance in pursuit of greater chain rigidity. Combination of plates one size thicker than standard's and thick,

tough pins ensures accurate operations and long performance life under harsh, heavy loads. Single strand roller chains of this series run on standard single roller chain sprockets.



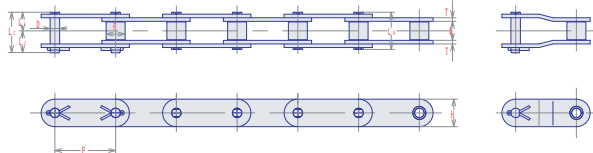
HKK Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Pin			Plate					
		Width	Dia.	Dia.	Length		Height	Thick.				
	P	W	R	D	L1	L2	H	T	kN			
HKK 251S	50.80	31.75	28.58	15.88	34.0	39.2	46.7	7.2	333	58.8	11.31	
HKK 264S	63.50	38.10	39.67	22.22	42.9	51.6	59.8	9.5	556	81.4	19.27	

Double Pitch Roller Chains

HKK Double-Pitch roller chain is similar to HKK standard roller chain, except the pitch is twice that of standard roller chain. These chains weigh less and are lower in cost than standard roller chain of the same strength. They are ideal for slow and moderate speed applications, particularly when shaft centers are relatively long.

There are two types of double-pitch chains. Transmission type has figure-eight shaped link plates. Conveyor type has straight edged link plates. Conveyor type chains are available with standard rollers or with oversized carrier rollers. Conveyor series chains with 1.5" pitch and larger are constructed with heavy series side plates. HKK Double-Pitch chains are manufactured to the highest standards, and with solid bushings and solid rollers.

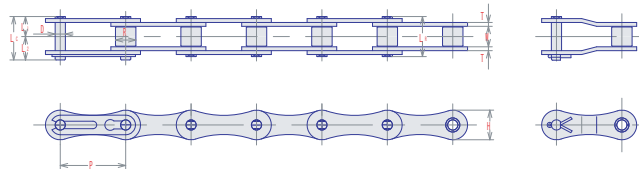
Conveyor Type



CONVEYOR TYPE

HKK Chain No.	Dimensions - mm								Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin			Plate				
		Width W	Dia. R	Dia. D	Length L1 L2		Height H	Thick. T			
STANDARD ROLLER											
HKK C 2040	25.40	7.95	7.92	3.96	8.2	10.3	11.4	1.5	16.9	3.63	0.48
HKK C 2050	31.75	9.53	10.16	5.08	10.2	11.8	15.0	2.0	27.5	6.28	0.82
HKK C 2060H	38.10	12.70	11.91	5.95	14.4	16.6	17.0	3.2	40.2	8.63	1.38
HKK C 2080H	50.80	15.88	15.88	7.93	17.8	21.0	22.6	4.0	68.6	14.7	2.32
HKK C 2100H	63.50	19.05	19.05	9.53	21.1	24.6	28.6	4.8	107.9	22.6	3.46
HKK C 2120H	76.20	25.40	22.23	11.10	26.3	30.7	34.9	5.6	151.0	30.4	4.92
HKK C 2160H	101.60	31.75	28.58	14.28	33.9	39.0	47.6	7.2	257.9	53.0	8.02
CARRIER ROLLER											
HKK C 2042	25.40	7.95	15.88	3.96	8.2	10.3	11.4	1.5	16.9	3.63	0.82
HKK C 2052	31.75	9.53	19.05	5.08	10.2	11.8	15.0	2.0	27.5	6.28	1.26
HKK C 2062H	38.10	12.70	22.23	5.95	14.4	16.6	17.0	3.2	40.2	8.63	2.08
HKK C 2082H	50.80	15.88	28.58	7.93	17.8	21.0	22.6	4.0	68.6	14.7	3.36
HKK C 2102H	63.50	19.05	39.67	9.53	21.1	24.6	28.6	4.8	107.9	22.6	5.64
HKK C 2122H	76.20	25.40	44.45	11.10	26.3	30.7	34.9	5.6	151.0	30.4	7.87
HKK C 2162H	101.60	31.75	57.15	14.28	33.9	39.0	47.6	7.2	257.9	53.0	12.77

Transmission Type



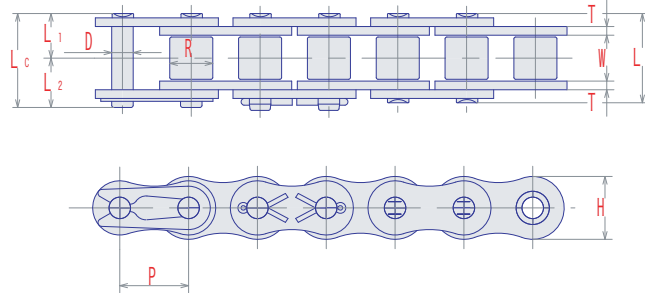
TRANSMISSION TYPE

HKK Chain No.	Dimensions - mm								Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin			Plate				
		Width W	Dia. R	Dia. D	Length L1 L2		Height H	Thick. T			
HKK A 2040	25.40	7.95	7.92	3.96	8.3	9.6	11.4	1.5	16.7	2.65	0.43
HKK A 2050	31.75	9.53	10.16	5.08	10.2	11.8	15.0	2.0	27.5	4.31	0.73
HKK A 2060	38.10	12.70	11.91	5.95	12.8	14.1	17.0	2.4	40.2	6.23	1.03
HKK A 2080	50.80	15.88	15.88	7.93	16.4	18.8	22.6	3.2	68.2	10.7	1.71

Stainless Steel Chains (ANSI & BS)

HKK Stainless Steel roller chains are used in highly corrosive and extreme temperature environments. All component parts of HKK Stainless Steel roller chains are made of 300 series stainless steel, to achieve the utmost corrosion and temperature resistance.

HKK Stainless Steel chains are equipped with solid rollers. This unique solid roller will not split or deform like conventional split rollers. These solid rollers enhance durability of the chain, especially under extreme loads and temperatures. HKK Stainless Steel roller chains are manufactured in accordance with ANSI dimensional specifications. 600 series stainless steel is also available.



ANSI STAINLESS STEEL CHAIN

HKK Chain No.	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin			Plate				
		Width	Dia.	Dia.	Length		Height	Thick.			
P	W	R	D	L1	L2	H	T1	kN	kN	kg/m	
HKK 25-SS *	6.35	3.10	3.30	2.30	3.8	4.7	6.0	0.75	3.3	0.1	0.13
HKK 35-SS *	9.525	4.78	5.08	3.58	6.1	7.6	9.0	1.25	5.68	0.26	0.34
HKK 41-SS ••	12.70	6.25	7.77	3.58	6.5	8.0	9.6	1.25	8.4	0.3	0.40
HKK 40-SS	12.70	7.95	7.92	3.96	8.5	10.0	11.7	1.5	11.1	0.44	0.60
HKK 40-2-SS									22.2	0.9	1.2
HKK 50-SS	15.875	9.53	10.16	5.08	10.4	11.9	14.6	2.0	17.6	0.68	0.98
HKK 50-2-SS									35.2	1.3	2.0
HKK 60-SS	19.05	12.70	11.91	5.95	13.0	14.9	14.9	2.4	24.5	1.03	1.46
HKK 60-2-SS									49.0	2.0	2.9
HKK 80-SS	25.40	15.88	15.88	7.93	16.4	19.1	23.4	3.2	42.3	1.77	2.52
HKK 80-2-SS									84.6	3.5	5.1
HKK 100-SS	31.75	19.05	19.05	9.53	20.0	23.3	29.3	4.0	51.0	2.55	3.91
HKK 100-2-SS									102	5.0	7.7
HKK 120-SS	38.10	25.40	22.23	11.10	27.0	29.0	35.1	4.8	68.6	3.92	5.76
HKK 120-2-SS									137	7.8	11.5

* Rollerless Chain : Roller Diameter 'R' is identical to the bushing, as these chains have no rollers & split bushings

•• Split Roller Chains

BS STAINLESS STEEL CHAIN

HKK British Chain No.	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin			Plate				
		Width	Dia.	Dia.	Length		Height	Thick.			
P	W	R	D	L1	L2	H	T1	kN	kN	kg/m	
HKK 05B-SS ••	8.00	3.1	5.00	2.30	3.8	4.7	7.1	0.75	3.0	0.1	0.18
HKK 06B-SS ••	9.525	5.72	6.35	3.28	6.3	7.1	8.2	1.0/1.25	6.18	0.27	0.43
HKK 08B-SS	12.70	7.85	8.51	4.45	8.4	9.4	11.8	1.5	10.3	0.52	0.61
HKK 10B-SS	15.875	9.65	10.16	5.08	9.5	11.1	14.7	1.65	15.7	0.68	0.89
HKK 12B-SS	19.05	11.68	12.07	5.72	11.0	12.6	16.1	1.8	18.1	0.88	1.14
HKK 16B-SS	25.40	17.02	15.88	8.26	18.6	20.6	20.3	3.2/4.0	42.2	2.06	2.59

•• Split Roller Chains

Stainless Steel Double Pitch Roller Chains

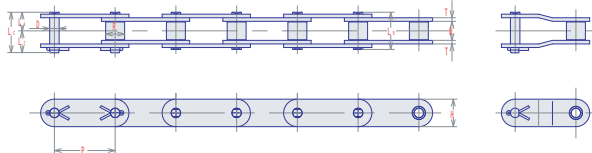
HKK Double-Pitch, Stainless Steel chain combine the same corrosion resistance and high temperature range as our single-pitch stainless chain, while maintaining lower cost and weight. All component parts of HKK stainless steel chains are made of 300 series stainless steel.

