

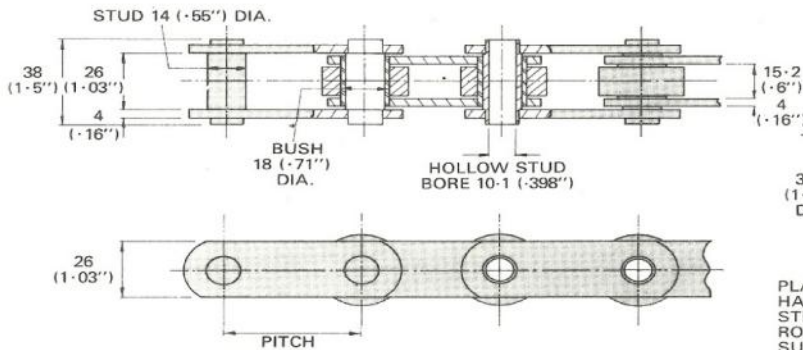
Precision Conveyor Chain



PRECISION CHAINS

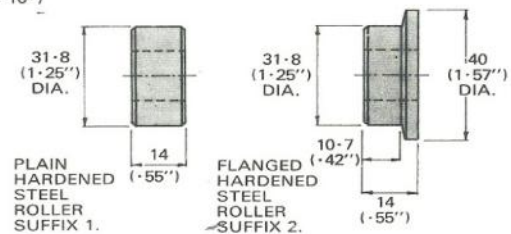
Chain Series D

Hollow Stud 27 kN (6,000 lb) TS.
Solid Stud 33 kN (7,500 lb) TS.
Stud/Bush Bearing Area 350 mm²



Finish
a. Normal — dipped in grease.
b. Works — lightly oiled.
c. Oven — graphite coating.
d. Zinc — zinc coating throughout.
e. Moly — MoS₂ coating, round parts only.
f. Rape — dipped in rape oil.
g. Oil — dipped in light machine oil.

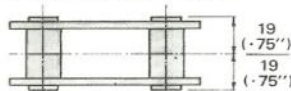
Materials
k. Normal — standard steels.
l. Enhanced — special materials and/or heat treatment.
r. Low Corrosion — 431 hardened stainless round parts.
s. Medium Corrosion — 431 hardened stainless round parts other components in 300 stainless.
u. Higher Corrosion — 300 stainless throughout.
w. Marine/Chemical — 316 stainless throughout.
y. Hot Oven — 310 stainless, except attachments.



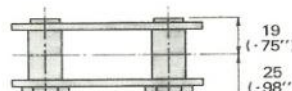
PITCH		ROLLERLESS CHAIN		PLAIN ROLLER CHAIN		FLANGED ROLLER CHAIN	
mm	in	REFERENCE	MASS kg/m	REFERENCE	MASS kg/m	REFERENCE	MASS kg/m
HOLLOW STUD CHAIN 27kN TS.							
50.8	2.0	A08D9	2.61	A08D1	3.50	A08D2	4.00
75	2.95	A75D9	2.31	A75D1	2.90	A75D2	3.23
76.2	3.0	A12D9	2.29	A12D1	2.88	A12D2	3.21
100	3.94	A100D9	2.15	A100D1	2.60	A100D2	2.84
101.6	4.0	A16D9	2.13	A16D1	2.58	A16D2	2.82
125	4.92	A125D9	2.06	A125D1	2.41	A125D2	2.61
152.4	6.0	A24D9	1.97	A24D1	2.27	A24D2	2.43
SOLID STUD CHAIN 33 kN TS.							
50.8	2.0	B08D9	3.07	B08D1	3.95	B08D2	4.45
75	2.95	B75D9	2.62	B75D1	3.21	B75D2	3.53
76.2	3.0	B12D9	2.59	B12D1	3.19	B12D2	3.51
100	3.94	B100D9	2.39	B100D1	2.82	B100D2	3.07
101.6	4.0	B16D9	2.36	B16D1	2.80	B16D2	3.05
125	4.92	B125D9	2.24	B125D1	2.58	B125D2	2.79
152.4	6.0	B24D9	2.12	B24D1	2.42	B24D2	2.58

Also available with plain 31.8 (1.25") dia. Delrin Roller (Suffix 26) or Plain Hardened Steel Rollers 25.4 (1") dia. and 38.1 (1.5") dia. (Suffix 13 and 11 respectively). Stock chains in bold type. Thickness of Sidebars in Stainless Steel increased from 4 to 5 and overall width of chain from 38 to 42

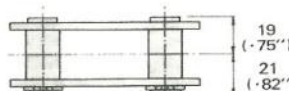
Connecting Links



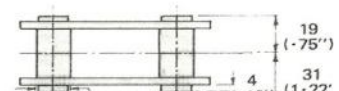
RIVET TYPE



SCREWED TYPE

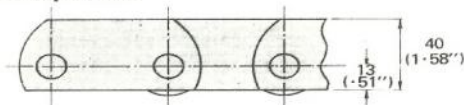


CIRCLIP TYPE



No. 86 TYPE

Deep Link



PITCH	mm	50.8	75	76.2	100	101.6	125	152.4
in		2.0	2.95	3.0	3.94	4.0	4.92	6.0
CHAIN REF. (PLAIN ROLLER)		D08D1	D75D1	D12D1	D100D1	D16D1	D125D1	D24D1
EXTRA MASS kg/m		1.02	0.96	0.95	0.92		0.88	0.87

Also available as **DOUBLE STRENGTH** chain.



MERLEY CHAINS LTD.

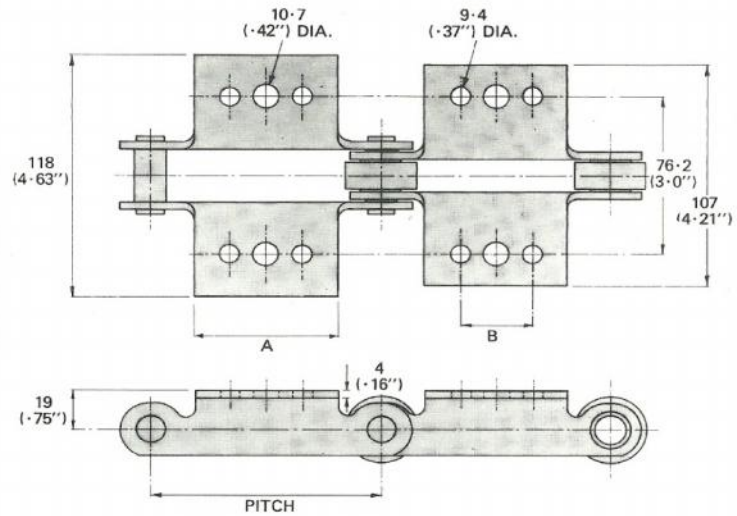
Series D

Integral K Attachments

K1 — 1 HOLE K2 — 2 HOLES K3 — 3 HOLES

TYPE	PITCH mm in	A mm in	B mm in	EXTRA MASS kg EACH
K1 & K2	50.8 2.0	38 1.5	22.2 0.875	0.05
K1 & K2	76.2 3.0	38 1.5	22.2 0.875	0.05
K3	101.6 4.0	64 2.5	31.8 1.25	0.08
K3	152.4 6.0	114 4.5	57.2 2.25	0.14

Can be spaced where required,
one or both sides of chain.

