

■ WELDED STEEL CHAINS

INDUSTRY'S HIGH PERFORMANCE WELDED STEEL CHAINS

Rex® Welded Steel chains are the material handling industry's choice for the most demanding applications. Our customers know that Rex chains provide superior strength and durability for extended wear life and trouble free service.

Rexnord Corporation, manufacturers of Rex chain for over 100 years, is the leader in the chain industry. Our years of experience provide unique expertise in material selection, heat treatment and chain design for improved chain strength and long wear life. What this means to you is superior value and greater productivity.

THE REX WELDED STEEL STORY

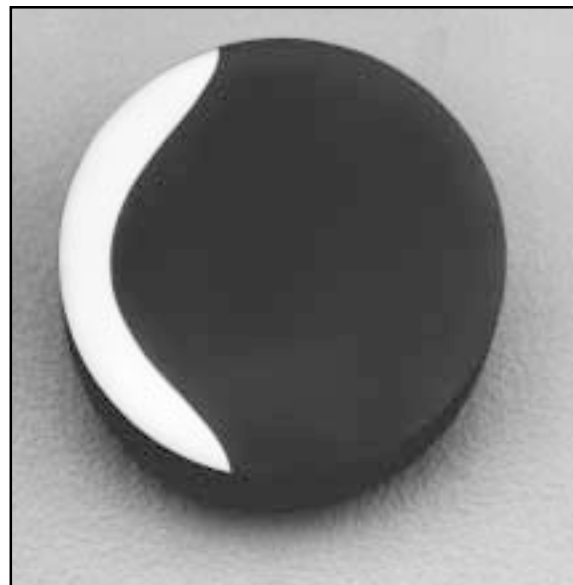
A lot goes into a Rex chain that is not visible on the surface. The precision of a diameter or the case depth of an induction hardened part can only be realized after an in-depth analysis. Rexnord regularly tests Rex and competitive chains and it is clear, all welded chains are not created equally. What follows is the story of how we make Rex welded steel chains to be the best – anywhere in the world!

Maximizing Chain Wear Life Through Superior Heat Treatments

Chain wear life is directly affected by the hardness of the wearing components. Quite simply, the harder the parts, the longer the wear life. Rexnord's heat treatment technology exceeds that of other chain manufacturers.

Computer controlled furnaces, and Rexnord designed induction heat treating equipment, produce chain components with the industry's hardest possible wearing surfaces and yet still provide the necessary toughness to resist shock loads. In addition, unique Rexnord process controls provide chains with consistent wear life. This allows users to predict the wear life of their chains, allowing for chain replacement as part of their preventative maintenance programs. In the end, superior chain eliminates costly and unexpected down time.

All Rex welded steel chains come standard with "premium" heat treatments. The photo (top right) shows a cross section of a Selectively Induction Hardened (SIH) chain pin. This exclusive Rexnord process involves super hardening only the portion of the chain rivet that wears as the chain articulates over the sprockets. The remainder of the rivet is



A cross section of a selectively induction hardened WHX pin – the crescent area is super-hardened to dramatically lengthen pin wear life. The balance of the pin material is left in the thru-hardened condition to give the pin excellent toughness.

held at thru-hardening levels to assure chain toughness and resistance to breakage. This treatment is standard on WHX Narrow Mill chains. Other manufacturers of welded chain compromise their design, either sacrificing component hardness or resistance to overloads.

Rex Wide Mill heat treated chains (WDH) come standard with thru-hardened rivets, sidebars and barrels. Other manufactures short-change wear life by not hardening the barrels – significantly reducing chain wear life. Only Rex Wide Mill chains have thru-hardened barrels!

The table below illustrates the importance of superior heat treatment. By using the table, one can predict the increase in wear life by upgrading the heat treatment. As an example, increasing hardness from 35RC to 60RC could provide up to double the chain life!

Importance of Heat Treatment

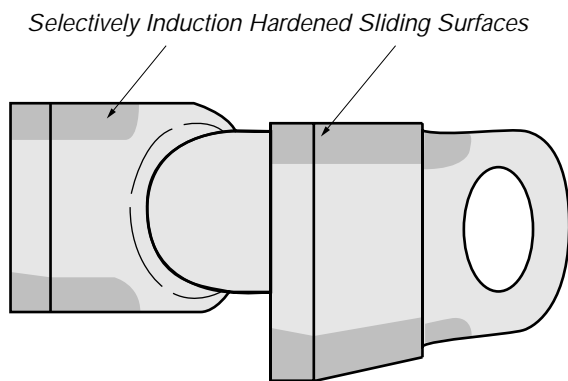
Heat Treatment	Not Hardened	Thru-Hardened	Induction Hardened
Hardness RC (typ)	20	35	60
Relative Wear Life*	1	2	4

**Dry operating conditions*

■ WELDED STEEL CHAINS

Maximizing Chain Wear Life – (Cont'd.)

The Rexnord story continues with a variety of heat treating options to further extend wear life and increase your plant's productivity. The graphic below represents a chain link with Selectively Induction Hardened (SIH) sidebars. This process can be applied to chain links to greatly improve sliding wear. If you regularly replace chains due to sidebar wear, you should select SIH sidebars. This is a very cost effective way to increase your chain life.



Selectively Induction Hardened sidebars can be ordered to give greater resistance to abrasive sliding wear, thus providing greater sidebar life.

To extend wear life in especially corrosive applications, Rex welded steel chains can be provided with a variety of plating options or with stainless steel components. Contact Rexnord for application assistance. Let us put 100 years of experience to work for you!