HKK Stainless Steel Double-Pitch chains are assembled with solid rollers. This unique solid roller will not split or deform like

conventional split rollers. Solid rollers will retain their original cylindrical shape under severe loads and adverse temperatures.

Transmission type chains with figure-eight side plates are available. HKK Double-Pitch Stainless Steel chain sizes C2060H and up are manufactured with heavy side plates. Carrier rollers and attachments are also available. 600 series stainless steel is available upon request.

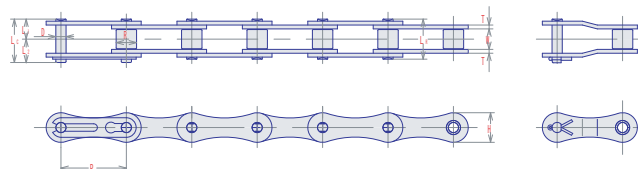
ConveyorType



CONVEYOR TYPE

HKK Stainless Chain No.	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate					
		Width	Dia.	Dia.	Length	Height	Thick.				
P	W	R	D	L1	L2	H	T	kN	kN	kg/m	
STANDARD ROLLER TYPE											
HKK C 2040-SS	25.40	7.95	7.92	3.96	8.5	10.0	11.4	1.5	12.4	0.44	0.43
HKK C 2050-SS	31.75	9.53	10.16	5.08	10.4	11.9	15.0	2.0	20.3	0.68	0.73
HKK C 2060H-SS	38.10	12.70	11.91	5.95	14.4	16.5	17.0	3.2	27.4	1.03	1.38
HKK C 2080H-SS	50.80	15.88	15.88	7.93	17.9	20.9	22.6	4.0	47.1	1.77	2.32
HKK C 2100H-SS	63.50	19.05	19.05	9.53	21.2	24.8	28.6	4.8	56.9	2.55	3.46
CARRIER ROLLER TYPE											
HKK C 2042-SS	25.40	7.95	15.88	3.96	8.5	10.0	11.4	1.5	12.4	0.44	0.82
HKK C 2052-SS	31.75	9.53	19.05	5.08	10.4	11.9	15.0	2.0	20.3	0.68	1.26
HKK C 2062H-SS	38.10	12.70	22.23	5.95	14.4	16.5	17.0	3.2	27.4	1.03	2.08
HKK C 2082H-SS	50.80	15.88	28.58	7.93	17.9	20.9	22.6	4.0	47.1	1.77	3.36
HKK C 2102H-SS	63.50	19.05	39.67	9.53	21.2	24.8	28.6	4.8	56.9	2.55	5.64

Transmission Type



TRANSMISSION TYPE

HKK Stainless Chain No.	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate					
		Width	Dia.	Dia.	Length	Height	Thick.				
P	W	R	D	L1	L2	H	T	kN	kN	kg/m	
HKK A 2040-SS	25.40	7.95	7.92	3.96	8.5	10.0	11.4	1.5	12.4	0.44	0.43
HKK A 2050-SS	31.75	9.53	10.16	5.08	10.4	11.9	15.0	2.0	20.3	0.68	0.73
HKK A 2060-SS	38.10	12.70	11.91	5.95	13.0	14.9	17.0	2.4	27.4	1.03	1.03
HKK A 2080-SS	50.80	15.88	15.88	7.93	16.4	19.1	22.6	3.2	47.1	1.77	1.71

AQUA Proof Roller Chains

HKK 's Aqua-series Chain is the perfect choice where corrosion resistance and high strength is needed. Aqua-series chains are designed to provide maximum corrosion resistance, far superior to Zinc or Nickel plated chains, while maintaining the strength and durability of carbon steel chain. A two-step treatment process done before chain is assembled ensures all chain components are fully treated. All Aqua-series chains are standard with cold forged Solid Bushing & Rollers. Solid bushings and rollers provide dramatically longer life than conventional split bushing chains.

Feature :

Excellent corrosion resistance without plating same strength and working load values as standard roller chain with no hydrogen embitterment by surface treatment

Results of corrosion resistant tests :

Salt spray test

CHAINS	Hour for Rust developed (hours)
Special surface treated	1000 No rust
Glossy chromating	72 - 96
Coloured chromating	120 - 240
Molten zinc plating	120 - 240

Salt spray test

CHAINS	Hour for Rust developed (hours)
Nickel plated	48
Special surface treated	600 - 840
Made of SUS304 stainless steel	above 840 No rust

Applications :

Outdoor service, Sea water applications, Stacking crane, Car parking

Applicable Chains :

#40 - #240 , Attachment chain is available.

Purpose of Special surface treatment :

Linkplate for anticorrosion, Other parts for anticorrosion and to reduce friction

Caution :

For the food products industry where the chain may be exposed to direct food contact, stainless steel chain is recommended.

Applicable Chains :

Attachment chain is available. For identification, a suffix is added to the chain numbers.

ANTICORROSIVE TEST

Indoors, splashed 5% salty water morning & evening (15days after)

Maximum Corrosion Resistance & Strength in Wet Environments



Standard



NP

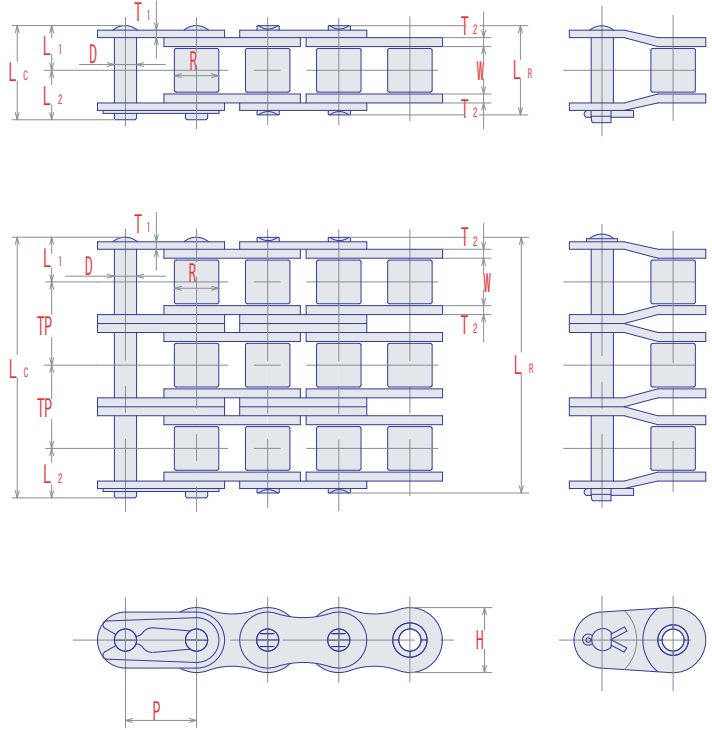
Stainless Steel

AP



AQUA Proof Roller Chains

HKK 's Aqua-series Chain is the perfect choice where corrosion resistance and high strength is needed. Aqua-series chains are designed to provide maximum corrosion resistance, far superior to Zinc or Nickel plated chains, while maintaining the strength and durability of carbon steel chain. A two-step treatment process done before chain is assembled ensures all chain components are fully treated. All Aqua-series chains are standard with cold forged Solid Bushing & Rollers. Solid bushings and rollers provide dramatically longer life than conventional split bushing chains.