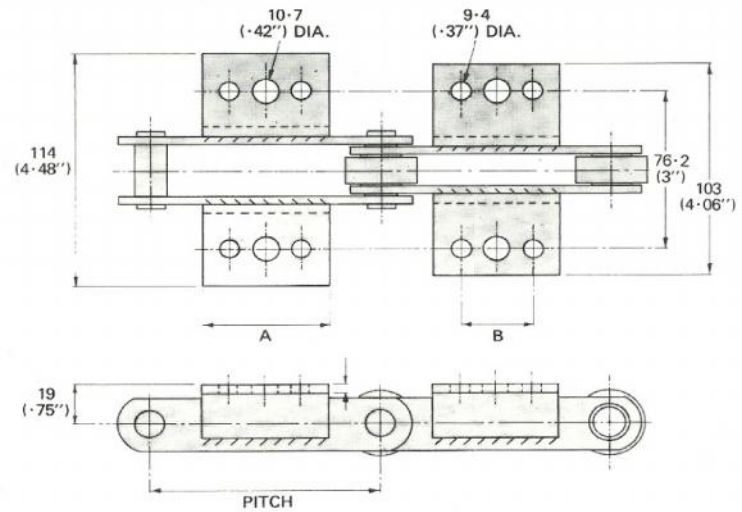


Welded K Attachments

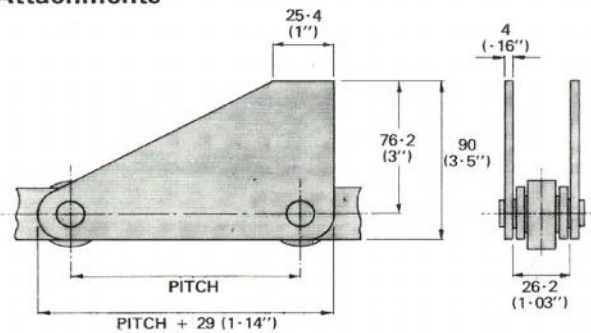
K1 — 1 HOLE K2 — 2 HOLES K3 — 3 HOLES

TYPE	PITCH mm in	A mm in	B mm in	MASS kg EACH
K1	76.2 3.0	28 1.1	— —	0.05
K2	76.2 3.0	43 1.7	22.2 0.87	0.08
K3	101.6 4.0	56 2.2	31.8 1.25	0.10
K3	152.4 6.0	84 3.3	57.2 2.25	0.16

Can be spaced where required,
one or both sides of chain.



Integral S Attachments



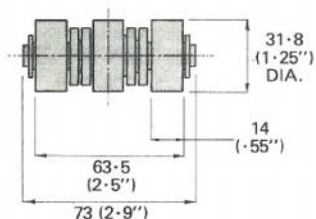
Can be spaced on outer links
where required.
Also available with block
bolted or welded
between outer sidebars.



MERLEY CHAINS LTD.

Series D

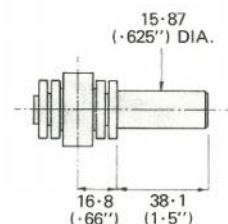
Outboard Rollers



Rollers mounted on extended studs.
Secured by riveted washer.
Flanged roller can be supplied.

Spigot

INTEGRAL WITH SOLID STUD



Standard Conveyor Chain Sprockets

GREY CAST IRON, CAST TEETH, FOR USE WITH PLAIN ROLLER CHAIN.

Sprockets can be supplied:

- In Stainless Steel or non ferrous materials.
- Bushed in non ferrous materials.
- With machine cut teeth.
- Split in two halves or with segmental teeth.

Unless otherwise specified:

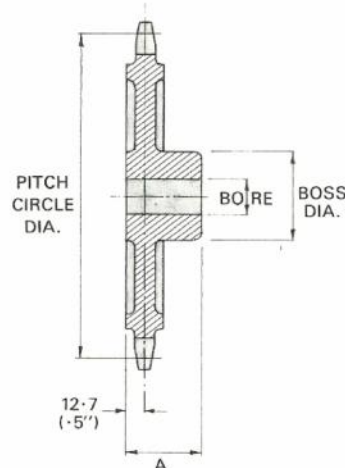
Bores are machined to H9 Tolerance, BS 4500 Part 1 (ISO R286).
Keyways are metric, either tapered or parallel to BS 4235 Part 1, 1972 (based on ISO/R773 & R774.)

Sprockets are keywayed in pairs on centre line of tooth gap with bosses facing, deep end of tapered keyway on boss side.

Single setscrews are positioned over the keyway.
Any second setscrew positioned at 90° to the first.

PITCH	No. OF TEETH	SPROCKET REFERENCE	PITCH CIRCLE DIA.	MAX BORE	BOSS DIA.	A	MASS kg EACH
31.8 (1.25") ROLLER TREAD DIA.							
50.8 2.0	8	08D1/801	132.7	50	76	51	3
	12	08D1/1201	196.3	70	102	51	6
	16	08D1/1601	260.4	80	114	64	9
76.2 3.0	8	12D1/801	199.1	70	102	51	5
	10	12D1/1001	246.6	80	114	64	9
	12	12D1/1201	294.4	80	114	64	10
101.6 4.0	16	12D1/1601	390.6	100	140	76	17
	8	16D1/801	265.5	80	114	64	9
	12	16D1/1201	392.6	95	140	76	21
152.4 6.0	16	16D1/1601	520.8	95	140	76	27
	8	24D1/801	398.3	95	140	76	14
	12	24D1/1201	588.8	95	140	76	34
25.4 (1") ROLLER TREAD DIA.							
76.2 3.0	8	12D13/801	199.1	70	102	51	6
	12	12D13/1201	294.4	80	114	64	11

Items in bold type can be supplied without machining



FABRICATED STEEL, FLAME CUT TEETH.

Number of teeth from 6 upwards, see page 55 for pitch circle dia.