MAXIMIZING CHAIN STRENGTH

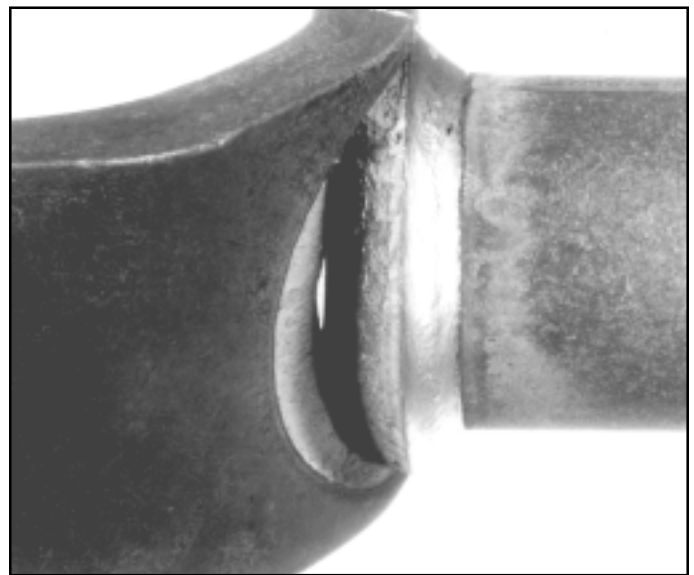
A key factor leading to the durability of Rex welded steel chains is superior fatigue strength.

Rex Narrow Series welded steel chains have tightly controlled, interference fits between the pin and chain sidebar hole. This interference fit creates a beneficial residual stress in the sidebar to greatly increase the fatigue life of the chain. The chains have a “stepped” (3 diameter) pin to ease assembly and protect the integrity of the interference fit.

Competitive chains with poorly controlled interference fits (or with clearance fits!) have much lower fatigue strength. Low fatigue strength chains are subject to unexpected chain failures after a chain sees many cycles of loading.

Another key factor in providing maximum chain strength is proper welding, stress relieving, and heat treatment. Improper controls and processes can lead to failures around the weld either from improper weld penetration or by causing high hardness zones that result in brittle failures. Rexnord uses the latest technology in process and quality controls to assure proper weldments.

Rex welded links are regularly tested during each manufacturing lot to assure our process is in control, producing high quality welds. The photo below shows a welded steel link that has been destructively tested to assure the strength and penetration of the weld. As demonstrated in the photo, the chain material failed first, not the weld. This demonstrates a high quality weld.



Rexnord's quality assurance program requires welded steel links to be tested for weld strength and penetration.

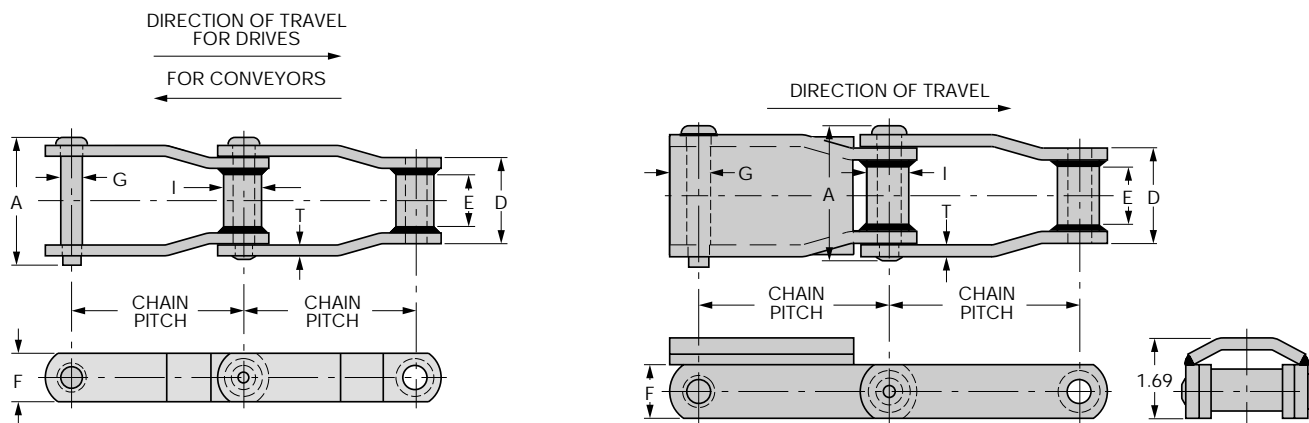
MAXIMIZING PLANT PRODUCTIVITY

Rexnord Corporation brings many years of application and design experience with it to your plant in the form of chain, bearings and other fine power transmission components. Our sales people and application engineers are eager to work with your organization to maximize the productivity of your plant. Please call us for any assistance we might offer. We look forward to working with you.

WELDED STEEL CHAINS

NARROW SERIES WR, WH, WHX AND WSX

- WR chains have only thru-hardened rivets.
- WH chains have all parts thru-hardened.
- WHX chains have thru-hardened parts and selectively induction hardened rivets as standard.
- WSX chains have all stainless steel construction. Sidebars are 300 series; pins and barrels are precipitation hardened stainless.
- Riveted construction is standard. Pin and cottered construction can be furnished on a made-to-order basis.



NARROW SERIES

Dimensions are in inches. Strengths, loads and weights are in pounds.

