INTERNATIONAL STANDARD 1977 / III

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Conveyor chains, attachments and chain wheels — Part III : Attachments — Metric series

Chaînes convoyeurs, plaques d'attache et roues pour chaînes — Partie III : Plaques d'attache — Série métrique

First edition — 1974-07-01

UDC 621.867.3

Ref. No. ISO 1977/III-1974 (E)

Descriptors : conveyors, fixing plates, chains, chain conveyors, dimensions.

Price based on 3 pages

FOREWORD

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Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 1997/III (originally ISO/DIS 2565) was drawn up by Technical Committee ISO/TC 100, *Chains and chain wheels for power transmission and conveyors*, and circulated to the Member Bodies in August 1972.

It has been approved by the Member Bodies of the following countries :

Australia	France	South Africa, Rep. of
Austria	Germany	Spain
Belgium	India	Sweden
Czechoslovakia	Ireland	Thailand
Egypt, Arab Rep. of	Japan	United Kingdom
Finland	Romania	U.S.A.

No Member Body expressed disapproval of the document.

Printed in Switzerland

Conveyor chains, attachments and chain wheels — Part III : Attachments — Metric series

0 INTRODUCTION

This document forms part of ISO 1977, dealing with conveyor chains, attachments and chain wheels. Other parts are :

— Part I : *Chains — Metric series.* [1)]

— Part II : *Chain wheels.*

1 SCOPE AND FIELD OF APPLICATION

This International Standard gives specifications for K attachments and deep plate attachments for use with conveyor chains conforming with the requirements of part I.

2 NOMENCLATURE

The nomenclature of these attachments is given in figures 1 and 2.

3 DIMENSIONS

3.1 The dimensions of K type attachments are given in table 1.

3.2 The dimensions of deep plate attachments are given in table 2. All other data, including chain breaking loads, are as given in part I.

4 TYPES

Three types of K attachment plates are given, having common dimensions as detailed in table 1, and designated as follows :

— K1 : with one attachment hole centrally disposed in each plate;

— K2 : with two attachment holes disposed in each plate as shown in figure 1;

— K3 : as K2 but with a third hole centrally positioned between the other two.

Attachments may be fitted on one or both sides of the chain.

5 MANUFACTURE (K ATTACHMENTS ONLY)

5.1 For convenience, the K attachments are illustrated in figure 1 as being manufactured from rolled steel angle section, but the actual construction is left to the discretion of the manufacturer and may be of integral form whereby the actual chain plates are bent over to form the platform.

5.2 The attachment length is left to the discretion of the manufacturer but should be sufficient to accommodate the attachment holes of the K2 attachment plate.

6 MARKING (INTEGRAL K AND DEEP PLATES)

The marking shall be in accordance with part I and be the same as would normally appear on the basic chain plates which they replace.

1) In preparation. (Revision of ISO/R 1977.)