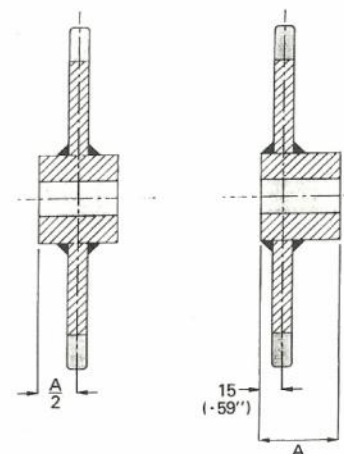
One sided or central boss, boss dia. to suit torque requirements

Bore rough finish or fully machined to H9 tolerance.

Keywayed, setscrewed or bushed as required.

Flame hardened teeth available.

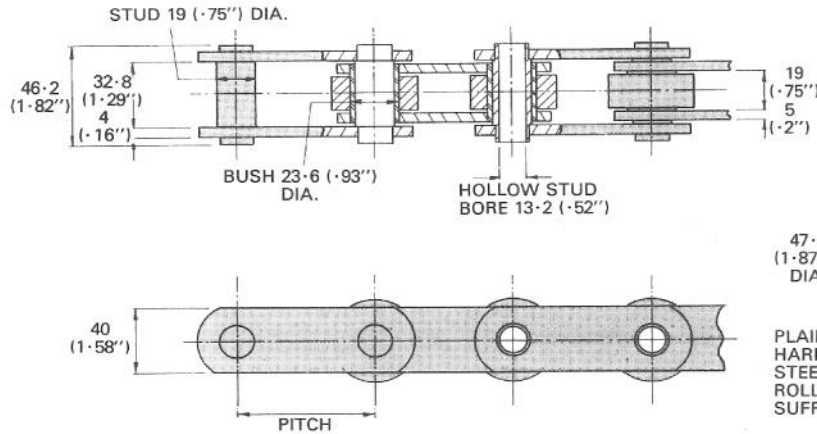
No. OF TEETH	DISTANCE THROUGH BOSS, DIMENSION A				
	CHAIN PITCH				
	50.8	75 & 76.2	100 & 101.6	125	152.4
6-9	50	50	65	65	75
10-11	50	65	65	65	75
12-14	50	65	75	75	75
15-18	65	75	75	75	90
19-21	65	75	80	90	105
22-25	75	75	90	100	115



MERLEY CHAINS LTD.

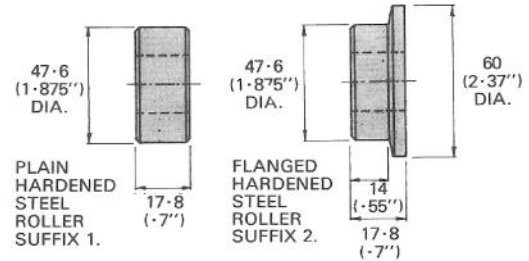
Chain Series G

Hollow Stud 54 kN (12,000 lb) TS.
Solid Stud 67 kN (15,000 lb) TS.
Stud/Bush Bearing Area 600 mm²



Finish
 a. Normal — dipped in grease.
 b. Works — lightly oiled.
 c. Oven — graphite coating.
 d. Zinc — zinc coating throughout.
 e. Moly — MoS₂ coating, round parts only.
 f. Rape — dipped in rape oil.
 g. Oil — dipped in light machine oil.

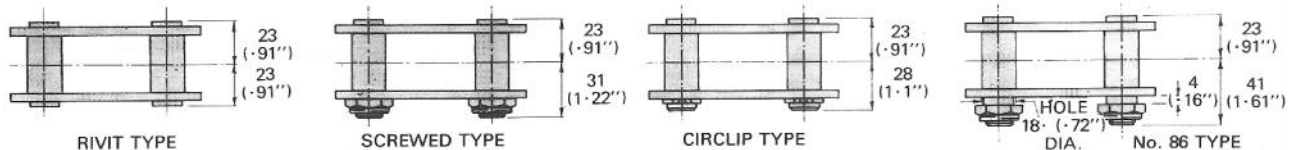
Materials
 k. Normal — standard steels.
 l. Enhanced — special materials and/or heat treatment.
 r. Low Corrosion — 431 hardened stainless round parts.
 s. Medium Corrosion — 431 hardened stainless round parts other components in 300 stainless.
 u. Higher Corrosion — 300 stainless throughout.
 w. Marine/Chemical — 316 stainless throughout.
 y. Hot Oven — 310 stainless, except attachments.



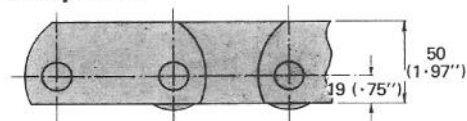
PITCH mm in	ROLLERLESS CHAIN		PLAIN ROLLER CHAIN		FLANGED ROLLER CHAIN	
	REFERENCE	MASS kg/m	REFERENCE	MASS kg/m	REFERENCE	MASS kg/m
HOLLOW STUD CHAIN 54 kN TS.						
76.2 3.0	A12G9	4.45	A12G1	6.95	A12G2	7.35
100 3.94	A100G9	4.09	A100G1	5.96	A100G2	6.23
101.6 4.0	A16G9	4.05	A16G1	5.92	A16G2	6.20
125 4.92	A125G9	3.82	A125G1	5.33	A125G2	5.55
150 5.91	A150G9	3.67	A150G1	4.92	A150G2	5.12
152.4 6.0	A24G9	3.65	A24G1	4.90	A24G2	5.10
203.2 8.0	A32G9	3.45	A32G1	4.40	A32G2	4.53
SOLID STUD CHAIN 67 kN TS.						
76.2 3.0	B12G9	5.14	B12G1	7.64	B12G2	8.04
100 3.94	B100G9	4.61	B100G1	6.47	B100G2	6.77
101.6 4.0	B16G9	4.57	B16G1	6.44	B16G2	6.74
125 4.92	B125G9	4.24	B125G1	5.75	B125G2	5.97
150 5.91	B150G9	3.98	B150G1	5.27	B150G2	5.45
152.4 6.0	B24G9	4.00	B24G1	5.25	B24G2	5.45
203.2 8.0	B32G9	3.71	B32G1	4.65	B32G2	4.80

Also available with 38.1 (1.5") dia. Plain Hardened Rollers, suffix 15.
 Stock chains in bold type.

Connecting Links



Deep Link



PITCH	mm in	76.2 3	100 3.94	101.6 4	125 4.92	150 5.91	152.4 6	203.2 8
CHAIN REFERENCE (Plain Roller)		D12G1	D100G1	D16G1	D125G1	D150G1	D24G1	D32G1
EXTRA MASS kg/m		0.97	0.94	0.94	0.93	0.91	0.91	0.89

Also available in **DOUBLE STRENGTH** chain.