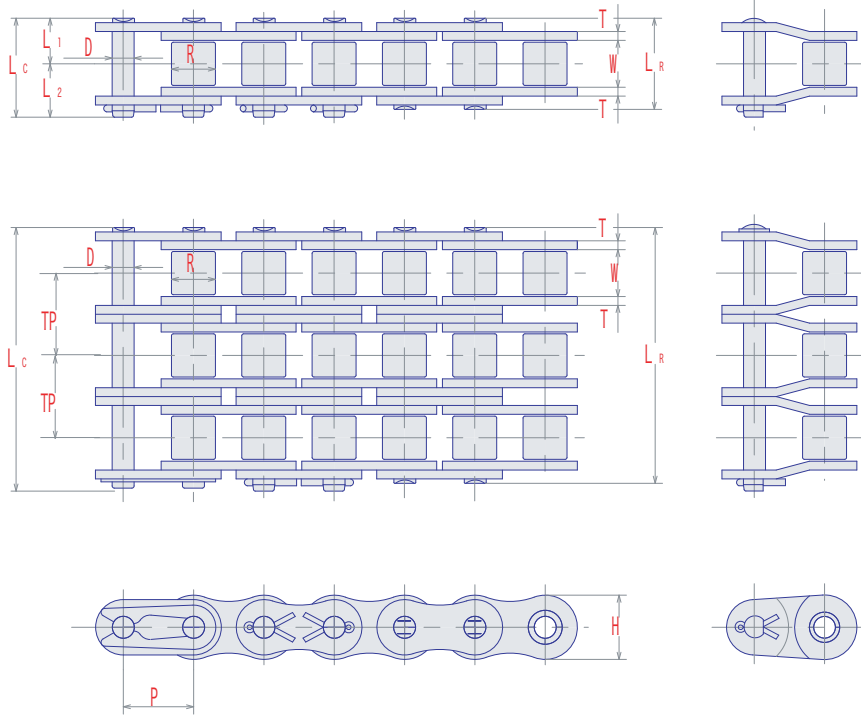
AQUA PROOF

HKK Aqua Chain No.	Dimensions - mm										Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin		Plate			Trans. Pitch TP				
		Width W	Dia. R	Dia. D	Length L1 L2		Height H	Thick. T1 T2					
HKK 08B	12.70	7.75	8.51	4.45	8.4	9.6	11.8	1.5	1.5	13.92	17.8	3.14	0.61
HKK 08B-2											31.1	5.35	1.26
HKK 08B-3											44.5	7.85	1.88
HKK 10B	15.875	9.65	10.16	5.08	9.5	11.2	14.7	1.65	1.65	16.59	22.2	4.90	0.89
HKK 10B-2											44.5	8.33	1.79
HKK 10B-3											66.7	12.2	2.66
HKK 10B-2											44.5	8.33	1.79
HKK 10B-3											66.7	12.2	2.66
HKK 12B	19.05	11.68	12.07	5.72	11.0	12.6	16.1	1.8	1.8	19.46	28.9	7.06	1.14
HKK 12B-2											57.8	12.0	2.28
HKK 12B-3											86.7	17.6	3.36
HKK 16B	25.40	17.02	15.88	8.26	17.6	20.6	21.0	3.2	4.0	31.88	60.0	12.6	2.59
HKK 16B-2											106	21.4	5.13
HKK 16B-3											160	31.5	7.68
HKK 20B	31.75	19.56	19.05	10.16	20.1	23.9	26.4	3.5	4.5	36.45	95	19.6	3.76
HKK 20B-2											170	33.3	7.26
HKK 20B-3											250	49.0	10.86
HKK 24B	38.10	25.40	25.40	14.63	26.7	31.4	33.4	4.9	5.9	48.36	160	27.5	7.29
HKK 24B-2											280	46.8	14.53
HKK 24B-3											425	68.8	21.76

Nickel Plated ANSI Roller Chains

HKK Nickel-Plated chains are used in mildly corrosive environments such as outdoors. Carbon steel Nickel-Plated chain is plated before assembly to ensure complete protection of all parts, while providing maximum strength.

HKK Nickel-Plated chains are manufactured with solid rollers and solid bushings to extend chain life. Nickel-Plated attachment chains are also available. Zinc Plated chains are also available upon request.



NP ANSI STANDARD

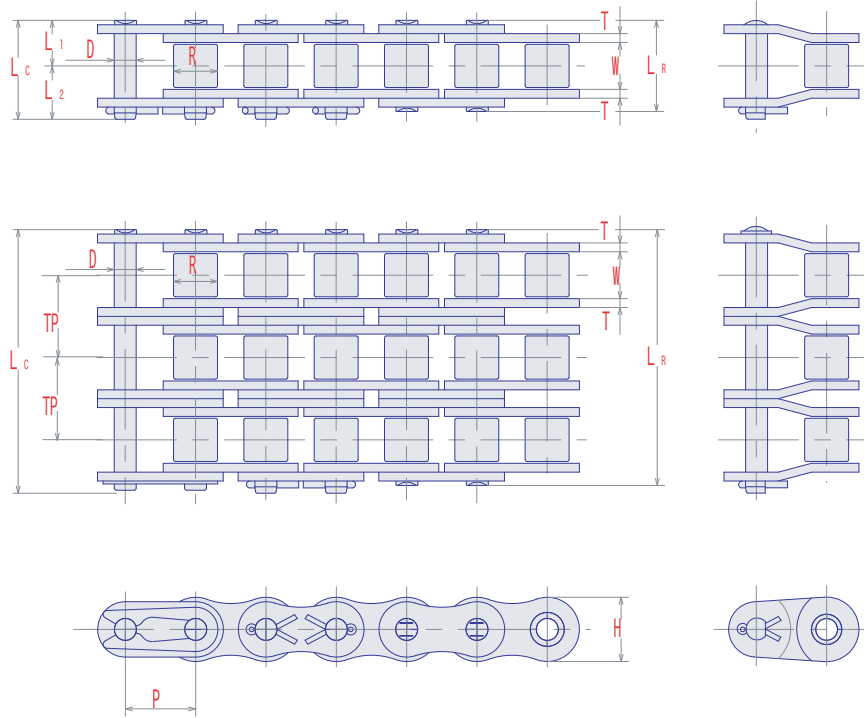
HKK Nickel Plated Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin			Plate		Trans. Pitch TP			
		Width W	Dia. R	Dia. D	Length L1 L2		Height H	Thick. T				
	P	W	R	D	L1	L2	H	T	TP			
HKK 35NP	9.525	4.78	5.08*	3.58	6.0	6.9	9.0	1.25		10.8	1.86	0.34
HKK 40NP	12.70	7.95	7.92	3.96	8.3	9.4	11.7	1.5		19.1	3.04	0.60
HKK 50NP	15.875	9.53	10.16	5.08	10.2	11.7	14.6	2.0		31.9	5.39	0.98
HKK 60NP	19.05	12.70	11.91	5.95	12.8	14.1	17.5	2.4		43.1	7.26	1.46
HKK 80NP	25.40	15.88	15.88	7.93	16.4	19.1	23.4	3.2		78.5	12.7	2.52
HKK 100NP	31.75	19.05	19.05	9.53	19.7	23.3	29.3	4.0		118	19.1	3.91
HKK 35-2 NP	9.525	4.78	5.08*	3.58	11.1	11.9	9.0	1.25	10.1	21.6	3.16	1.63
HKK 40-2 NP	12.70	7.95	7.92	3.96	15.4	16.8	11.7	1.5	14.4	38.2	5.17	1.22
HKK 50-2NP	15.875	9.53	10.16	5.08	19.2	20.8	14.6	2.0	18.1	63.8	9.06	2.00
HKK 60-2 NP	19.05	12.70	11.91	5.95	24.0	25.7	17.5	2.4	22.8	86.2	12.3	2.95
HKK 80-2 NP	25.40	15.88	15.88	7.93	30.8	33.7	23.4	3.2	29.3	157	21.6	5.10
HKK 100-2 NP	31.75	19.05	19.05	9.53	37.6	41.2	29.3	4.0	35.8	236	32.5	7.74

* Chain is rollerless; R shows bushing dia.

Nickel Plated BS Roller Chains

HKK Nickel-Plated chains are used in mildly corrosive environments such as outdoors. Carbon steel Nickel-Plated chain is plated before assembly to ensure complete protection of all parts, while providing maximum strength.

HKK Nickel-Plated chains are manufactured with solid rollers and solid bushings to extend chain life. Nickel-Plated attachment chains are also available. Zinc Plated chains are also available upon request.



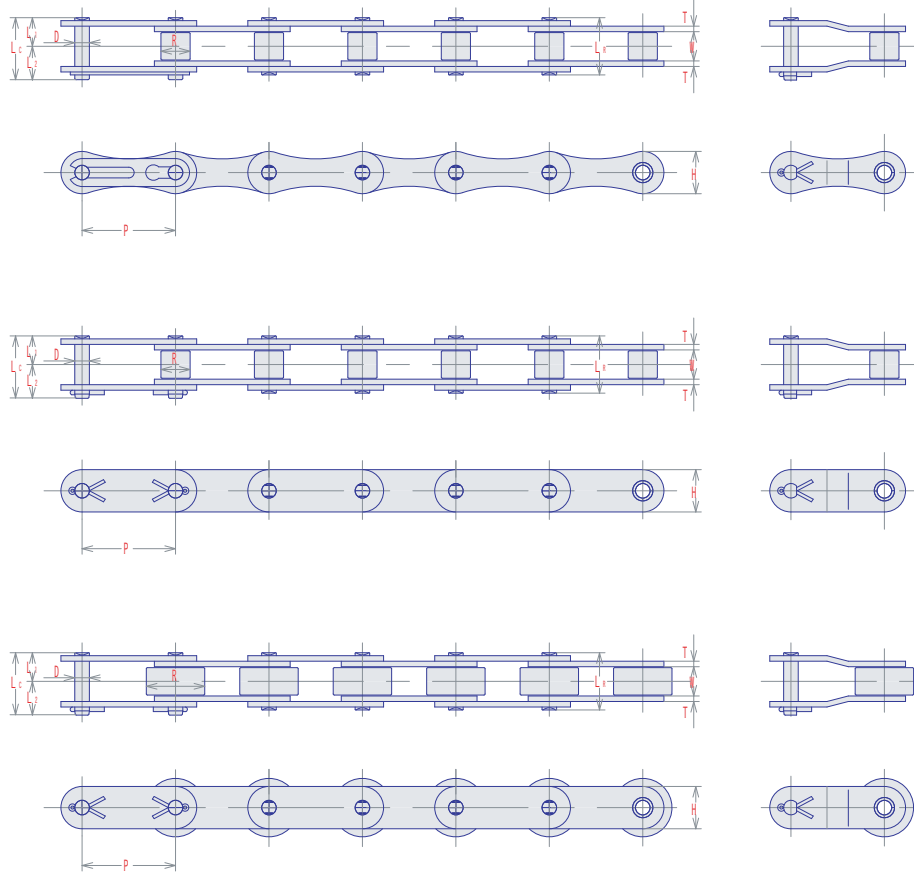
NP BS STANDARD

HKK Nickel Plated Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin		Plate		Trans. Pitch TP				
		Width W	Dia. R	Dia. D	Length L1 L2		Height H		Thick. T			
HKK 06B-NP	9.525	5.72	6.35	3.28	6.3	7.1	8.2	1.0	10.24	8.92	1.77	0.43
HKK 06B-2-NP					11.5	12.2				16.9	3.0	0.81
HKK 08B-NP	12.70	7.75	8.51	4.45	8.4	9.6	11.8	1.5	13.92	17.8	3.14	0.61
HKK 08B-2-NP					15.3	16.6				31.1	5.35	1.26
HKK 10B-NP	15.875	9.65	10.16	5.08	9.5	11.2	14.7	1.65	16.59	22.2	4.90	0.89
HKK 10B-2-NP					17.8	19.5				44.5	8.33	1.79
HKK 12B-NP	19.05	11.68	12.07	5.72	11.0	12.6	16.1	1.8	19.46	28.9	7.06	1.14
HKK 12B-2-NP					20.8	22.3				57.8	12.0	2.28
HKK 16B-NP	25.40	17.02	15.88	8.26	17.6	20.5	20.6	3.2	31.88	60	12.6	2.59
HKK 16B-2-NP					33.6	36.5				106	21.4	5.13
HKK 20B-NP	31.75	19.56	19.05	10.16	20.1	23.9	26.4	3.5	36.45	95	19.6	3.76
HKK 20B-2-NP					38.4	42.2				170	33.3	7.26

Nickel Plated Double Pitch Roller Chains

HKK Nickel-Plated chains are used in mildly corrosive environments such as outdoors. Carbon steel Nickel-Plated chain is plated before assembly to ensure complete protection of all parts, while providing maximum strength.

