

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1977

CONVEYOR CHAINS, ATTACHMENTS AND CHAIN WHEELS

PART I

CHAINS (METRIC SERIES)

1st EDITION

May 1971

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BRIEF HISTORY

The ISO Recommendation R 1977, *Conveyor chains, attachments and chain wheels – Part I : Chains (Metric series)*, was drawn up by Technical Committee ISO/TC 100, *Chains and chain wheels for power transmission and conveyors*, the Secretariat of which is held by the British Standards Institution (BSI).

Work on this question led to the adoption of Draft ISO Recommendation No. 1977, which was circulated to all the ISO Member Bodies for enquiry in January 1970. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	India	South Africa, Rep. of
Belgium	Ireland	Spain
Czechoslovakia	Israel	Thailand
France	Japan	U.A.R.
Germany	New Zealand	United Kingdom
Greece	Romania	

The following Member Bodies opposed the approval of the Draft :

Sweden
U.S.A.

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided to accept it as an ISO RECOMMENDATION.

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INTRODUCTION

This ISO Recommendation has been prepared with a view to ensuring interchangeability of complete chains and interchangeability of individual links of chains for repair purposes.

Subsequent documents will relate to attachments and chain wheels.

1. SCOPE

This ISO Recommendation applies to metric-dimensioned bush, plain and flanged roller chains of both solid and hollow bearing pin types designed for general conveying and mechanical handling duties.

2. NOMENCLATURE

The nomenclature of chains is as given in the Figure on page 5 and in the key, on page 6, to Tables 1 and 2.

3. DESIGNATION

Conveyor chain designating numbers are based on the numbers given in Tables 1 and 2 (column 1). The numbers are derived from the minimum breaking loads (in kilonewtons) and are given the prefix M to indicate solid bearing pin chain, or prefix MC to indicate hollow bearing pin chain.

Examples :

M80 = Solid bearing pin chain of 80 kN nominal breaking load.

MC224 = Hollow bearing pin chain of 224 kN nominal breaking load.

The symbol B (bush), F (flanged), P (plain) or S (small) is added, as appropriate, to indicate the type. This is followed by further digits indicating the pitch in millimetres.

Example :

MC224-F-200 = Chain MC224 with flanged roller and pitch of 200 mm.