MERLEY CHAINS LTD.

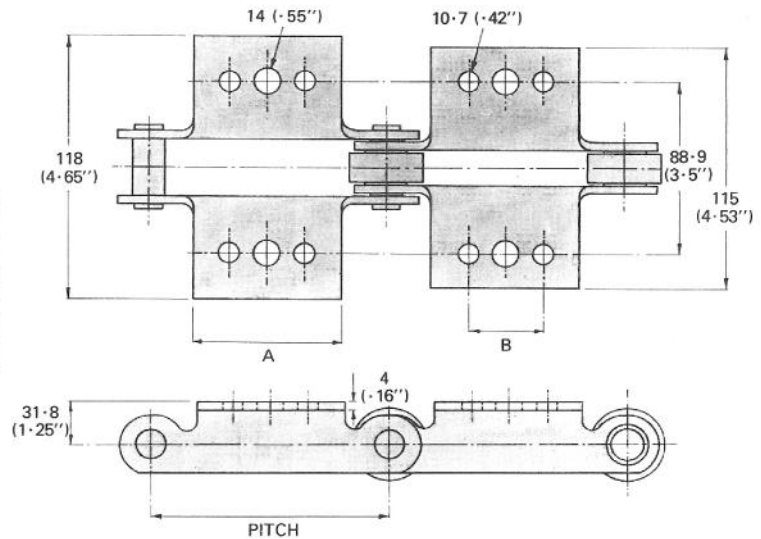
Series G

Integral K Attachments

K1 = 1 HOLE K2 = 2 HOLES K3 = 3 HOLES

TYPE	PITCH		A		B		EXTRA MASS kg EACH	
	mm	in	mm	in	mm	in	Inner	Outer
K1	76.2	3.0	38	1.5	—	—	0.08	0.06
K3	101.6	4.0	64	2.5	31.8	1.25	0.13	0.10
K3	152.4	6.0	114	4.5	57.2	2.25	0.24	0.18

Can be spaced where required,
one or both sides of chain.

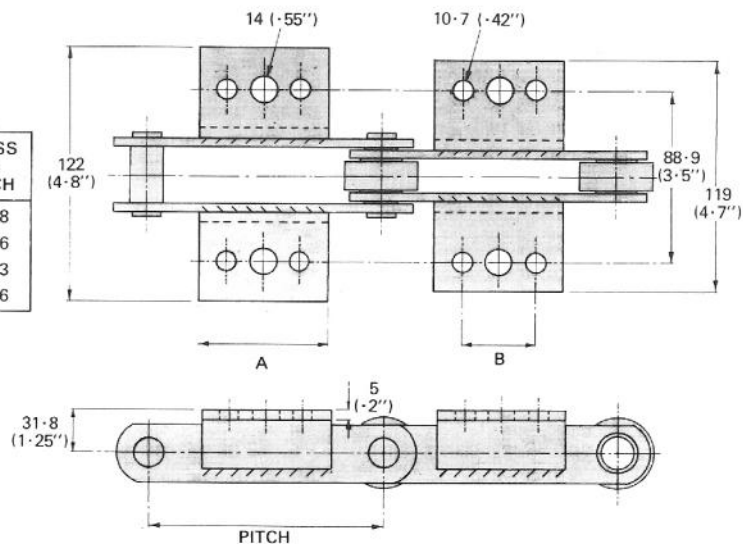


Welded K Attachments

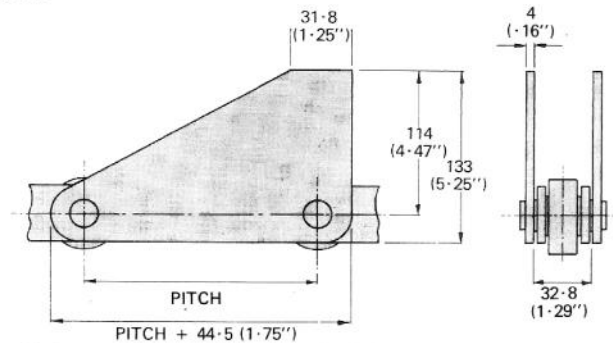
K1 = 1 HOLE K2 = 2 HOLES K3 = 3 HOLES

TYPE	PITCH		A		B		MASS kg EACH	
	mm	in	mm	in	mm	in		
K1	76.2	3.0	28	1.1	—	—	0.08	
K3	101.6	4.0	56	2.2	31.8	1.25	0.16	
K3	152.4	6.0	84	3.3	57.2	2.25	0.23	
K2	203.2	8.0	127	5.0	88.9	3.5	0.36	

Can be spaced where required,
one or both sides of chain.



Integral S Attachments



Can be spaced on outer links where required.
Also available with block bolted between plates.

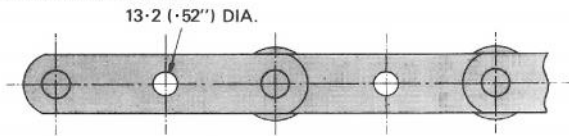


MERLEY CHAINS LTD.

Series G

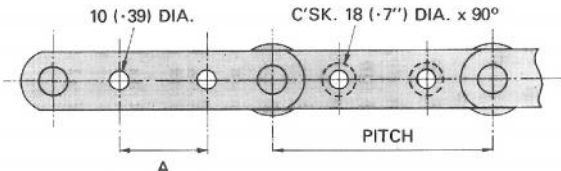
Central Attachment Hole

BOTH SIDES OF CHAIN



Two Attachment Holes

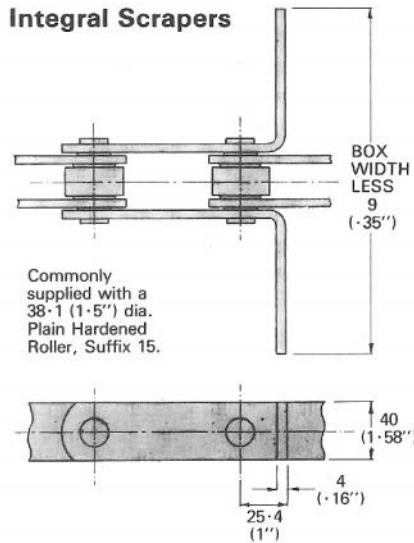
ONE OR BOTH SIDES OF CHAIN



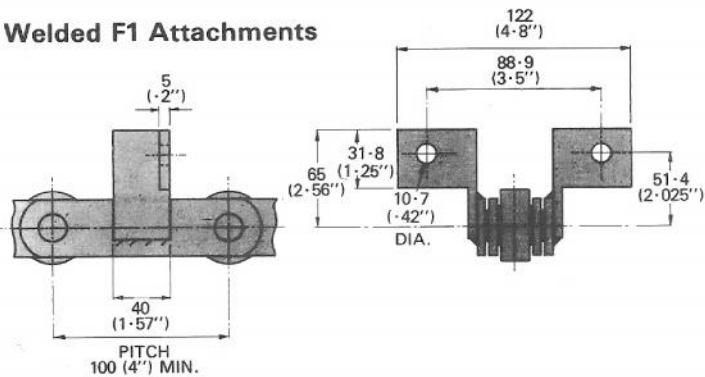
PITCH	mm	101.6	152.4
	in	4.0	6.0
A	mm	25.4	60.3
	in	1.0	2.375

Dimension A applies to a chain with a plain 47-6 dia. roller.
For other situations
modify appropriately.