Rex Chain No.	Average Pitch	A	E	Sidebars		Pins	Barrel		Minimum Ultimate Strength, Lbs. x 10 ³	Rated Working Load	Average Weight Per Foot	Sprocket Unit [Ⓞ] No.
				Thickness	Height		G	D				
				T	F							
WR78	2.609	2.98	1.12	0.25	1.13	0.50	2.00	0.88	21,000	3,000	4	78
WH78	2.609	2.98	1.12	0.25	1.13	0.50	2.00	0.88	25,500	3,500	4	78
WHT78	2.609	2.98	1.12	0.25	1.13	0.50	2.00	0.88	25,500	3,500	6	78
WH82	3.075	3.25	1.25	0.25	1.25	0.56	2.25	1.22	29,500	4,400	6	103
WH9103HD	3.075	3.81	1.25	0.38	1.50	0.75	2.28	1.25	51,000	6,000	8	103
WH784	4.000	2.98	1.12	0.25	1.13	0.50	2.00	0.88	24,000	3,500	3	130
WHT130/138	4.000	2.98	1.12	0.25	1.13	0.50	2.00	0.88	24,000	3,500	6	130
WHX124	4.000	4.18	1.63	0.38	1.50	0.75	2.81	1.44	50,500	7,350	9	H124
WHX124HD	4.063	4.82	1.63	0.50	2.00	0.88	3.00	1.63	80,000	9,150	14	H124
WSX124	4.000	4.35	2.01	0.38	1.50	0.75	2.81	1.44	Consult Rexnord		14	H124
WHX111	4.760	4.79	2.25	0.38	1.50	0.75	3.38	1.44	50,500	8,850	8	111
WH720CS	6.000	3.61	1.12	0.31	1.56	0.75	2.16	1.44	54,000	5,700	6	CS720S
WHX106	6.000	4.18	1.63	0.38	1.50	0.75	2.81	1.44	50,500	7,350	7	106
WHX106SHD	6.000	4.78	1.50	0.50	2.00	0.88	3.00	1.63	82,000	9,150	12	106
WHX106XHD	6.050	4.87	1.63	0.50	2.00	1.00	3.00	1.75	Consult Rexnord		13	106
WH110	6.000	4.57	1.88	0.38	1.50	0.75	3.00	1.25	50,500	7,900	7	110
WHX132	6.050	6.31	3.00	0.50	2.00	1.00	4.38	1.75	85,000	15,000	14	132
WSX132	6.050	6.25	3.00	0.50	2.00	1.00	4.38	1.75	Consult Rexnord		14	132
WHX150	6.050	6.31	3.00	0.50	2.50	1.00	4.38	1.75	90,000	15,000	16	132
WHX155	6.050	6.48	2.75	0.56	2.50	1.13	4.38	1.75	102,000	17,500	19	132
WHX157	6.050	6.68	2.75	0.63	2.50	1.13	4.63	1.75	117,000	18,200	20	132
WHX2855	6.050	6.57	2.75	0.63	2.50	1.25	4.63	1.75	140,000	20,250	20	132
WHX3855	6.050	6.57	2.75	0.63	3.00	1.25	4.63	1.75	175,000	20,250	22	132
WHX159	6.125	6.87	2.88	0.63	3.00	1.25	4.63	2.00	204,000	20,250	27	132
WHX4855	12.000	6.57	2.75	0.63	2.50	1.25	4.63	1.75	119,000	20,250	15	4855

[Ⓞ] Cast or fabricated sprockets may be used.

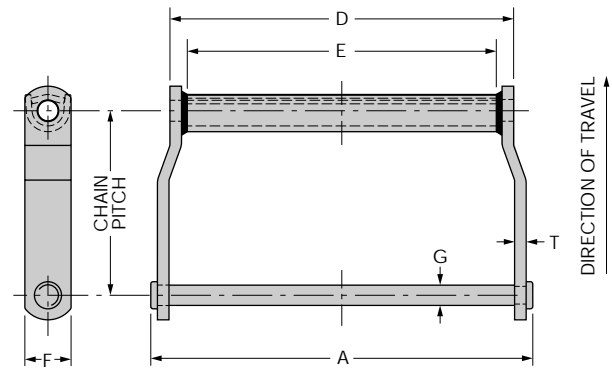
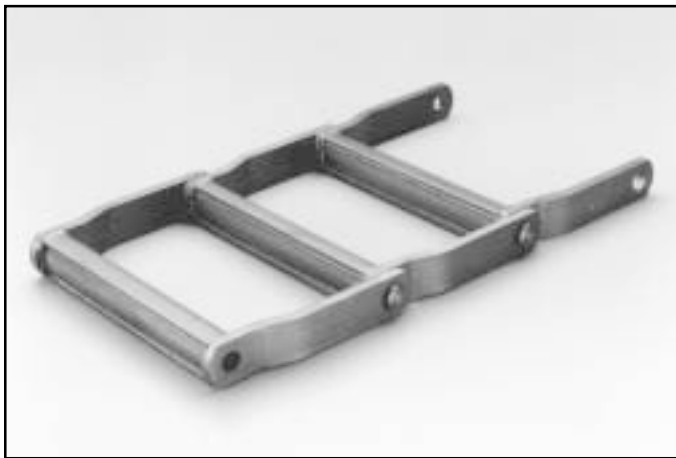
WELDED STEEL CHAINS

WIDE SERIES – WD, WDH

Rex® Wide Series chains are furnished standard with heat-treated rivets only (WD Series) or all components heat-treated (WDH Series). WDH Series chains are intended for use in applications where joint wear, barrel OD wear, and sidebar wear are a problem.

- WD Series have thru-hardened rivets.
- WDH Series have all parts thru-hardened.
- Riveted construction is standard. Pin and cottered construction can be furnished on a made-to-order basis.
- Lube holes drilled into barrels is an MTO option.
- Induction hardened pins are an MTO option.
- Galvanized pins are an MTO option.

➔ **Rexnord has found that some competitive wide mill drag chains use a low carbon steel for their barrels. A low carbon steel will not respond to heat treatment even though it may be put in a furnace and attempted to be heat treated. Rex Welded Steel chains use medium carbon steel barrels that respond very well to heat treatment and provide twice the wear resistance of these low carbon barrels. Harder components, longer life!**



Rex Wide Series Chains are specially designed for loads and operating conditions imposed by drag conveyor service. As with our Narrow Series, many material and configuration options are available.

WELDED STEEL CHAINS

Dimensions are in inches. Strengths, loads and weights are in pounds.

Rex Chain No.		Average Pitch	A	E	Sidebars		Pins	Barrel Length	Minimum Ultimate Strength, Lbs. x 10 ³		Rated Working Load		Average Weight Per Foot	Sprocket [Ⓞ] Unit No.
WD Series	WDH Series				Thickness	Height			WD Series	WDH Series	WD Series	WDH Series		
					T	F								
WD102	WDH102	5.000	9.13	6.50	0.38	1.50	0.75	7.75	38,300	55,000	8,500	10,000	11	H102
WD104	WDH104	6.000	6.75	4.13	0.38	1.50	0.75	5.38	38,300	55,000	8,500	10,000	9	H104
WD110	WDH110	6.000	11.8	9.00	0.38	1.50	0.75	10.38	38,300	55,000	8,500	10,000	12	H110
WD113	WDH113	6.000	12.5	9.00	0.50	1.50	0.88	10.63	48,000	57,000	9,300	11,700	18	H110
WD120	WDH120	6.000	12.1	8.75	0.50	2.00	0.88	10.25	70,000	79,000	12,300	15,000	20	H120
WD112	WDH112	8.000	11.8	9.00	0.38	1.50	0.75	10.38	38,300	55,000	8,500	10,000	10	H112
WD116	WDH116	8.000	15.5	13.0	0.38	1.75	0.75	14.13	55,000	59,000	10,700	11,500	13	H116
WD118	WDH118	8.000	16.8	13.3	0.50	2.00	0.88	14.88	70,000	79,000	12,300	15,000	21	WD118 [Ⓞ]
WD480	WDH480	8.000	14.6	11.2	0.50	2.00	0.88	12.75	70,000	79,000	12,300	15,000	18	H480
	WDH580	8.000	14.6	11.2	0.50	2.00	1.00	12.75	–	108,000	–	20,500	18	H480
	WDH680	8.000	15.33	11.2	0.63	2.00	1.00	13.00	–	108,000	–	20,500	21	H480