HKK Nickel-Plated chains are manufactured with solid rollers and solid bushings to extend chain life. Nickel-Plated attachment chains are also available. Zinc Plated chains are also available upon request.

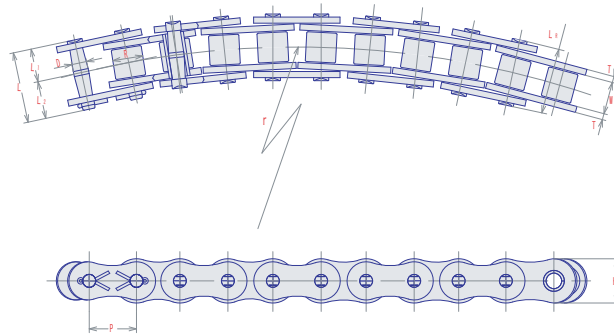


NP DOUBLE PITCH

HKK Nickel Plated Chain No.	Dimensions - mm								Average Ultimate Strength	Maximum Allowable Load	Average Chain Weight
	Pitch	Roller		Pin		Plate					
		Width	Dia.	Dia.	Length	Height	Thick.				
P	W	R	D	L1	L2	H	T1	kN	kN	kg/m	
HKK A 2040-NP	25.40	7.95	7.92	3.96	8.2	10.3	11.4	1.5	16.9	2.65	0.43
HKK A 2050-NP	31.75	9.53	10.16	5.08	10.2	11.8	15.0	2.0	27.5	4.31	0.73
HKK A 2060-NP	38.10	12.70	11.91	5.95	12.7	14.8	17.0	2.4	40.2	6.23	1.03
HKK A 2080-NP	50.80	15.88	15.88	7.93	16.4	19.1	22.6	3.2	68.6	10.7	1.71
HKK C 2040-NP	25.40	7.95	7.92	3.96	8.2	10.3	11.4	1.5	16.9	2.65	0.48
HKK C 2050-NP	31.75	9.53	10.16	5.08	10.2	11.8	15.0	2.0	27.5	4.31	0.82
HKK C 2060-NP	38.10	12.70	11.91	5.95	14.4	16.6	17.0	3.2	40.2	8.29	1.38
HKK C 2080-NP	50.80	15.88	15.88	7.93	17.8	21.0	22.6	4.0	68.6	15.2	2.32
HKK C 2080-NP	63.50	19.05	19.05	9.53	21.1	24.6	28.6	4.8	107.9	23.0	3.46
HKK C 2042-NP	25.40	7.95	7.92	3.96	8.2	10.3	11.4	1.5	16.9	2.65	0.82
HKK C 2052-NP	31.75	9.53	10.16	5.08	10.2	11.8	15.0	2.0	27.5	4.31	1.26
HKK C 2062-NP	38.10	12.70	11.91	5.95	14.4	16.6	17.0	3.2	40.2	8.29	2.08
HKK C 2082-NP	50.80	15.88	15.88	7.93	17.8	21.0	22.6	4.0	68.6	15.2	3.36
HKK C 2102H-NP	63.50	19.05	19.05	9.53	21.1	24.6	28.6	4.8	107.9	23.0	5.64

Side Bow Chains

HKK Side Bow roller chain consists of standard solid roller / solid bushing roller links. Specially designed pin links allow increased clearance between pins and bushings and between the roller link and pin link plates. This feature gives the chain freedom to slightly twist or curve on a horizontal plane.

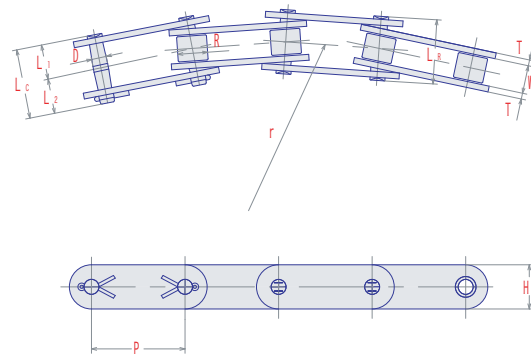


SB STANDARD

HKK Side Bow Chain No.	Dimensions - mm								Min. Curve Radius r	Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin		Plate						
		Width W	Dia. R	Out Dia. D	Length L1 L2	Height H	Thick. T					
HKK 40-SB	12.70	7.95	7.92	3.96	8.5	10.4	11.7	1.5	350	14.9	1.77	0.63
HKK 50-SB	15.875	9.53	10.16	5.08	10.6	12.5	14.6	2.0	400	22.1	3.14	1.03
HKK 60-SB	19.05	12.70	11.91	5.95	13.2	14.9	17.5	2.4	500	29.4	4.22	1.46
HKK 80-SB	25.40	15.88	15.88	7.93	16.7	19.7	23.4	3.2	600	57.9	7.65	2.42

Side Bow Double Pitch Chains

HKK Double pitch side bow chains are manufactured to the same high standards as our regular side bow chains but are better suited when shaft centers are relatively long. Available in standard roller or carrier roller type.

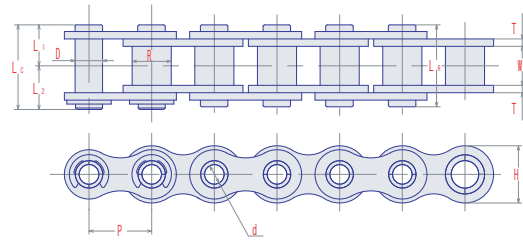


SB DOUBLE PITCH

HKK Side Bow Chain No.	Dimensions - mm								Min. Curve Radius r	Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch P	Roller		Pin		Plate						
		Width W	Dia. R	Out Dia. D	Length L1 L2	Height H	Thick. T					
HKK 2040-SB	25.4	7.95	7.92	3.96	8.5	10.4	11.4	1.5	700	14.9	1.77	0.48
HKK 2050-SB	31.75	9.53	10.16	5.08	10.6	12.5	15.0	2.0	800	22.1	3.14	0.82
HKK 2060-SB	38.10	12.70	11.91	5.95	13.2	14.9	17.0	2.4	1000	29.4	4.22	1.20
HKK 2042-SB	25.4	7.95	15.88	3.96	8.5	10.4	11.4	1.5	700	14.9	1.77	0.82
HKK 2052-SB	31.75	9.53	19.05	5.08	10.6	12.5	15.0	2.0	800	22.1	3.14	1.26
HKK 2062-SB	38.1	12.70	22.23	5.95	13.2	14.9	17.0	2.4	1000	29.4	4.22	2.01

Hollow Pin Chains

HKK Hollow Pin chains are constructed with cold-forged solid bushings. This process assures the inside diameter of the bushing is completely cylindrical all the way through. This unique hollow pin feature allows easy insertion of cross rods without damaging the chain or rods. Hollow Pin chain operates on standard sprockets and standard double pitch sprockets.

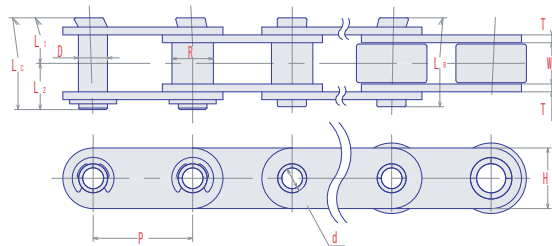


HP STANDARD

HKK Hollow Pin Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Hollow Pin				Plate				
		Width	Dia.	Outside	Inside	Length		Height	Thick.			
	P	W	R	D	d	L1	L2	H	T			
HKK 40-HP	12.70	7.95	7.92	5.63	4.03	8.4	9.2	12.0	1.5	12.7	1.77	0.58
HKK 50-HP	15.875	9.53	10.16	7.09	5.13	10.1	11.2	15.0	2.0	19.6	3.14	0.97
HKK 60-HP	19.05	12.70	11.91	8.29	6.04	13.0	14.2	18.1	2.4	28.4	4.22	1.46
HKK 80-HP	25.40	15.88	15.88	11.34	8.08	16.2	18.1	24.1	3.2	51.0	7.65	2.47

Double Pitch Hollow Pin Chains

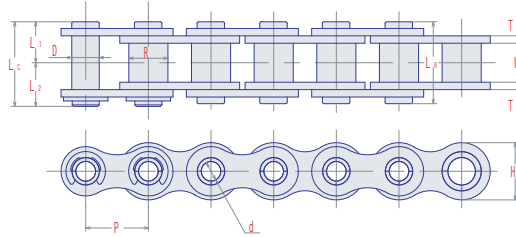
HKK Hollow pin chains with oil less parts are quality chains functioning rationally, combining both advantages of hollow pin chains and self-lube chains. Available on the same sprockets as double pitch roller chains.