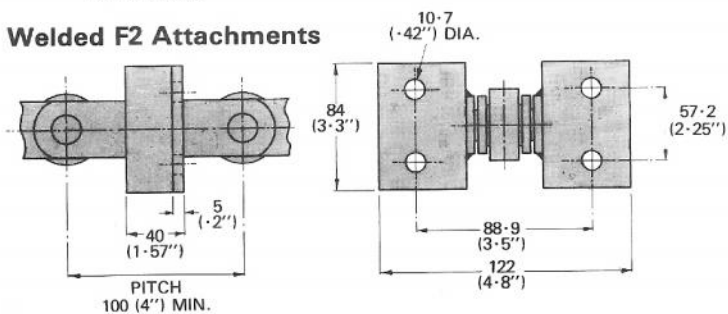
Integral Scrapers



Welded F1 Attachments

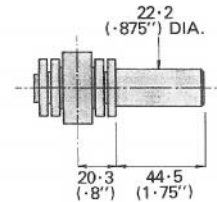


Welded F2 Attachments

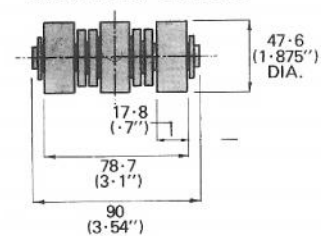


Spigot

INTEGRAL WITH SOLID STUD



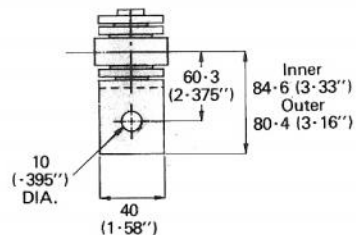
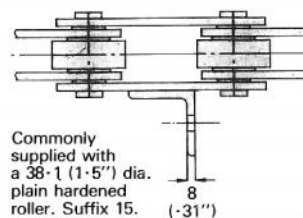
Outboard Rollers



Rollers mounted on extended studs.
Secured by rivited washer.
Flanged roller can be supplied.

Welded L1 Attachments

ON INNER OR OUTER LINK



Series G

Standard Conveyor Chain Sprockets

GREY CAST IRON, CAST TEETH, FOR USE WITH PLAIN ROLLER CHAIN.

Sprockets can be supplied:

In Stainless Steel or non ferrous materials.

Bushed in non ferrous materials.

With machine cut teeth.

Split in two halves or with segmental teeth.

Unless otherwise specified:

Bores are machined to H9 Tolerance, BS 4500 Part 1 (ISO R286).

Keyways are metric, either tapered or parallel to BS 4235 Part 1, 1972 (based on ISO/R773 & R774.)

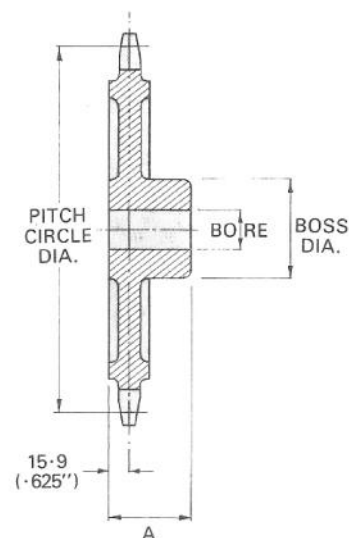
Sprockets are keywayed in pairs on centre line of tooth gap with bosses facing, deep end of tapered keyway on boss side.

Single setscrews are positioned over the keyway.

Any second setscrew positioned at 90° to the first.

PITCH mm in	No. OF TEETH	REFERENCE	PITCH CIRCLE DIA.	MAX. BORE	BOSS DIA.	A	MASS kg EACH
47·6 (1·875") ROLLER TREAD DIA.							
76·2 3·0	8	12G1/801	199·1	75	114	64	7
	12	12G1/1201	294·4	85	127	64	11
	16	12G1/1601	390·6	90	140	76	28
101·6 4·0	8	16G1/801	265·5	80	127	64	10
	12	16G1/1201	392·6	85	140	76	20
	16	16G1/1601	520·8	100	152	102	39
152·4 6·0	8	24G1/801	398·3	85	140	76	22
	12	24G1/1201	588·8	100	165	102	43
	16	24G1/1601	781·2	100	165	102	61
38·1 (1·5") ROLLER TREAD DIA.							
101·6 4·0	8	16G15/801	265·5	80		64	10
	12	16G15/1201	392·6	85		76	20

Items in bold type can be supplied without machining.



FABRICATED STEEL, FLAME CUT TEETH.

Number of teeth from 6 upwards, see page 55 for pitch circle dia.

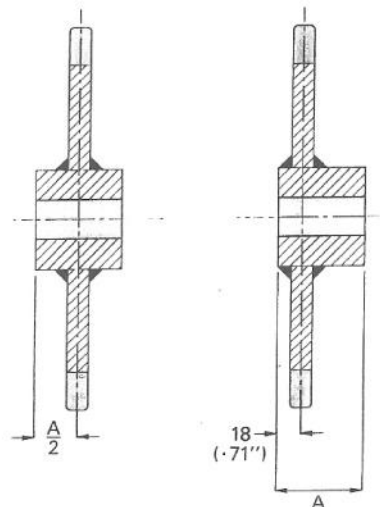
One sided or central boss, boss dia. to suit torque requirements.

Bore rough finish or fully machined to H9 tolerance.

Keywayed, setscrewed or bushed as required.

Flame hardened teeth available.