[Ⓞ] Cast or fabricated steel sprockets may be used except as noted.

[Ⓞ] Available as a fabricated steel sprocket only.

Note: Dimensions are subject to change. Certified dimensions of ordered material are furnished upon request.

WELDED STEEL CHAINS

NEW! REVERSE BARREL WIDE MILL DRAG CHAINS

A simple and effective solution for an old problem.

The Problem: Since their introduction, wide mill welded steel chains were designed to run “narrow” or “closed end” forward. This is the direction of travel that the chains on the preceding page run. Running in this direction, an offset sidebar chain will experience scrubbing between the outside of the chain’s barrel and the drive sprocket’s tooth (Figure 1). On shorter conveyors, where the chain contacts the sprocket very frequently, this scrubbing can cause rapid wear of both the chain and sprocket. This scrubbing may not cause as much chain wear on longer conveyors but it will still cause sprocket wear.

The Solution: Rexnord engineers realized that if they reversed the barrel of the chain so it could run in the opposite direction, “wide” or “open end” forward, the scrubbing action could be eliminated. Instead of the articulation occurring between the outside of the chain barrel and the sprocket tooth it occurs inside the chain joint between the pin and the barrel (Figure 2). This arrangement is preferable since both the pin and the barrel of the wide mill chains are heat treated to withstand this type of wear.

How do I Know if I Need Reverse Barrel Chain?

Note the difference in position of the pin within the barrel in Figures 1 and 2. When running narrow end forward and the engaged pin is being pulled forward at the time of engagement and the pin of the previous link is being pulled against the front of the barrel.

When reverse barrel chain is run wide end forward (Figure 2), the sprocket is pushing against the force applied. This may extend the useful life of chains used in long and/or heavy loaded applications where the typical mode of chain failure is breaking at the barrel welds.

Articulation is Between Chain Barrel and Sprocket Tooth

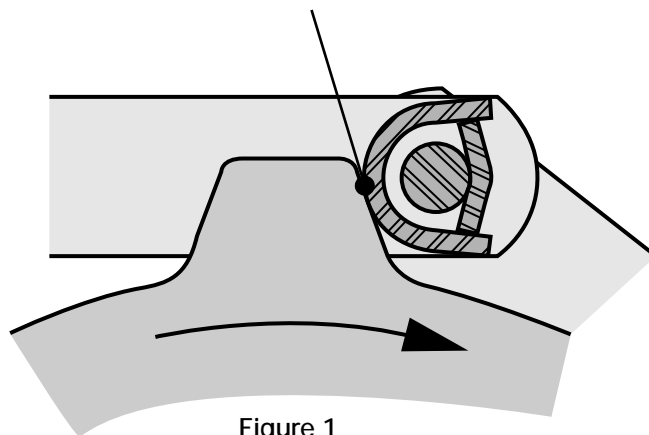


Figure 1

Articulation is Between Pin and Barrel

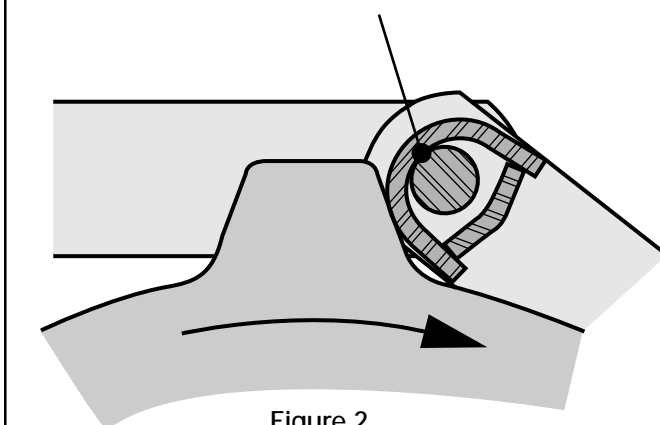
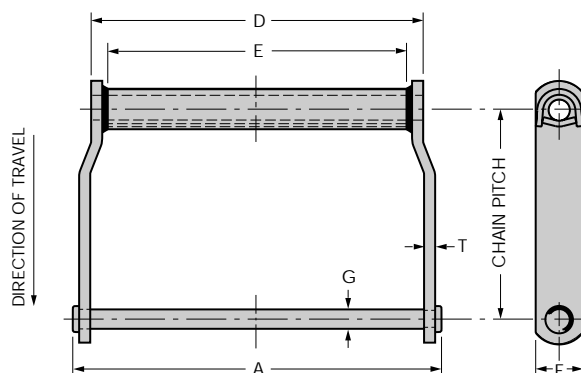


Figure 2



Dimensions are in inches. Strengths, loads and weights are in pounds.

Rex Chain No.	Average Pitch	A	E	Sidebars		Pins	Barrel Length	Minimum Ultimate Strength, Lbs. x 10 ³	Rated Working Load	Average Weight Per Foot	Sprocket Unit No.
				Thickness	Height						
				T	F	G	D				
WDH2210	6.136	11.9	9.00	0.38	1.50	0.75	10.38	55,000	10,000	11.5	H110
WDH2316	8.126	15.8	13.00	0.38	1.75	0.75	14.13	55,000	11,500	13	H116
WDH2380	8.161	14.6	11.25	0.50	2.00	0.88	12.75	79,000	15,000	18	H480

Other chains available on a made-to-order basis. Contact Rexnord.