HP DOUBLE PITCH CHAINS

HKK Hollow Pin Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Hollow Pin				Plate				
		Width	Dia.	Outside	Inside	Length		Height	Thick.			
	P	W	R	D	d	L1	L2	H	T			
HKK C2040-HP	25.40	7.95	7.92	5.63	4.03	8.4	9.2	12.0	1.5	12.7	1.77	0.46
HKK C2050-HP	31.75	9.53	10.16	7.09	5.13	10.1	11.2	15.0	2.0	19.6	3.14	0.76
HKK C2060-HP	38.10	12.70	11.91	8.29	6.04	13.0	14.2	18.1	2.4	28.4	4.22	1.12
HKK C2080-HP	50.80	15.88	15.88	11.34	8.08	16.2	18.1	24.1	3.2	51.0	7.65	1.98
HKK C2042-HP	25.40	7.95	15.88	5.63	4.03	8.4	9.2	12.0	1.5	12.7	1.77	0.81
HKK C2052-HP	31.75	9.53	19.05	7.09	5.13	10.1	11.2	15.0	2.0	19.6	3.14	1.25
HKK C2062-HP	38.10	12.70	22.23	8.29	6.04	13.0	14.2	18.1	2.4	28.4	4.22	1.79
HKK C2082-HP	50.80	15.88	28.58	11.34	8.08	16.2	18.1	24.1	3.2	51.0	7.65	3.17

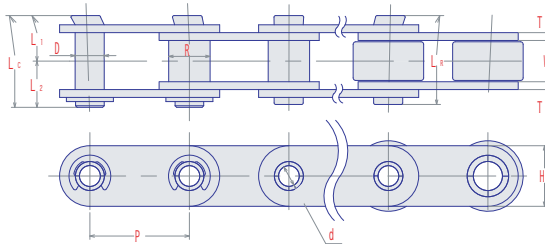
Stainless Hollow Pin Chains



HP-SS STANDARD

HKK Hollow Pin Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Hollow Pin				Plate				
		Width	Dia.	Outside	Inside	Length		Height	Thick.			
	P	W	R	D	d	L1	L2	H	T			
HKK 40-HP SS	12.70	7.95	7.92	5.63	4.03	8.4	9.2	12.0	1.5	7.65	0.44	0.58
HKK 50-HP SS	15.875	9.53	10.16	7.09	5.13	10.1	11.2	15.0	2.0	11.8	0.69	0.97
HKK 60-HP SS	19.05	12.70	11.91	8.29	6.04	13.0	14.2	18.1	2.4	17.1	1.03	1.46
HKK 80-HP SS	25.40	15.88	15.88	11.34	8.08	16.2	18.1	24.1	3.2	31.0	1.77	2.47

Double Pitch Stainless Hollow Pin Chains



HP-SS DOUBLE PITCH

HKK Hollow Pin Chain No.	Dimensions - mm									Average Ultimate Strength kN	Maximum Allowable Load kN	Average Chain Weight kg/m
	Pitch	Roller		Hollow Pin				Plate				
		Width	Dia.	Outside	Inside	Length		Height	Thick.			
	P	W	R	D	d	L1	L2	H	T			
HKK C2040-HP SS	25.40	7.95	7.92	5.63	4.03	8.4	9.2	12.0	1.5	7.65	0.44	0.46
HKK C2050-HP SS	31.75	9.53	10.16	7.09	5.13	10.1	11.2	15.0	2.0	11.8	0.69	0.76
HKK C2060-HP SS	38.10	12.70	11.91	8.29	6.04	13.0	14.2	18.1	2.4	17.1	1.03	1.12
HKK C2080-HP SS	50.80	15.88	15.88	11.34	8.08	16.2	18.1	24.1	3.2	31.0	1.77	1.98
HKK C2042-HP SS	25.40	7.95	15.88	5.63	4.03	8.4	9.2	12.0	1.5	7.65	0.44	0.81
HKK C2052-HP SS	31.75	9.53	19.05	7.09	5.13	10.1	11.2	15.0	2.0	11.8	0.69	1.25
HKK C2062-HP SS	38.10	12.70	22.23	8.29	6.04	13.0	14.2	18.1	2.4	17.1	1.03	1.79
HKK C2082-HP SS	50.80	15.88	28.58	11.34	8.08	16.2	18.1	24.1	3.2	31.0	1.77	3.17

Leaf Chains

HKK Leaf chains are built of interlaced plates held together by rivet pins. They are built with the same high degree of precision as our roller chains. HKK Leaf chains are used for applications that require strong flexible linkage for transmitting motion or lift. Specially selected steel and unique heat treatment assures high strength and durability. The first number or numbers in leaf chain identifies the chain pitch, the last two numbers identify the chain's lacing. New applications should use BL series leaf chains.

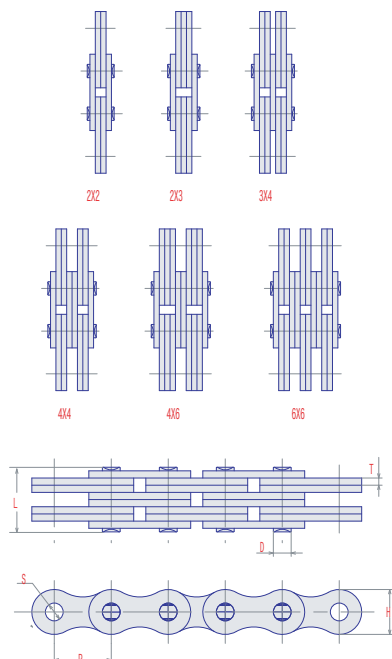
AL SERIES LEAF CHAIN

HKK AL series Leaf chains are constructed of an equal number of plates on both the inner and outer links. AL series chain use the same pin diameter and plate thickness as standard ANSI chains. AL series Leaf chain was removed from ANSI standards in 1975.

HKK Leaf Chain No.	Assembly	Dimensions - mm					Average Ultimate Strength kN	Maximum Allowable Load kN	Average Weight kg/m
		Pitch	Pin		Plate				
			Dia	Length	Height	Thick.			
P	D	L	H	T	kN	kN	kg/m		
AL-422	2x2	12.70	3.96	8.4	10.3	1.5	18.6	1.86	0.36
AL-444	4x4			14.6			37.3	3.43	0.70
AL-466	6x6			21.2			55.9	3.92	1.04
AL-522	2x2	15.875	5.08	10.5	12.7	2.0	30.4	3.04	0.58
AL-544	4x4			19.0			60.8	5.30	1.16
AL-566	6x6			27.6			94.1	6.28	1.73
AL-622	2x2	19.05	5.95	12.4	15.2	2.4	43.1	4.41	0.81
AL-644	4x4			22.2			86.3	7.45	1.68
AL-666	6x6			32.6			129	8.73	2.46
AL-822	2x2	25.40	7.93	16.6	20.2	3.2	72.6	7.35	1.42
AL-844	4x4			29.4			145	13.2	2.88
AL-866	6x6			43.0			218	15.4	4.23
AL-1022	2x2	31.75	9.53	19.6	24.5	4.0	108	11.6	2.46
AL-1044	4x4			36.2			216	20.6	4.81
AL-1066	6x6			53.5			324	24.0	7.24
AL-1222	2x2	38.10	11.10	24.0	29.2	4.8	152	16.5	3.35
AL-1244	4x4			43.7			304	29.1	6.58
AL-1266	6x6			63.4			456	34.2	9.82
AL-1422	2x2	44.45	12.70	27.8	34.2	5.6	205	22.1	4.99
AL-1444	4x4			51.2			410	38.9	9.56
AL-1466	6x6			73.6			615	46.1	14.13
AL-1622	2x2	50.80	14.28	31.8	40.3	6.4	269	28.3	6.35
AL-1644	4x4			58.4			539	49.9	12.62
AL-1666	6x6			84.8			809	58.8	18.87

BL SERIES LEAF CHAIN

HKK BL series Leaf chains should be used in all new applications. Greater load capacities are achieved using larger diameter pins and thicker plates. Pin diameters and plate thickness are of the next larger size ANSI standard roller chains.