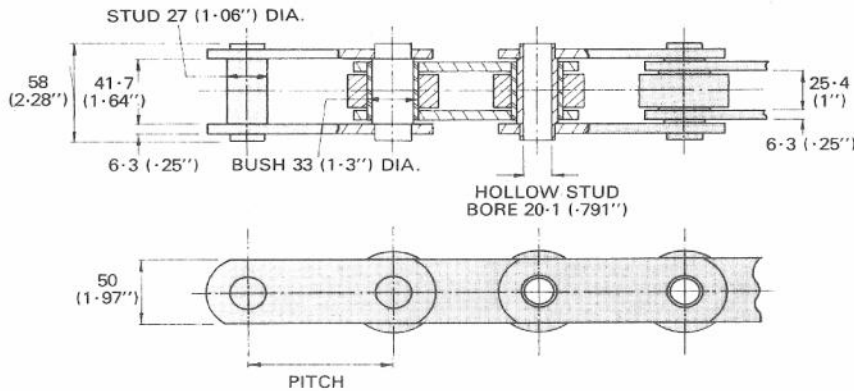
No. OF TEETH	DISTANCE THROUGH BOSS, DIMENSION A				
	CHAIN PITCH				
	76·2	100 & 101·6	125	150 & 152·4	203·2
6-9	65	65	65	75	100
10-11	65	65	75	75	100
12-14	65	75	75	100	100
15-18	75	100	100	100	115
19-21	100	100	100	115	130
22-25	100	100	115	130	140



MERLEY CHAINS LTD.

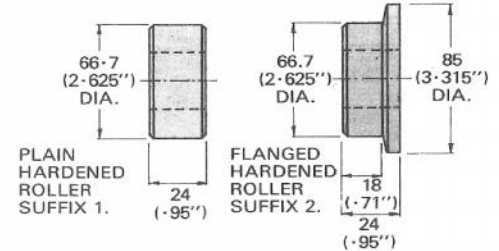
Chain Series H

Hollow Stud 107 kN (24,000 lb) TS.
Solid Stud 134 kN (30,000 lb) TS.
Stud/Bush Bearing Area 1100 mm²



Finish
a. Normal — dipped in grease.
b. Works — lightly oiled.
c. Oven — graphite coating.
d. Zinc — zinc coating throughout.
e. Moly — MoS₂ coating, round parts only.
f. Rape — dipped in rape oil.
g. Oil — dipped in light machine oil.

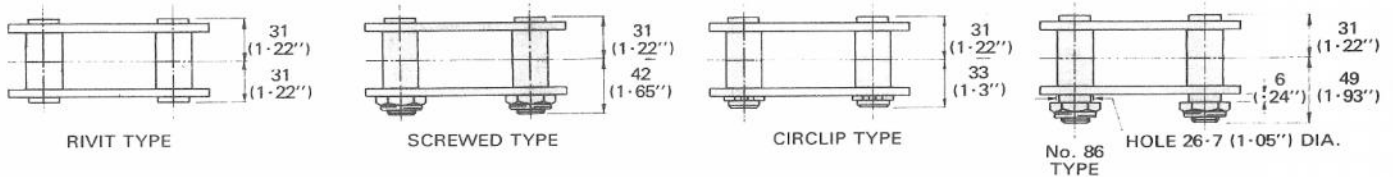
Materials
k. Normal — standard steels.
l. Enhanced — special materials and/or heat treatment.
r. Low Corrosion — 431 hardened stainless round parts.
s. Medium Corrosion — 431 hardened stainless round parts other components in 300 stainless.
u. Higher Corrosion — 300 stainless throughout.
w. Marine/Chemical — 316 stainless throughout.
y. Hot Oven — 310 stainless, except attachments.



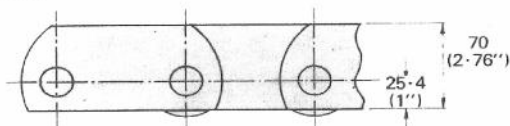
PITCH		ROLLERLESS CHAIN		PLAIN ROLLER CHAIN		FLANGED ROLLER CHAIN	
mm	in	REFERENCE	MASS kg/m	REFERENCE	MASS kg/m	REFERENCE	MASS kg/m
HOLLOW STUD CHAIN 107 kN TS.							
100	3.94	A100H9	7.97	A100H1	12.97	A100H2	13.97
101.6	4.0	A16H9	7.85	A16H1	12.77	A16H2	13.75
125	4.92	A125H9	7.38	A125H1	11.38	A125H2	12.18
127	5.0	A20H9	7.29	A20H1	11.23	A20H2	12.02
150	5.91	A150H9	7.01	A150H1	10.34	A150H2	11.01
152.4	6.0	A24H9	6.92	A24H1	10.20	A24H2	10.85
177.8	7.0	A28H9	6.67	A28H1	9.48	A28H2	10.04
203.2	8.0	A32H9	6.47	A32H1	8.93	A32H2	9.40
228.6	9.0	A36H9	6.32	A36H1	8.51	A36H2	8.94
254.0	10.0	A40H9	6.20	A40H1	8.17	A40H2	8.57
304.8	12.0	A48H9	6.01	A48H1	7.65	A48H2	7.98
SOLID STUD CHAIN 134 kN TS.							
100	3.94	B100H9	9.45	B100H1	14.45	B100H2	15.45
101.6	4.0	B16H9	9.32	B16H1	14.24	B16H2	15.20
125	4.92	B125H9	8.61	B125H1	12.61	B125H2	13.41
127	5.0	B20H9	8.48	B20H1	12.42	B20H2	13.21
150	5.91	B150H9	8.04	B150H1	11.37	B150H2	12.04
152.4	6.0	B24H9	7.92	B24H1	11.20	B24H2	11.85
177.8	7.0	B28H9	7.51	B28H1	10.32	B28H2	10.88
203.2	8.0	B32H9	7.21	B32H1	9.67	B32H2	10.16
228.6	9.0	B36H9	6.98	B36H1	9.15	B36H2	9.60
254.0	10.0	B40H9	6.79	B40H1	8.76	B40H2	9.15
304.8	12.0	B48H9	6.51	B48H1	8.43	B48H2	8.76

Also available with 47.6 (1.875") dia. Plain Rollers, Suffix 26 or fitted with Integral Double Row Ball Bearing (16-³/₈" dia. Balls). Solid Stud chains can be fitted with grease nipple lubrication. Stock chains in bold type.

Connecting Links



Deep Link



PITCH	mm	101.6	150	152.4	200	203.2
	in	4.0	5.91	6.0	7.87	8.0
CHAIN REF. (PLAIN ROLLER)		D16H1	D150H1	D24H1	D200H1	D32H1
EXTRA MASS kg/m		2.1	2.0	2.0	1.95	1.95



MERLEY CHAINS LTD.