40 **Note: Dimensions are subject to change. Certified dimensions of ordered material are furnished upon request.**

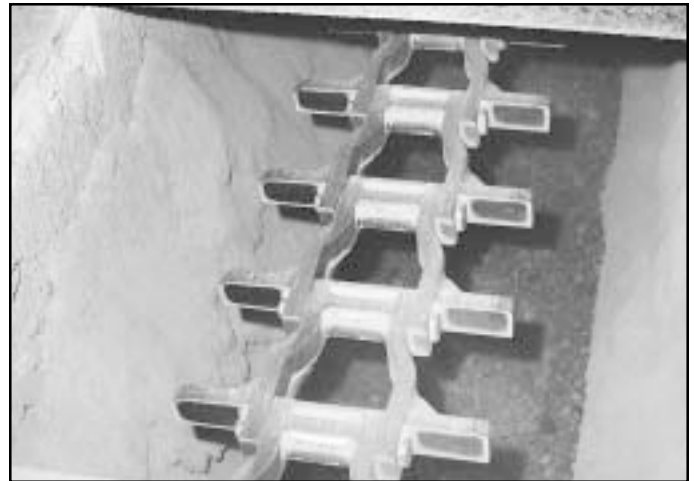
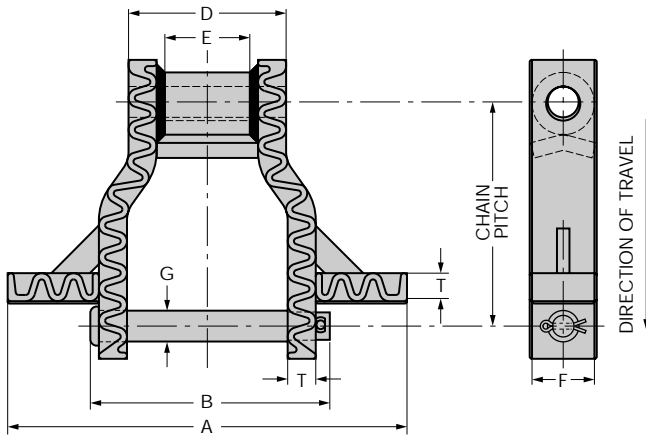
WELDED STEEL CHAINS

HEAVY DUTY WELDED STEEL DRAG CHAINS

Rex® Heavy Duty drag chains are ideal for conditions where severe abrasion and heat exist. They offer these important features and benefits:

- **Hardface welding** on both of the chain's sliding surfaces is standard. A typical weld hardness of 60 RC and a heavy weld bead give this chain excellent sliding wear resistance in cold and hot clinker applications.
- **Interference fits** between the pin and chain sidebar dramatically improves chain strength and joint wear life over that of a cast drag chain. In addition, no loose pins to move around in the chain joint.

- **An induction hardened pin** affords the best of two worlds – a 60 RC typical hardened case and impact resistant material in the core of the pin. The result is longer service life and good resistance to shock loads.
- **Square edges on the wing and sidebar** of welded drag chain convey more efficiently than rounded cast chain edges. They also move a deeper bed of material with each revolution of the chain.
- **Heat treated and fabricated steel components** eliminate the failures that cast chains experience from casting porosity and inclusions.



WHX Drag Chains offer solutions to wear and breakage problems common with cast chains. Fabricated steel construction with heat treated pins, barrels, face plates, wings, and sidebars provide added protection not found in cast chain designs.

WELDED STEEL CHAINS

TH Thru-Hardened
 CIH Circumferentially Induction Hardened
 SIH Selectively Induction Hardened

Dimensions are in inches. Strengths, loads and weights are in pounds.

Rex Chain No.	Average Pitch	A	Sidebars			Pins			Barrel Length		Minimum Ultimate Strength, Lbs. x 10 ³	Rated Working Load	Sprocket Unit No.
			Thickness	Height	Heat Treat	B	G	Heat Treat	D	E			
			T	F									
WHX5157	6.050	8 to 14 inches 2 inch increments	0.63	2.5	TH	6.94	1.13	SIH	4.63	2.75	117,000	18,200	5157 [Ⓜ]
WHX6067	9.000	10 to 26 inches 2 inch increments	0.75	2.5	TH	8.19	1.25	CIH	5.5	3.63	195,000	24,300	6121 [Ⓜ]
WHX5121 [Ⓜ]	9.000	10 to 30 inches 2 inch increments	1.13	2.5	TH	9.75	1.25	CIH	6.31	3.63	205,000	27,600	6121 [Ⓜ]
WHX6121	9.000	10 to 30 inches 2 inch increments	1.13	2.5	TH	9.75	1.25	CIH	6.31	3.63	205,000	27,600	6121 [Ⓜ]

[Ⓜ] WHX5121 is dimensionally the same as WHX6121 except it runs closed end forward.

[Ⓜ] Octagonal tail wheels are available. The octagonal design reduces the scrubbing which reduces traditional tail sprocket life. See page 108.

Note: Dimensions are subject to change. Certified dimensions of ordered material are furnished upon request.

