

Small craft – Anchor chains

- 1. Scope** This Japanese Industrial Standard specifies type, shape, dimensions, and mechanical properties of anchor chains used for the windlasses of small craft (hereinafter referred to as “chain”) and hot galvanizings.

- Remarks:**
1. This Standard applies to chains with a nominal diameter range between 6 and 12.5 mm used for mooring small craft, which can be controlled by a windlass, but does not apply to those for slings.
 2. This Standard makes reference to the following standards:
JIS H 8641 – Zinc hot dip galvanizings
ISO 1835 – Short link chain for lifting purposes – Grade M(4), non-calibrated, for chain slings etc.
ISO 4565 – Small craft – Anchor chains

Reference: This Standard has been established paying due regard to the preferred coordination with ISO 4565.

- 2. Classification** Chains shall be classified as given in Table 1 according to the nominal dia. and grade.

Table 1. Classification of chains

Nominal dia. mm	Class symbol	
	Class L	Class M
6	L— 6	M— 6
6.3	L— 6.3	M— 6.3
8	L— 8	M— 8
10	L—10	M—10
12	L—12	M—12
12.5	L—12.5	M—12.5

- Remarks:**
1. The minimum breaking stress for Class L chains shall be 315 MPa, and that for Class M chains, 400 MPa.
 2. Nominal diameters of 6 mm and 12 mm have been provisionally established on the basis of the provisions of ISO 1835.

3. Shapes and dimensions

- (1) The shapes and dimensions of chains shall be as shown in Fig. 1 and Table 2.
- (2) When an end link is fitted to the chain, it shall be designated as end link A.
- (3) The allowable dimensional deviations for chains and end link A are applicable to galvanized ones.



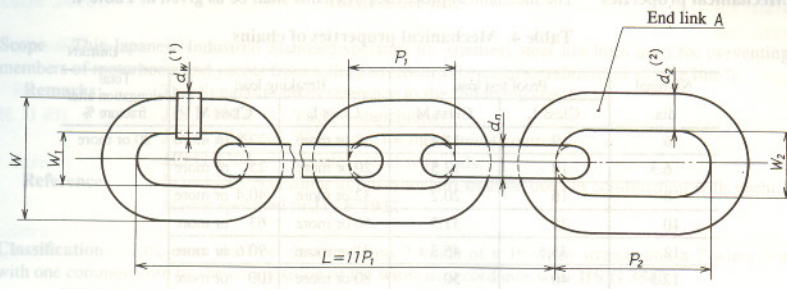


Fig. 1 Shapes of chains

Table 2. Dimensions and allowable dimensional deviations

Unit: mm

Nominal dia.	Chain dia.	Pitch	Inside width	Outside width	11 Links length	End link A		
						Chain dia.	Pitch	Inside width
	d_1	P_1	W_1	W	L	d_2	P_2	W_2
6	6 ± 0.3	18 ± 0.5	8.1 or more	21.5 or less	198 ± 4	8 ± 0.4	40 ± 1.2	18 or more
6.3	6.3 ± 0.3	19 ± 0.5	8.5 or more	22.7 or less	208 ± 4	8 ± 0.4	40 ± 1.2	18 or more
8	8 ± 0.4	24 ± 0.7	10.8 or more	28.8 or less	264 ± 5	10 ± 0.5	44 ± 1.3	20 or more
10	10 ± 0.5	30 ± 0.9	13.5 or more	36 or less	330 ± 7	12 ± 0.6	54 ± 1.6	25 or more
12	12 ± 0.6	36 ± 1.1	16.2 or more	43.2 or less	396 ± 8	14 ± 0.7	54 ± 1.6	25 or more
12.5	12.5 ± 0.6	38 ± 1.1	16.9 or more	45 or less	413 ± 8	14 ± 0.7	54 ± 1.6	25 or more

Notes: (†) The allowable dimensional deviation for the welded part d_w shall be $^{+0.26}_{-0}$.(†) The dimensional deviation of d_2 shall be such that the connection with chains is satisfactory.

- (4) The lengths of chains shall be as given in Table 3, and in addition, they shall comply with the lengths specified by each Classification Society.

Table 3. Length of chains

Unit: m

Nominal dia.	Standard Length				
	5	10	30	50	80
6	○	—	○	○	—
6.3	○	—	○	○	—
8	○	—	○	○	—
10	—	○	—	○	—
12	—	○	—	○	○
12.5	—	○	—	○	○

Remark: Columns marked with ○ in the table represent the recommended length for each nominal dia.