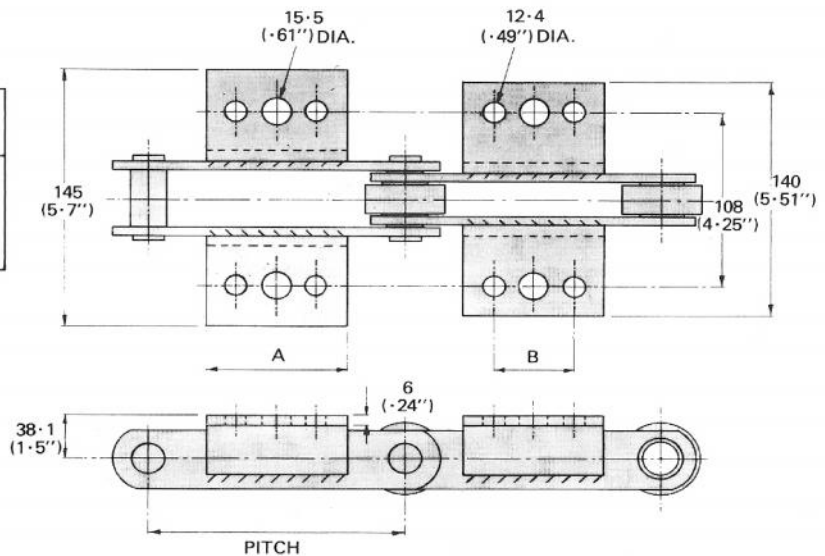
Series H

Welded K Type Attachments

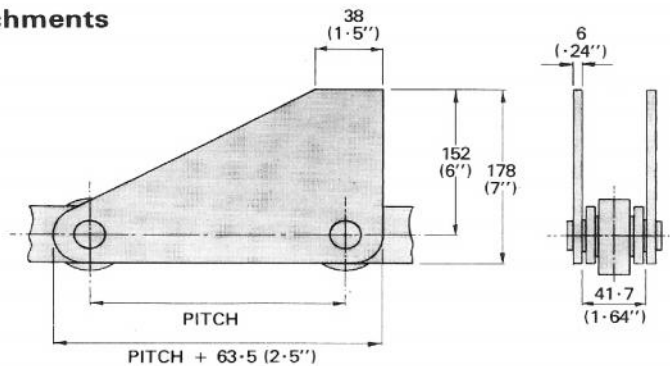
K1 = 1 HOLE K2 = 2 HOLES
K3 = HOLES

ATTACH- MENT TYPE	PITCH mm in	A mm in	B mm in	MASS kg EACH
K1 & K2	101.6 4.0	56 2.20	31.8 1.25	0.30
K3	152.4 6.0	84 3.30	57.2 2.25	0.45
K2	203.2 8.0	127 5.0	88.9 3.50	0.62
K2	304.8 12.0	168 6.60	133.4 5.25	0.91

Can be spaced where required,
one or both sides of chain.



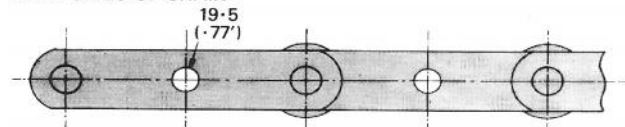
Integral S Type Attachments



Can be spaced on outer links where required.
Also available with block bolted between plates.

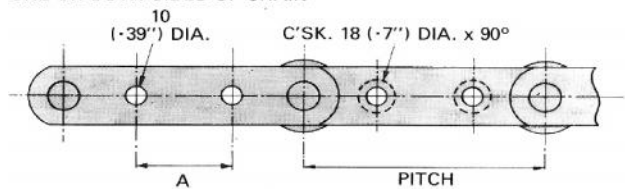
Central Attachment Hole

BOTH SIDES OF CHAIN



Two Attachment Holes

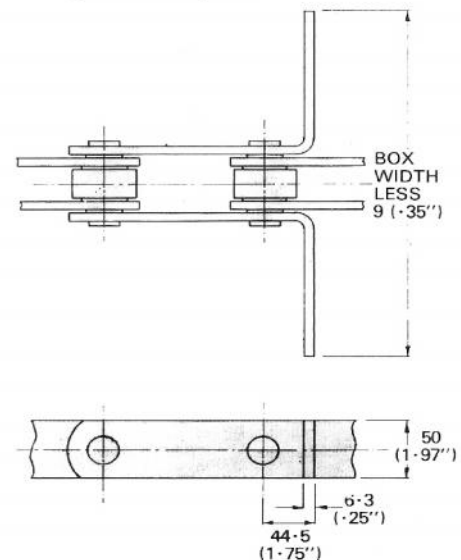
ONE OR BOTH SIDES OF CHAIN



PITCH	mm	127.0	152.4	190.5	228.6
	in	5.0	6.0	7.5	9.0
A	mm	34.9	60.3	101.6	139.7
	in	1.375	2.375	4.0	5.5

Dimension A applies to a chain with a plain 66.7 dia. roller.
For other situations modify appropriately.

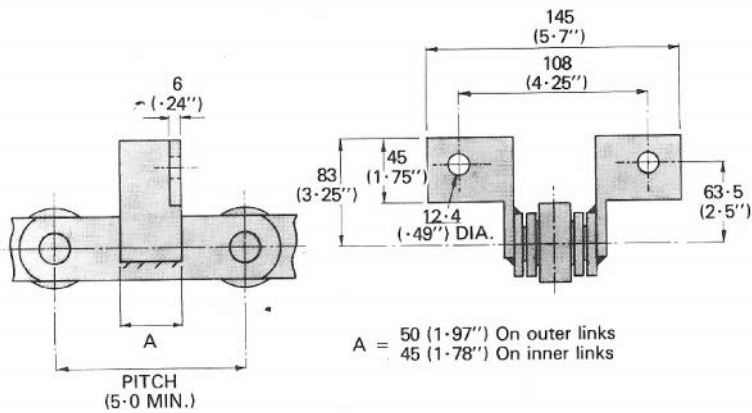
Integral Scrapers



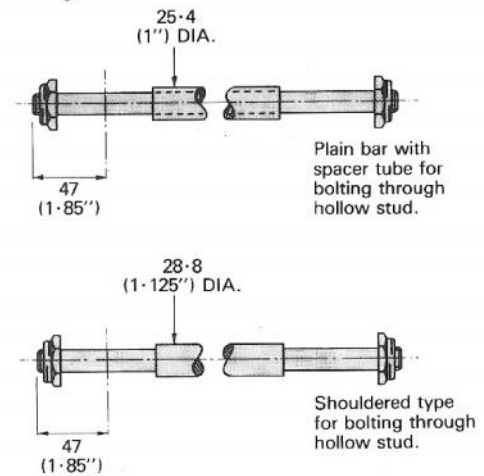
MERLEY CHAINS LTD.