HKK Leaf Chain No.	Assembly	Dimensions - mm					Average Ultimate Strength kN	Maximum Allowable Load kN	Average Weight kg/m
		Pitch	Pin		Plate				
			Dia	Length	Height	Thick.			
P	D	L	H	T	kN	kN	kg/m		
BL-423	2x3	12.70	5.08	12.5	11.7	2.0	27.5	4.51	0.79
BL-434	3x4			16.8			40.7	5.30	1.07
BL-446	4x6			23.0			54.4	5.98	1.58
BL-523	2x3	15.875	5.95	15.0	14.6	2.4	42.7	6.68	1.19
BL-534	3x4			20.0			64.0	8.33	1.61
BL-546	4x6			27.6			85.3	9.41	2.26
BL-623	2x3	19.05	7.93	19.5	17.5	3.2	70.6	0.81	1.89
BL-634	3x4			26.2			106	12.3	2.68
BL-646	4x6			36.5			141	13.7	4.15
BL-823	2x3	25.40	9.53	23.8	24.1	4.0	114	17.0	3.17
BL-834	3x4			32.5			172	20.6	4.37
BL-846	4x6			45.0			228	23.5	6.23
BL-1023	2x3	31.75	11.10	28.6	29.3	4.8	157	26.0	4.64
BL-1034	3x4			38.7			245	31.4	6.50
BL-1046	4x6			53.4			314	36.3	9.21
BL-1223	2x3	38.10	12.70	34.2	35.1	5.6	207	36.8	6.46
BL-1234	3x4			45.5			332	44.1	9.05
BL-1246	4x6			62.6			414	50.5	11.86
BL-1423	2x3	44.45	14.28	38.8	40.9	6.4	270	49.0	8.90
BL-1434	3x4			51.7			405	58.8	11.61
BL-1446	4x6			71.2			539	67.7	17.86
BL-1623	2x3	50.80	17.45	43.7	46.7	7.2	392	58.8	12.08
BL-1634	3x4			58.9			618	70.6	16.85
BL-1646	4x6			80.2			785	80.4	23.94

Attachment Chains

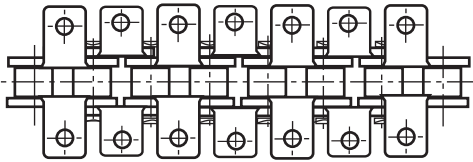
HKK attachment chains are standard ANSI single and double pitch chains with modified side plates or pins. Attachments may be used for a variety of purposes such as conveying, timing, or alignment. Several types of standard attachments are available from stock while custom attachments can be made to order. HKK carbon steel attachment chains are standard with solid rollers and solid bushings, greatly extending chain life. For corrosive or extreme environments, stainless steel, nickel plated, and Aqua-Series chains are also available. HKK stocks many unique attachments for specialized applications such as the poultry, packaging, and forestry industries.

ATTACHMENT SPACING

When referencing attachment chains, the attachment spacing must be specified. The attachment spacing or centers (space from the center of one attachment to the next) should be referred to in terms of pitches (links). When counting pitches both the outside (pin link) and the inside (roller link) must be counted. Example: Attachments on Every Link (all inside and outside links). Attachments on every second pitch on the pin link (every outside link). Attachments on every second pitch on the roller link (every inside link). Attachment every third pitch (alternating between inside and outside links).

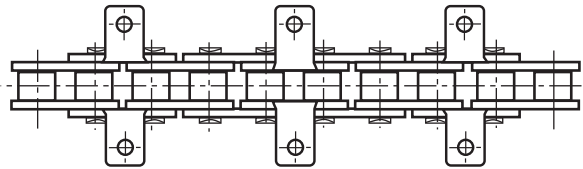
EVERY PITCH

Attachment on both inside and outside links



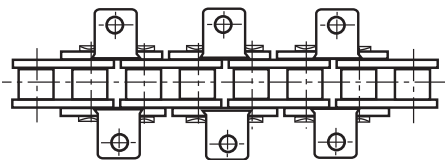
EVERY 3rd PITCH

Attachment alternating on inside and outside.



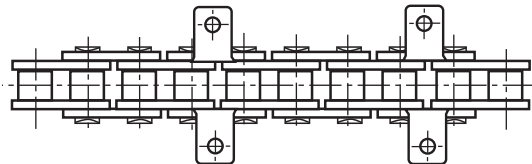
EVERY 2nd Pitch on PIN LINK

Attachment on every outside link.



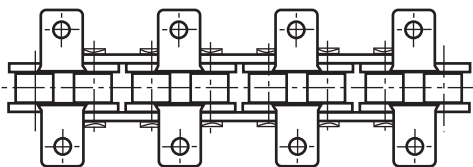
EVERY 4th Pitch on PIN LINK

Attachment on every other outside link.



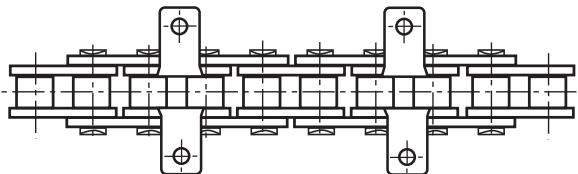
EVERY 2nd Pitch on ROLLER LINK

Attachment on every inside link.



EVERY 4th Pitch on ROLLER LINK

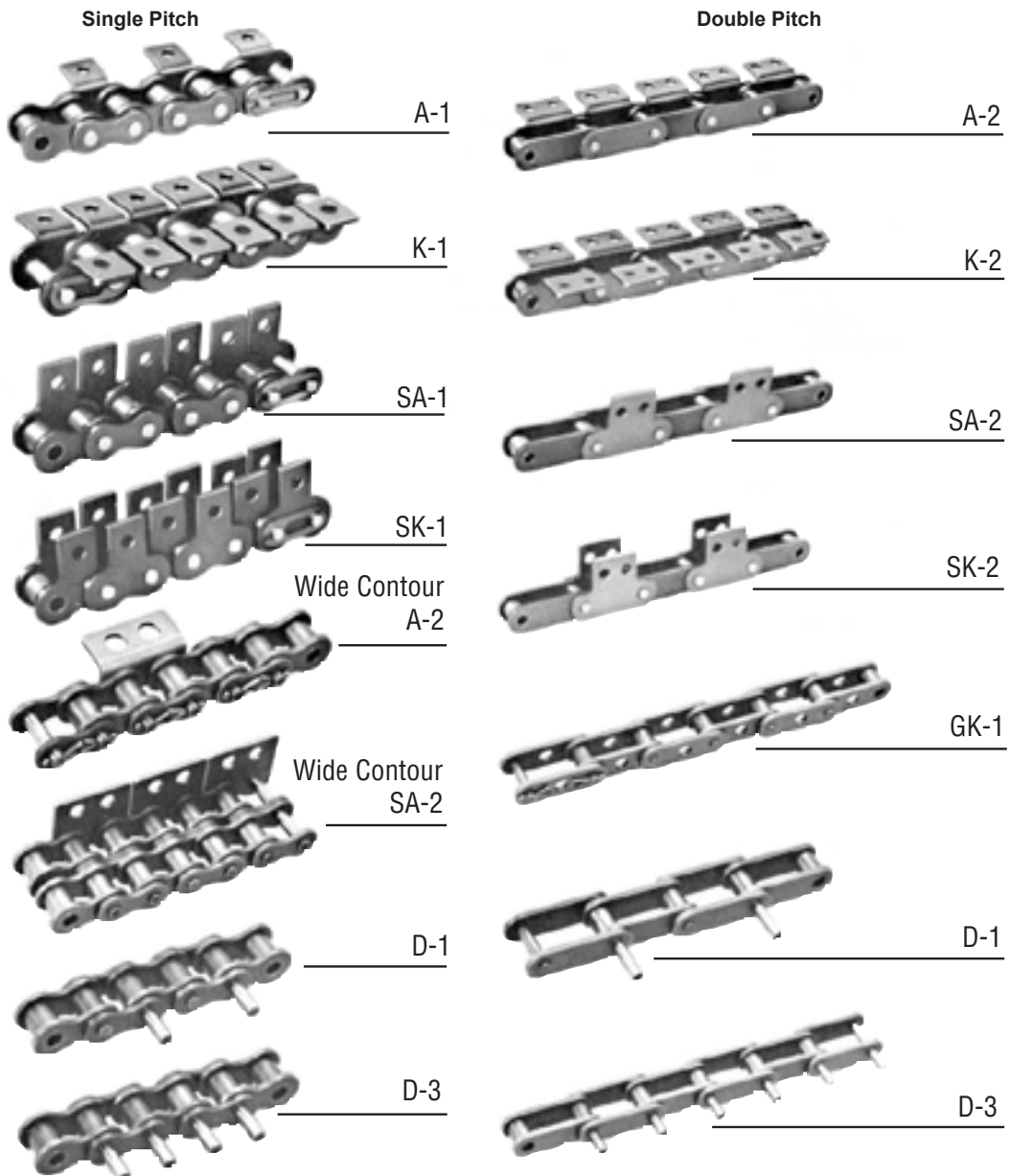
Attachment on every other inside link.



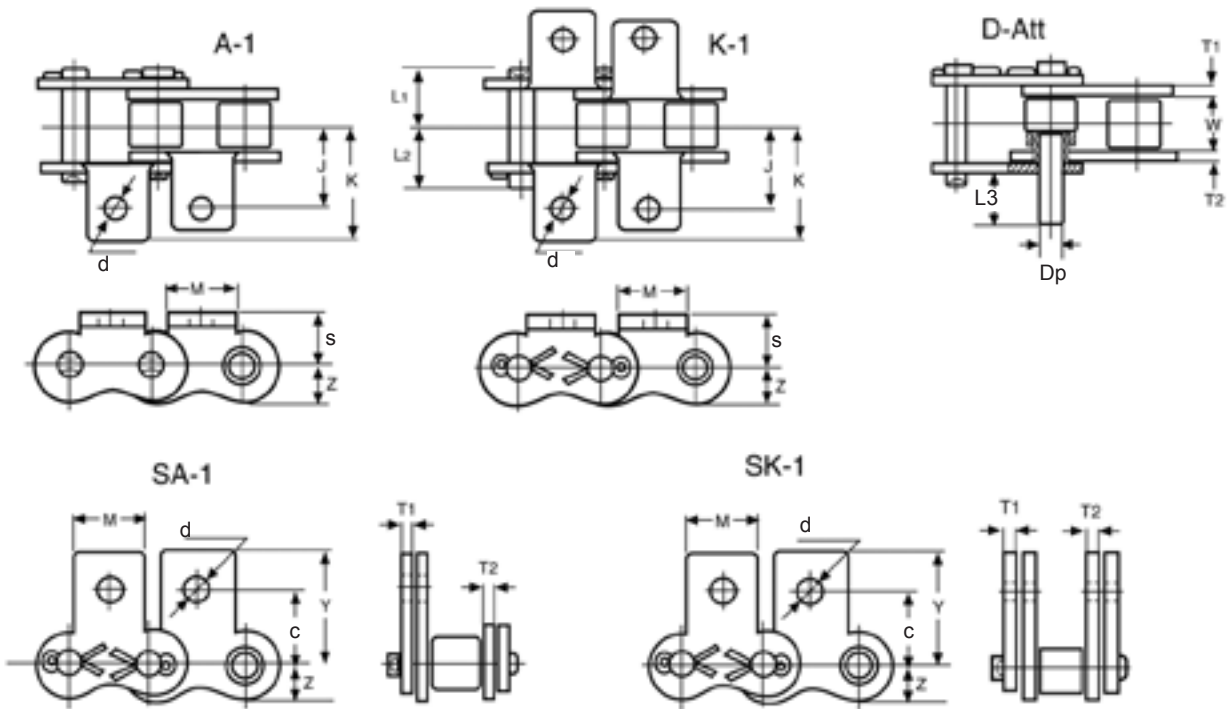
Standard Attachments

HKChain stocks most standard attachment chains in carbon steel and stainless steel. Most custom attachment spacing can be assembled with short delivery times. Single pitch chain with two attachment holes in one attachment is considered wide contour. Many custom attachments are also available or can be made to order, (see page 23.)