WELDED STEEL CHAINS

ATTACHMENT WELDING INSTRUCTIONS

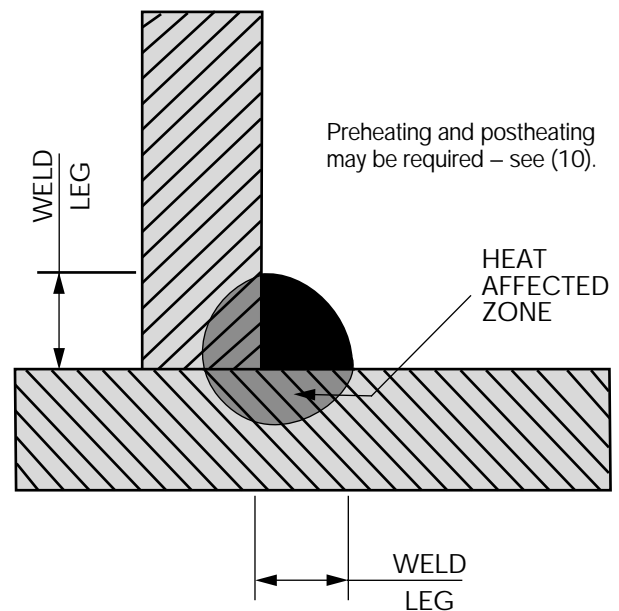
- 1 Surfaces to be welded should be clean and free of foreign material. It is not necessary to remove the pre-lubricant before welding, however, proper ventilation is mandatory.
- 2 Weld strength should be sufficiently high to cause failure of the parent metal and not of the weld itself.
- 3 Welds should be free of cracks, undercutting, slag, inclusions, and excessive porosity. Craters due to stop welding should be located away from corners and edges; most craters contain slight cracks which can initiate failures at high stress areas.
- 4 Weld beads should be free of pinholes, have uniformly fine surface ripples, and have little or no indication of where a new piece of filler metal was started.
- 5 Weld edges should indicate complete fusion without overlap or undercut.
- 6 Welds should be clean, free of spatter, slag, excessive oxides, and arc scars.
- 7 Arcs should be struck on attachments, not on the sidebars. Arc scars on sidebars can produce early chain failure.
- 8 Convex shaped weld beads are preferred. Convex fillet welds are strong and less subject to cracking than concave forms.
- 9 Electrode selection is very important. An electrode that has been successfully used is E7018 (70,000 psi tensile strength, low hydrogen). This rod is for all position use, AC or DC. Good welding practice dictates that electrodes be stored in a dry atmosphere or baked prior to use. Specific electrode manufacturer recommendations should be closely followed.
- 10 Preheating and Postheating – Heat applied to the weld heat affected zone is always beneficial. These processes, while not generally required for small attachments, are recommended for large or heavily loaded attachments such as Styles “A” & “C” log cradles. No welding should be performed on parts below 70°F.

Heating is usually done by use of a neutral flame to heat the parts prior to or after welding.

Preheat: Performed to reduce possibility of weld cracking both surface and subsurface. Parts to be welded – link and attachment – should be heated uniformly to 300°F.

Postheat: Performed to relieve internal stresses and to reduce weld zone hardness. Heat affected zone of weld heated to 700°F.

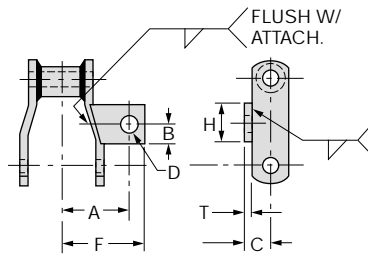
- 11 Tack welds should never be used in areas that will not be welded in the finished product.



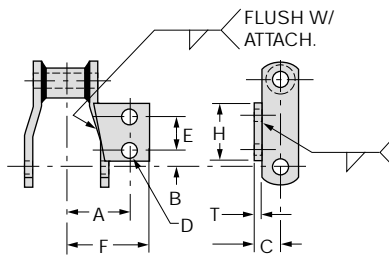
CAUTION

No welding should be performed on or immediately adjacent to an induction hardened or carburized part. Welding to an induction hardened part can produce tempering and softening of this hard surface. Welding attachments to the carbon rich surface of a carburized part will result in brittle welds and possible cracking.

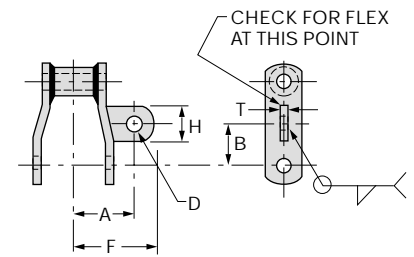
WELDED STEEL CHAINS – Attachments



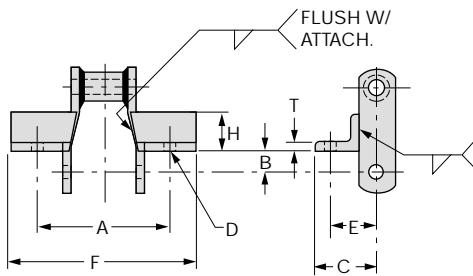
A1



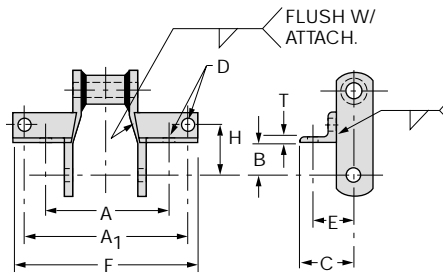
A2, A25^②



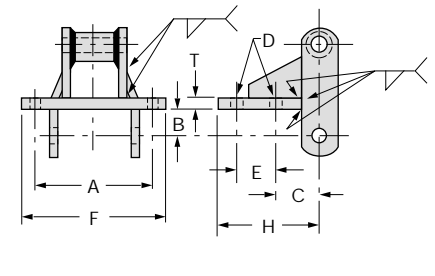
A22



F2



F4



F26, F28

Dimensions are in inches. Weights are in pounds.