Series H

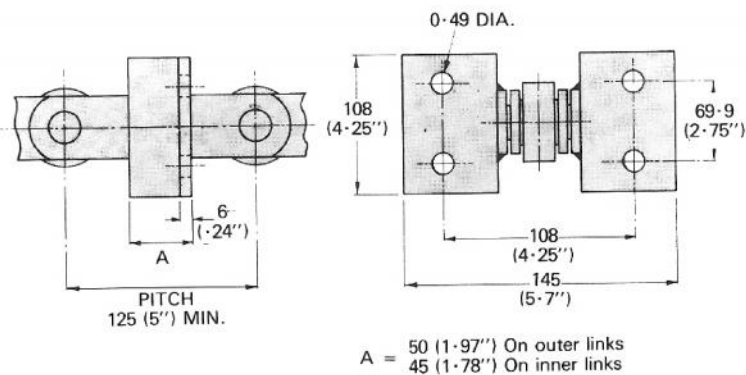
Welded F1 Attachments



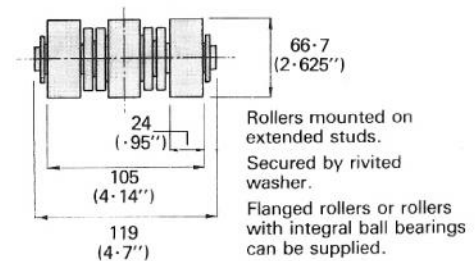
Staybars



Welded F2 Attachments

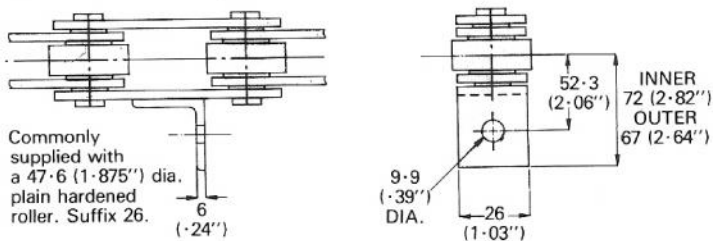


Outboard Rollers



Welded L1 Attachments

ON INNER OR OUTER LINK



MERLEY CHAINS LTD.

Series H

Standard Conveyor Chain Sprockets

GREY CAST IRON, CAST TEETH, FOR USE WITH PLAIN ROLLER CHAIN.

Sprockets can be supplied:

- In Stainless Steel or non ferrous materials.
- Bushed in non ferrous materials.
- With machine cut teeth.
- Split in two halves or with segmental teeth.

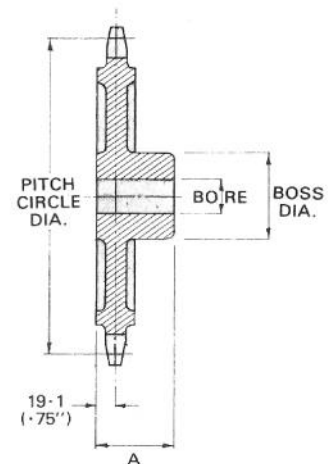
Unless otherwise specified:

- Bores are machined to H9 Tolerance, BS 4500 Part 1 (ISO R286).
- Keyways are metric, either tapered or parallel to BS 4235 Part 1, 1972 (based on ISO/R773 & R774.)
- Sprockets are keywayed in pairs on centre line of tooth gap with bosses facing, deep end of tapered keyway on boss side.
- Single setscrews are positioned over the keyway.
- Any second setscrew positioned at 90° to the first.

PITCH		No. OF TEETH	* REFERENCE	PITCH CIRCLE DIA.	MAX. BORE	BOSS DIA.	A	MASS kg EACH
mm	in							
101.6	4.0	8	16H1/801*	265.5	95	150	83	12
		12	16H1/1201*	392.6	100	165	90	23
		14	16H1/1401	456.6	110	180	95	33
		16	16H1/1601	520.8	120	190	102	41
125	4.92	8	125H1/801	326.6	100	165	90	15
127	5.0	8	20H1/801	331.9	100	165	90	18
		12	20H1/1201	420.7	110	190	102	37
		24	20H1/2401	973.0	120	215	114	130
152.4	6.0	6	24H1/601	304.8	100	180	90	15
		8	24H1/801	398.2	100	165	90	23
		10	24H1/1001	493.2	110	180	102	37
		12	24H1/1201	588.8	120	190	102	52
		16	24H1/1601	781.2	130	215	114	90
		24	24H1/2401	1167.6	140	230	127	165
177.8	7.0	8	28H1/801	464.6	100	180	90	38
		16	28H1/1601	911.4	120	220	121	105
203.2	8.0	8	32H1/801*	531.0	120	190	102	41
		10	32H1/1001	657.6	130	215	114	65
		12	32H1/1201	785.1	130	215	114	88
		13	32H1/1301	849.1	130	215	114	110
		14	32H1/1401	913.2	130	215	114	125
228.6	9.0	8	36H1/801*	597.4	110	185	102	55
254.0	10.0	8	40H1/801	663.7	110	190	102	65
304.8	12.0	8	48H1/801*	796.5	135	215	114	93
		12	48H1/1201	1177.7	135	280	127	168

*Available with central boss.

Items in bold type can be supplied without machining.



Strengthening ribs are incorporated where necessary.

FABRICATED STEEL, FLAME CUT TEETH.

Number of teeth from 6 upwards, see page 55 for pitch circle dia.

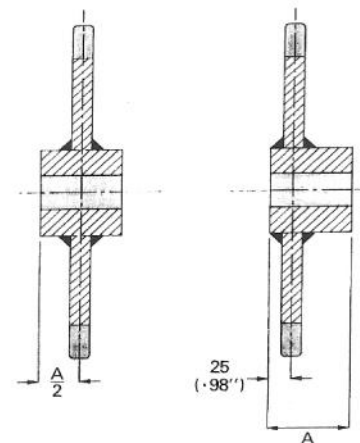
One sided or central boss, boss dia. to suit torque requirements.

Bore rough finish or fully machined to H9 tolerance.

Keywayed, setscrewed or bushed as required.

Flame hardened teeth available.

No. OF TEETH	DISTANCE THROUGH BOSS, DIMENSION A							
	CHAIN PITCH							
	101.6	125 & 127	152.4	177.8	203.2	228.6	254.0	304.8
6-9	85	90	90	100	100	100	100	115
10-11	85	90	100	100	100	115	115	130
12-14	90	100	100	100	115	115	115	130
15-18	100	100	115	115	130	—	—	—
19-21	105	105	115	130	—	—	—	—
22-25	115	115	130	—	—	—	—	—



MERLEY CHAINS LTD.