HKK (new)	HKK (old)	Dodge, Diamond, Morse	Rex, Link Belt
A-1	A-1	B-1, 1 hole	A-1
K-1	K-1	B-2, 1 hole	K-1
A-2	A-2	B-1, 2 hole	A-2
K-2	K-2	B-2, 2 hole	K-2
SA-1	M-1	S-1, 1 hole	M-35
SK-1	MM-1	S-2, 1 hole	M-1
SA-2	M-2	S-1, 2 hole	M-35-2
SK-2	MM-2	S-2, 2 hole	M-2
D-1	D-1	D-1	D-1
D-3	D-3	D-3	D-3



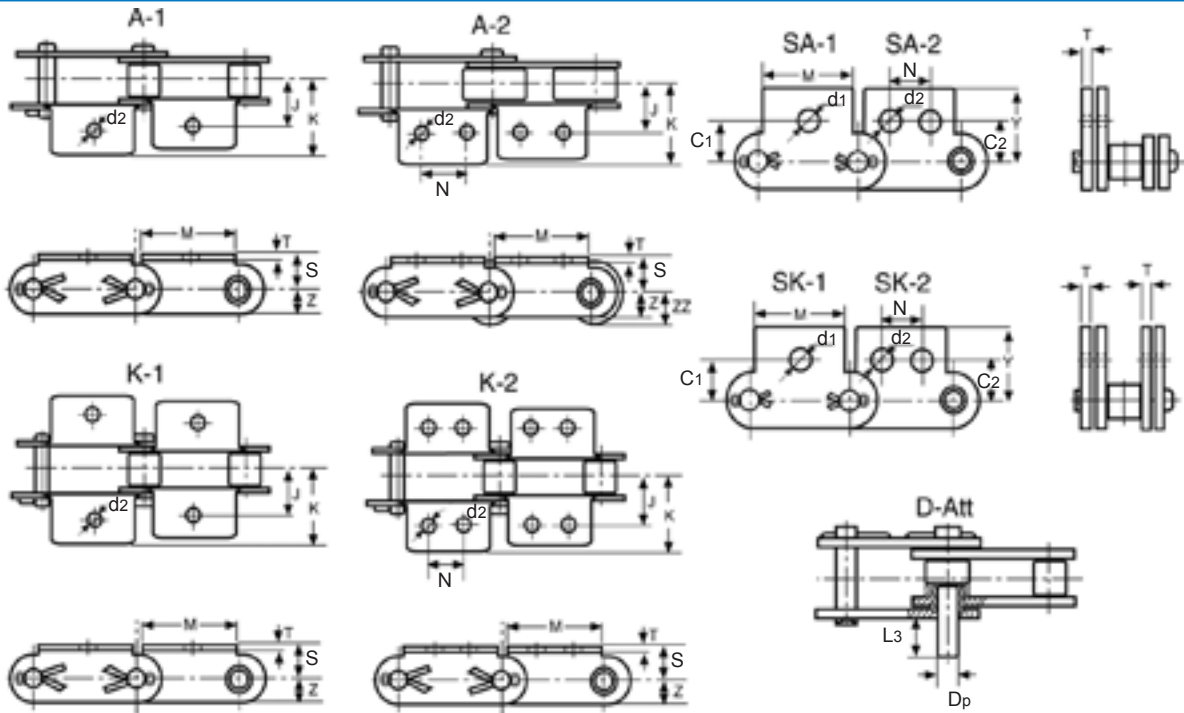
Single Pitch Attachments



HKK Chain No.	Chain Pitch	J	K	S	M	d	Z	C	X	Dp	L3
HKK 35	9.525	9.5	14.3	6.4	7.9	3.4	4.5	9.5	14.5	3.58	9.5
HKK 40	12.70	12.7	17.3	7.9	9.5	3.6	5.8	12.7	18.5	3.96	9.5
HKK 50	15.875	15.9	23.3	10.3	12.7	5.2	7.3	15.9	23.0	5.08	11.9
HKK 60	19.05	19.1	28.1	11.9	15.9	5.2	8.7	18.3	26.7	5.95	14.3
HKK 80	25.40	25.4	35.9	15.9	19.1	6.8	11.7	24.6	34.5	7.93	19.1
HKK 100	31.75	31.8	44.3	19.8	25.4	8.8	14.6	31.8	43.0	9.53	23.8
HKK 120	38.10	38.1	54.7	23.0	28.6	10.5	17.5	36.6	51.4	11.10	28.6
HKK 140	44.45	44.5	63.2	28.6	34.7	12.0	20.4	44.4	63.1	12.70	33.3
HKK 160	50.80	50.8	71.9	31.8	38.1	14.0	23.3	50.8	69.5	14.28	38.1

HKK Chain No.	Chain Pitch	T	W	H	L1	L2	Additional Weight				
							A att	K att	SA att	SK att	D att
HKK 35	9.525	1.25	4.78	9.0	5.9	6.8	0.9	1.8	0.9	1.8	0.8
HKK 40	12.70	1.5	7.95	11.7	8.2	9.1	1.2	2.4	1.2	2.4	1
HKK 50	15.875	2.0	9.53	14.6	10.3	11.6	4	8	4	8	2
HKK 60	19.05	2.4	12.70	17.5	12.7	13.9	6.5	13	6.5	13	3
HKK 80	25.40	3.2	15.88	23.4	16.2	18.8	13	26	13	26	7
HKK 100	31.75	4.0	19.05	29.3	19.6	23.2	27	54	27	54	12
HKK 120	38.10	4.8	25.40	35.1	24.7	28.5	47	94	47	94	20
HKK 140	44.45	5.6	25.40	40.9	26.9	31.2	65	130	65	130	30
HKK 160	50.80	6.4	31.75	46.7	32.1	36.4	88	176	88	176	45

