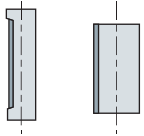
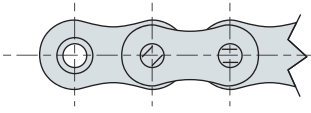
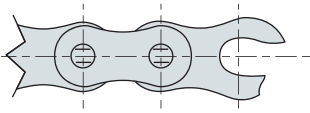


Trouble Shooting Hints

The below chart shows the most common chain failures and causes, but not necessarily the only ones.

Problem	Possible Causes of Problem	Suggested Remedy
<p>Pin or Bushing Galling</p> 	<ul style="list-style-type: none"> • Overload • Inadequate lubrication 	<ul style="list-style-type: none"> • Proper lubrication • Replace chain when elongation exceeds functional limits
<p>Turned Pins</p> 	<ul style="list-style-type: none"> • Overload • Inadequate lubrication 	<ul style="list-style-type: none"> • Replace chain as soon as possible
<p>Excessive Noise</p>	<ul style="list-style-type: none"> • Too little or too much slack • Chain obstruction • Loose chain guard or bearing 	<ul style="list-style-type: none"> • Adjust centers or take-up • Inspect & remove obstruction • Tighten bolts and check bearings
<p>Chain Vibration</p>	<ul style="list-style-type: none"> • Excessive chain slack • Center distance too long • Stiff links 	<ul style="list-style-type: none"> • Adjust chain tensioner • Install idler • Lubricate or replace chain
<p>Wear on inside of link plate and one side of sprocket teeth</p>	<ul style="list-style-type: none"> • Misalignment 	<ul style="list-style-type: none"> • Realign sprockets and shafts • Replace chain and sprockets if necessary
<p>Chain Stiffness</p>	<ul style="list-style-type: none"> • Excessive load • Misalignment • Inadequate lubrication • Corrosion 	<ul style="list-style-type: none"> • Replace chain with one of suitable strength • Inspect alignment • Clean and establish correct lubrication • Replace with corrosion resistant chain
<p>Chain Climbs Sprockets</p>	<ul style="list-style-type: none"> • Excessive chain wear • Excessive chain slack • Inadequate lubrication • Sprocket tooth wear 	<ul style="list-style-type: none"> • Replace chain • Install tensioner if necessary • Replace sprocket
<p>Fractured Plate</p> 	<ul style="list-style-type: none"> • Extreme overload 	<ul style="list-style-type: none"> • Inspect the drive to determine the cause of high load • Redesign drive using a higher capacity chain

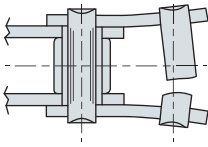
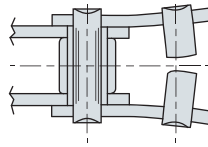
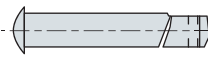
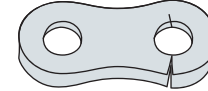
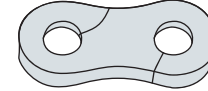
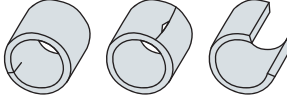
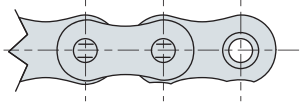
BS Single Pitch

ANSI Single Pitch

ANSI Double Pitch

ENGL. 81X

Technical Information

Problem	Possible Causes of Problem	Suggested Remedy
<p>Broken Pins</p> 	<ul style="list-style-type: none"> • Extreme overload 	<ul style="list-style-type: none"> • Inspect the drive to determine the cause of high load • Redesign drive using a higher capacity chain
<p>Broken Pins(center)</p> 	<ul style="list-style-type: none"> • Loading is greater than pins dynamic capacity 	<ul style="list-style-type: none"> • Inspect the drive to determine the cause of high load • Redesign drive using a higher capacity chain
<p>Broken Offset Link Pins</p> 	<ul style="list-style-type: none"> • Overload 	<ul style="list-style-type: none"> • One-pitch offsetlinks are not recommended • Redesign drive using a higher capacity chain
<p>Fatigue Fracture</p> 	<ul style="list-style-type: none"> • Loading is greater than chain's dynamic capacity 	<ul style="list-style-type: none"> • Inspect the drive to determine the cause of high load • Redesign drive using a higher capacity chain
<p>Cracking</p> 	<ul style="list-style-type: none"> • Stress corrosion cracking 	<ul style="list-style-type: none"> • Protect the chain from corrosion • Install anti-corrosive chains
<p>Broken Rollers</p> 	<ul style="list-style-type: none"> • Foreign material between chain and sprocket tooth • Fatigue failure 	<ul style="list-style-type: none"> • Redesign chain speed and load • Shield drive from foreign matter
<p>Worn Plates</p> 	<ul style="list-style-type: none"> • Bottom of plates worn due to rubbing on guides 	<ul style="list-style-type: none"> • Chain should be replaced when wear becomes over 5% of the plates height