Chain Number	A	B	C	D ^①		E	F	H	T	Average Weight per Ft.
				Bolt Dia.	Bolt Hole					
A1										
WH78	2.00	1.25	0.81	3/8	.41	–	2.50	1.25	0.25	5
WH82	2.09	1.50	0.88	3/8	.41	–	2.75	1.75	0.25	6
A2 & A25^②										
WH78	2.00	0.41	0.81	3/8	.41	1.13	2.50	2.00	0.25	5
WH82	2.13	0.75	0.88	3/8	.41	1.31	2.69	2.25	0.25	7
WHX124	2.63	0.88	1.13	3/8	.41	1.94	3.19	3.00	0.38	10
WHX124HD	2.63	0.94	1.50	1/2	.56	1.94	3.19	3.06	0.50	16
WHX111	3.13	1.22	1.13	1/2	.56	2.31	3.75	3.50	0.38	10
WHX132 ^③	3.75	1.63	1.50	1/2	.56	2.75	4.59	4.25	0.50	16
WHX150	3.75	1.63	1.75	1/2	.56	2.75	4.59	4.19	0.50	19
WHX155	3.75	1.63	1.81	1/2	.56	2.75	4.59	4.19	0.56	22
WHX157	4.00	1.75	1.88	1/2	.56	2.50	4.78	4.00	0.63	22
WHX159	4.00	1.69	2.13	1/2	.56	2.75	4.78	4.25	0.63	30
A22										
WH78	1.88	1.31	–	3/8	.41	–	2.50	1.00	0.38	5
F2										
WH78	3.75	0.56	2.31	3/8	.41	1.44	4.69	1.25	0.25	6
F4										
WH78	3.75 ^③	0.69	2.31	3/8	.41	1.75	5.50	1.94	0.25	8
WH82	4.13 ^③	0.81	2.38	3/8	.41	1.81	5.94	1.94	0.25	9
WHX124	4.38 ^③	0.88	3.06	3/8	.41	2.06	6.19	2.30	0.38	12
F26										
WH720CS	3.75	3.00	2.38	3/8	.41	2.63	5.00	6.78	0.25	8
F28										
WH720CS	3.75	3.00	2.38	3/8	.41	4.50	5.00	8.97	0.25	9

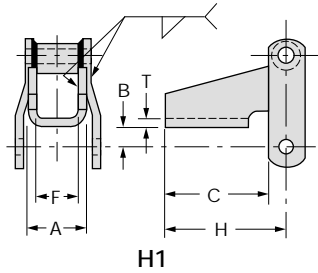
^① All holes round and straight.

^② A25 attachment is for WHX132.

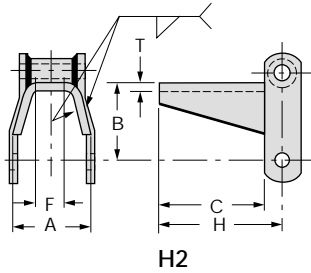
^③ A1 is 4.50 for WH78, 5.00 for WH82 and 5.25 for WHX124.

Note: Dimensions are subject to change. Certified dimensions of ordered material are furnished upon request.

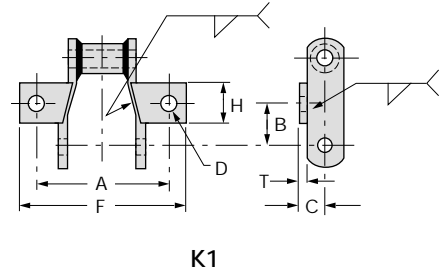
WELDED STEEL CHAINS – Attachments



H1



H2



K1

Dimensions are in inches. Weights are in pounds.

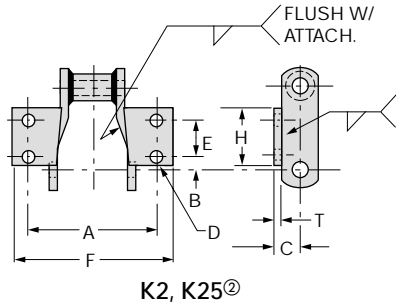
Chain Number	A	B	C	D ^①		E	F	H	T	Average Weight per Ft.
				Bolt Dia.	Bolt Hole					
H1										
WH78	1.75	0.50	3.06	–	–	–	0.88	3.63	0.25	8
WH82	2.00	0.63	3.00	–	–	–	1.13	3.63	0.25	10
H2										
WH78	2.94	2.38	3.00	–	–	–	1.00	3.56	0.25	8
WH82	2.56	2.69	3.00	–	–	–	1.00	3.63	0.25	9
K1										
WH78	4.00	1.25	0.81	3/8	.41	–	5.00	1.25	0.25	6
WH82	4.19	1.50	0.88	3/8	.41	–	5.50	1.75	0.25	7
K2 & K25^②										
WH78	4.00	0.41	0.81	3/8	.41	1.13	5.00	2.00	0.25	6
WH82	4.25	0.75	0.88	3/8	.41	1.31	5.38	2.25	0.25	8
WH110	5.31	2.13	1.13	3/8	.41	1.75	6.50	3.00	0.38	8
WHX111	6.25	1.22	1.13	1/2	.56	2.31	7.50	3.50	0.38	12
WHX124	5.25	0.88	1.13	3/8	.41	1.94	6.38	3.00	0.38	12
WHX124HD	5.25	0.94	1.50	1/2	.56	1.94	6.38	3.06	0.50	18
WHX132 ^②	7.50	1.63	1.50	1/2	.56	2.75	9.19	4.25	0.50	19
WHX150	7.50	1.63	1.75	1/2	.56	2.75	9.19	4.19	0.50	22
WHX155	7.50	1.63	1.81	1/2	.56	2.75	9.19	4.19	0.56	25
WHX157	8.00	1.75	1.88	1/2	.56	2.50	9.56	4.00	0.63	26
WHX159	8.00	1.69	2.13	1/2	.56	2.75	9.56	4.25	0.63	35

① All holes round and straight.

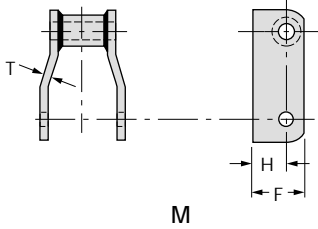
② K25 attachment is for WHX132.

Dimensions are in inches. Weights are in pounds.