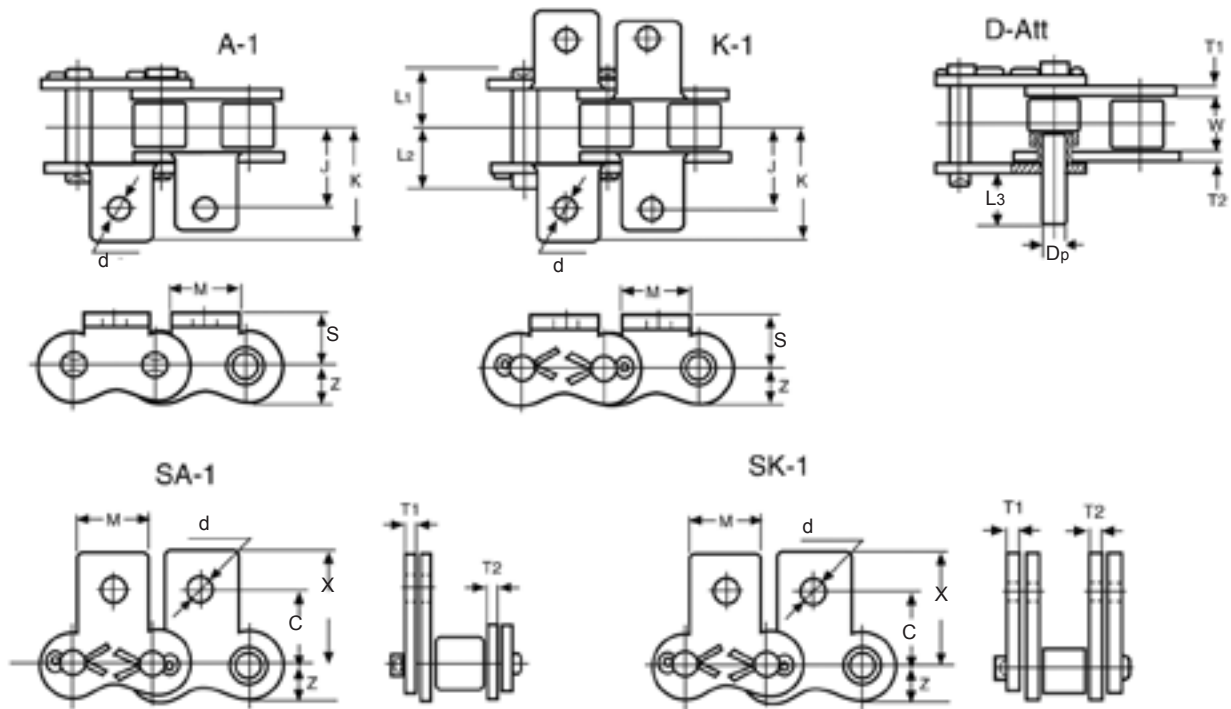
Double Pitch Attachments



HK Chain No.	Chain Pitch	J	K	S	M	d1	d2	N	T	Z	ZZ
HKK C2040 HKK C2042	25.40	12.7	19.2	9.1	19.1	5.2	3.6	9.5	1.5	5.7	7.94
HKK C2050 HKK C2052	31.75	15.9	24.2	11.1	23.8	6.8	5.2	11.9	2.0	7.5	9.53
HKK C2060H HKK C2062H	38.10	21.4	31.2	14.7	28.6	8.8	5.2	14.3	3.2	8.5	11.11
HKK C2080H HKK C2082H	50.80	27.8	40.6	19.1	38.1	10.5	6.8	19.1	4.0	11.3	14.29
HKK C2100H HKK C2102H	63.50	33.3	50.0	23.4	47.6	14.0	8.8	23.8	4.8	14.3	19.84
HKK C2120H HKK C2122H	76.20	39.7	61.9	27.8	57.2	16.0	10.5	28.6	5.6	17.4	22.22
HKK C2160H HKK C2162H	101.60	52.4	76.1	36.5	76.2	21.0	14.0	38.1	7.2	23.8	28.58

HK Chain No.	Chain Pitch	C1	C2	X	Dp	L3	Additional Weight				
							A att	K att	SA att	SK att	D att
HKK C2040 HKK C2042	25.40	11.1	13.5	19.8	3.96	9.5	3.2	6.4	2.7	5.4	0.9
HKK C2050 HKK C2052	31.75	14.3	15.9	24.6	5.08	11.9	6.3	12.6	5.9	11.8	1.8
HKK C2060H HKK C2062H	38.10	17.5	19.1	30.6	5.95	14.3	14.9	29.8	14.4	28.8	3
HKK C2080H HKK C2082H	50.80	22.2	25.4	40.2	7.93	19.1	31.5	63	31.5	63	7
HKK C2100H HKK C2102H	63.50	28.6	31.8	50.3	9.53	23.8	64	128	66	132	12
HKK C2120H HKK C2122H	76.20	33.3	37.3	61.1	11.10	28.6	102	204	97	194	20
HKK C2160H HKK C2162H	101.60	44.5	50.8	76.2	14.28	38.1	262	524	233	466	44

British Standard Attachments



HKK Chain No.	Chain Pitch	J	K	S	M	d	Z	C	X	Dp	L3
HKK 08B	12.70	13.8	20.9	8.5	11.0	4.3	5.9	13.7	20.8	4.45	14.8
HKK 10B	15.88	15.8	24.2	10.5	14.0	5.3	7.4	16.5	24.9	5.08	17.6
HKK 12B	19.05	17.6	27.3	12.2	18.0	6.4	8.1	18.5	28.1	5.72	20.7
HKK 16B	25.40	29.0	41.9	17.0	24.0	8.4	10.3	27.4	40.0	8.28	33.3
HKK 20B	31.75	34.5	49.3	21.0	30.0	10.5	13.2	33.0	47.5	10.16	38.3

HKK Chain No.	Chain Pitch	T1	T2	W	L1	L2	Additional Weight				
							A att	K att	SA att	SK att	D att
HKK 08B	12.70	1.5	1.5	7.75	8.4	9.6	2.0	4.0	2.0	4.0	1.8
HKK 10B	15.88	1.65	1.65	9.65	9.5	11.2	3.2	6.4	3.2	6.4	2.8
HKK 12B	19.05	1.8	1.8	11.68	11.0	12.6	4.5	9.0	4.5	9.0	4.1
HKK 16B	25.40	3.2	4.0	17.02	17.6	20.6	20	40	20	40	14.0
HKK 20B	31.75	3.5	4.7	19.56	20.1	23.9	25	50	25	50	24.3

Special Attachments

HKK offers many other non-standard attachments. HKK also stocks many specialized attachments for many particular industries, such as poultry, packaging lumber and many others. HKK can design and manufacture attachments tailored to any application or industry.



CAUTION: PLEASE READ CAREFULLY

- 1) Guards must be provided on all chain and sprocket installations in accordance with provisions of ANSI/ASME B15.1 Standards for Mechanical Power Transmission Apparatus, and ANSI/ASME B20.1 Safety Standards for Conveyors and Related Equipment, or other applicable safety standards. When revisions of these standards are published, the updated version shall apply.
- 2) Always lock out machinery power switch before attempting removal, installation, or any servicing of chain.
- 3) Wear eye and face protection when grinding, driving or disassembling pins.
- 4) Always wear gloves, protective clothing and safety shoes with steel toe when working with chains.
- 5) Make absolutely sure that chain is properly supported to prevent uncontrolled movement of chain and parts.
- 6) Chain pressers and breaking tools are recommended and should be in good working order and used according to instructions.
- 7) Do not attempt to connect, disconnect, or alter chain unless you are aware of the chain construction, including pin/rivet removal and the correct use of connecting links.
- 8) Chains made by different manufacturers should not be joined together with HKK chain in the same application.
- 9) Avoid plating or welding assembled chains or components.
- 10) Never repair damaged chains by replacing only the component parts.
- 11) Average Ultimate Strength of a chain is breaking load collected through a destruction tensile test. Never apply your working load over the maximum allowable load.

Maintenance Check List

Inspect on a regularly scheduled basis for worn, damaged or broken parts, possible interference by other systems components, and proper lubrication. Normal maintenance procedures can prevent most of the conditions described below. Carefully inspect roller chain drives on the same schedule as associated equipment.

Sprocket Misalignment

Wear on the sides of sprocket teeth generally indicates improper installation of sprockets and/or shafts. If shafts are out of parallel or not in the same plane, non-symmetrical wear will appear on sprockets or chain rollers.

After proper alignment is made retighten set screws in sprocket hubs.

Chain Wear and Elongation

Normal wear will cause some increase in chain length. However, if a sudden increase in elongation occurs, look for severe wear on the tips of sprocket teeth. This may be caused by any of the following: excessive loading or shock loading, displacement and/or wear in bearings, displacement of take-ups, or under-designed drives. Excessive elongation may be an indication that chain and/or sprockets should be replaced.

Before replacing chain or sprockets, recalculate initial drive design. Check chain tension if there is too much accumulated slack in the drive.

Broken Chain Parts

Generally caused by an overloaded drive; extreme misalignment; excessive elongation causing chain to jump sprocket teeth; heavy shock; improper drive design geometry; foreign objects.

Recalculate initial drive design and make necessary corrections. Inspect sprockets and shafts for proper alignment or looseness.

Link Plate Wear

Wear on inside of the link plates and on one side of sprocket teeth may be caused by a misalignment of sprockets.

Realign sprockets and shafts. Inspect chain carefully, readjust chain properly or replace.

Excessive Noise

Can be caused by broken links and chain rollers, extreme misalignment, elongation, chain jumping sprocket teeth, loose sprockets, broken teeth, accumulation of dirt packed into the chain or sprockets teeth, interference by foreign objects, contacting a fixed object.

Check for worn broken or missing parts. Check alignment of shafts and/or sprockets.

Improper Lubrication

Light or dark brown discoloration of pin-bushing joints and connecting link pins, or brown-red oxide color in oil may indicate chain is not dipping into the oil reservoir, or drip lubricator or spray is plugged.

Carefully clean and dry chain, immerse in oil, and re-install. Change oil in chain case and flush case. Determine if oil supply is adequate or unimpeded.

Recommended Replacement

Chain is worn-out and should be replaced when it stretches between .08% and 1.5% of its length.

Chain should also be replaced if any component parts are broken or excessively worn.

Removing Chain

Turn the drive until a connecting link is fully engaged with one of the sprockets so as to relieve the tension on the connecting pin. The connecting link may then be removed.

Cutting Riveted Chain

The two pins of a pin link must be driven out of the link plate. Strike the pins alternately to avoid distortion of the roller link plates as well as the plates of the adjacent links. Chain cutting tools can also be used. Follow their instruction carefully.

Inserting New Links

Insert only on new roller chain. Pitch variance between a new link and those on an old chain, especially one which is elongated due to wear, will cause shock when the new link engages the sprocket.

Installing New Chain

Chain and/or related parts should be visually inspected for damage, which could have occurred during shipping prior to installation. Never install new chain on worn sprockets as this will permanently damage chain. With new chain and sprockets installed, check for proper tension and alignment.

Periodic Cleaning

Remove chain from sprockets and clean with brush or rag. If chain is badly gummed, soak in cleaner, rinse, and soak chain in oil to restore lubrication. Clean sprockets; carefully inspect chain and sprockets before reinstalling.

Storing Chain

When roller chain is taken out of operation for prolonged periods, remove the chain from the sprockets and cover with heavy grease. Wrap in heavy grease resistant paper and store where the chain will not be exposed to abnormal moisture, temperature, abrasive or corrosive conditions. Sprockets remaining on shafts should be covered with heavy grease. When the drive is put back in service, remove the grease and thoroughly clean chain and sprockets before re-installing.

Heating and Welding

Do not apply heat to chain by cutting torch unless absolutely necessary. If cutting by torch is indicated, chain should be replaced. Welding should not be attempted.

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