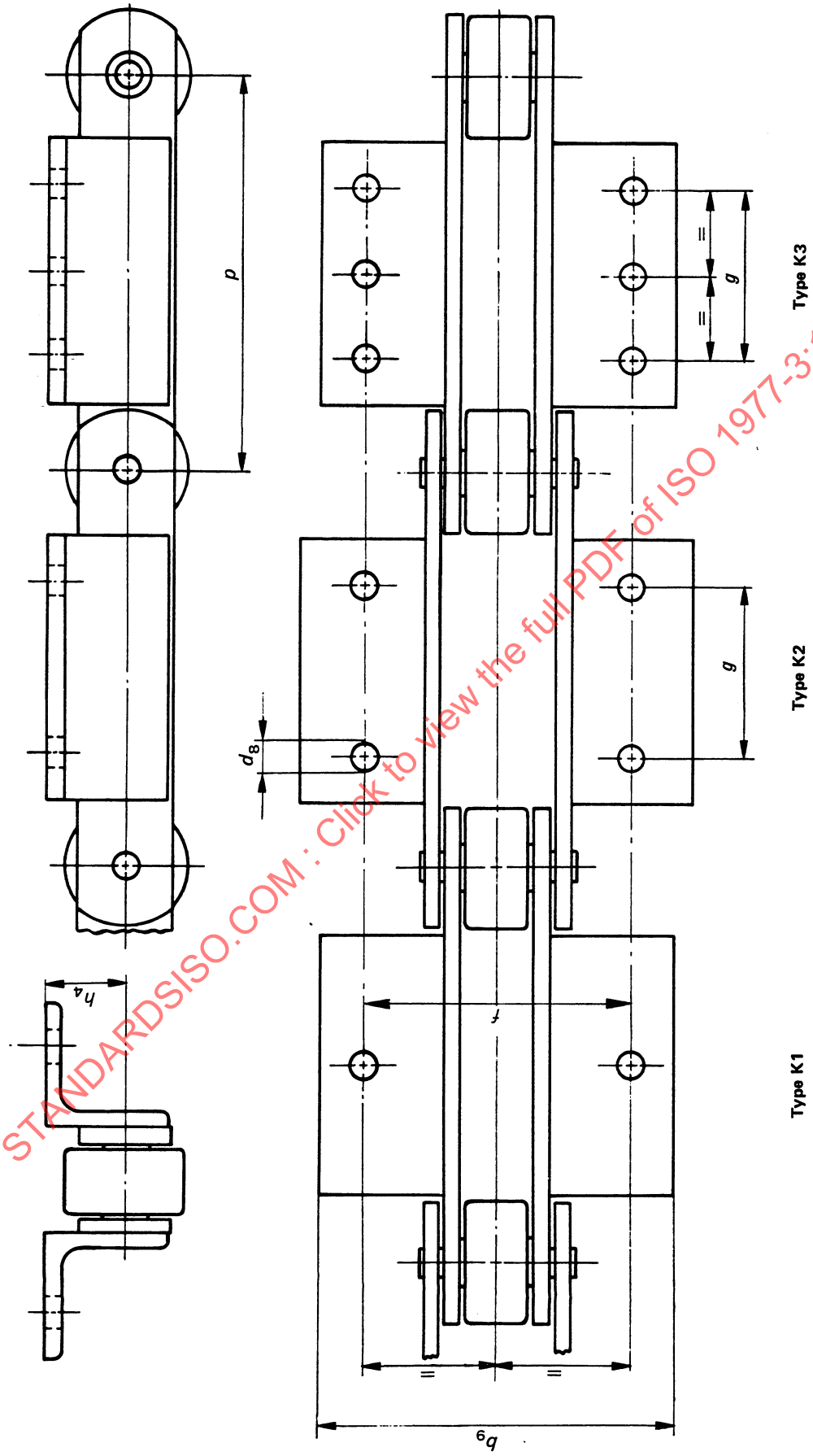

FIGURE 1 – Nomenclature of K attachements – Key to table 1

TABLE 1 — **Dimensions of K attachments**

Dimensions in millimetres

1	2	3	4	5	6	7	8	9	10	11
ISO chain number	**Hole diameter**	**Platform height**	**Transverse distance between hole centres**	**Width over attachments**	**Longitudinal distance between hole centres**					
					short		medium		long	
	d_8	h_4	f	b_9 (max.)	p min.*	g	p min.*	g	p min.*	g
M20	6,6	16	54	84	63	20	80	35	100	50
M28	9,0	20	64	100	80	25	100	40	125	65
M40	9,0	25	70	112	80	20	100	40	125	65
M56	11,0	30	88	140	100	25	125	50	160	85
M80	11,0	35	96	160	125	50	160	85	200	125
M112	14,0	40	110	184	125	35	160	65	200	100
M160	14,0	45	124	200	160	50	200	85	250	145
M224	18,0	55	140	228	200	65	250	125	315	190
M315	18,0	65	160	250	200	50	250	100	315	155
M450	18,0	75	180	280	250	85	315	155	400	240
M630	24,0	90	230	380	315	100	400	190	500	300
M900	30,0	110	280	480	315	65	400	155	500	240
MC28	9,0	25	70	112	80	20	100	40	125	65
MC56	11,0	35	88	152	125	50	160	85	200	125
MC112	14,0	45	110	192	160	50	200	85	250	145
MC224	18,0	65	140	220	200	50	250	100	315	155

* Minimum chain pitch for g.

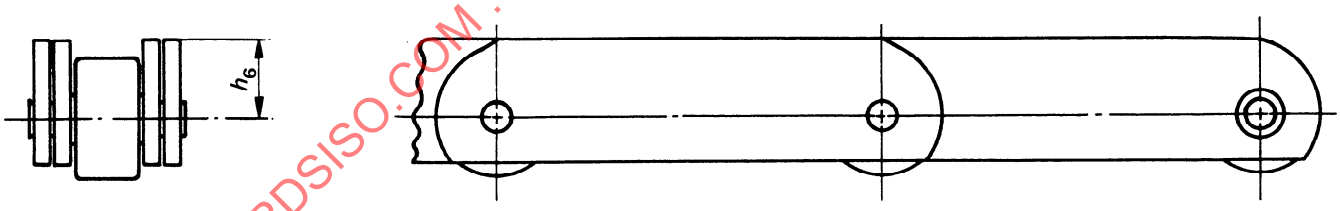

FIGURE 2 — **Nomenclature of deep plates — Key to table 2**

TABLE 2 — **Dimensions of deep plates**

Dimensions in millimetres

Chain number	**M20**	**M28**	**M40**	**M56**	**M80**	**M112**	**M160**	**M224**	**M315**	**M450**	**M630**	**M900**	**MC28**	**MC56**	**MC112**	**MC224**
Plate height h_6	16	20	22,5	30	32,5	40	45	60	65	80	90	120	22,5	32,5	45	65

NOTE — All other data, including breaking loads, are as given for the basic chain plates (see part I).

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