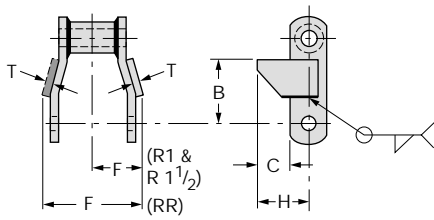
Chain Number	A	B	C	Bolt Diameter Required	E	F	H	T	Average Weight per Ft.
				D					
M									
WHX132	–	–	–	–	–	3.00	2.00	0.50	18
WHX157	–	–	–	–	–	3.50	2.25	0.63	26
WHX159	–	–	–	–	–	4.00	2.50	0.63	35
R1									
WH78	–	1.88	1.00	–	–	1.50	1.56	0.25	5
WH82	–	2.18	1.25	–	–	1.63	1.88	0.25	6
WHX124	–	2.72	1.13	–	–	2.16	1.88	0.38	9
R1^{1/2}									
WH78	–	1.88	1.50	–	–	1.50	2.06	0.25	5
RR									
WH78	–	1.88	1.00	–	–	3.00	1.56	0.25	5
WH82	–	2.19	1.25	–	–	3.25	1.88	0.25	7
WHX124	–	2.72	1.13	–	–	4.34	1.88	0.38	10
WHX124HD	–	2.72	1.13	–	–	5.13	2.13	0.50	18
R2									
WH78	–	0.69	1.00	–	–	1.50	1.56	0.25	5
WH82	–	0.88	1.25	–	–	1.63	1.88	0.25	6
WHX124	–	1.25	1.13	–	–	2.16	1.88	0.38	9
RR2									
WH78	–	0.69	1.00	–	–	3.00	1.56	0.25	5
WH82	–	0.88	1.25	–	–	3.25	1.88	0.25	7
WHX124	–	1.25	1.13	–	–	4.31	1.88	0.38	10
RF2									
WH78	–	1.50	2.13	–	–	3.00	2.69	0.63	10
WHX124	–	2.50	2.50	–	–	4.25	3.25	1.00	19
WHX124HD	–	2.50	2.50	–	–	4.75	3.50	1.00	25



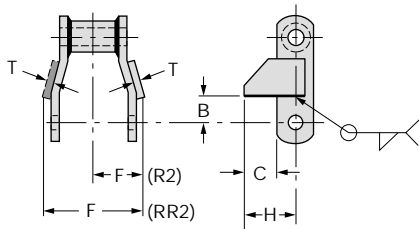
K2, K25^②



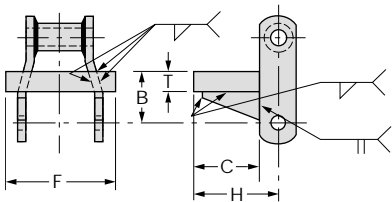
M



R1, R1^{1/2}, RR

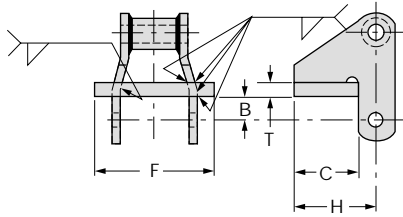


R2, RR2

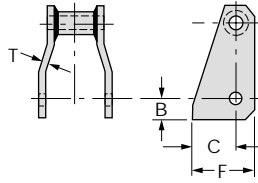


RF2

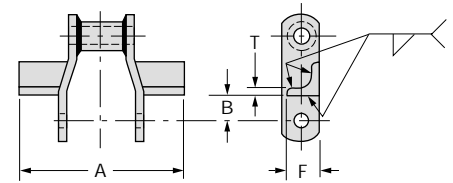
WELDED STEEL CHAINS – Attachments



RF121

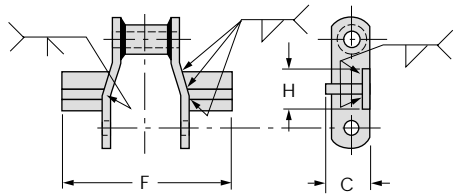


S1

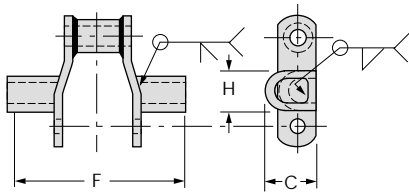


WING

Dimensions are in inches. Weights are in pounds.



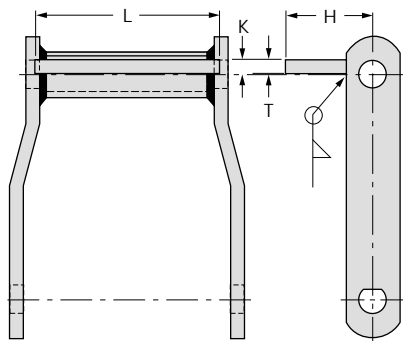
"A" STYLE



"C" STYLE

Chain Number	A	B	C	Bolt Diameter Required	E	F	H	T	Average Weight per Ft.
				D					
RF121									
WHX132	–	1.56	4.00	–	–	12.0	5.00	1.50	55
WHX150	–	1.56	4.00	–	–	12.0	5.25	1.50	57
WHX155	–	1.56	4.00	–	–	12.0	5.25	1.50	61
WHX157	–	1.50	4.00	–	–	12.0	5.25	1.50	63
WHX159	–	1.56	4.00	–	–	12.0	5.50	1.50	83
S1									
WHX132	–	1.16	5.00	–	–	6.00	–	0.50	25
WHX150	–	1.16	5.25	–	–	6.50	–	0.50	27
WHX155	–	1.50	5.25	–	–	6.50	–	0.56	31
WHX157	–	1.50	5.25	–	–	6.50	–	0.63	34
WHX159	–	1.88	5.25	–	–	6.75	–	0.63	46
WING									
WH78	6.00	0.75	–	–	–	1.00	–	0.25	7
WH82	6.50	0.94	–	–	–	1.25	–	0.25	9
WHX124	8.50	1.19	–	–	–	1.50	–	0.25	14
WHX124HD	8.50	1.38	–	–	–	2.00	–	0.38	19
WHX132	12.0	1.50	–	–	–	2.00	–	0.38	24
WH260	7.00	0.53	–	–	–	1.75	–	–	4
"A" STYLE CRADLE									
WHX132	–	–	3.00	–	–	11.0	3.00	–	22
WHX150	–	–	3.50	–	–	11.0	3.00	–	25
WHX155	–	–	3.50	–	–	11.0	3.00	–	28
WHX157	–	–	3.50	–	–	11.0	3.00	–	29
WHX159	–	–	4.00	–	–	11.0	3.00	–	39
"C" STYLE CRADLE									
WHX132	–	–	3.00	–	–	11.0	3.00	–	29
WHX150	–	–	3.00	–	–	11.0	3.00	–	31
WHX155	–	–	3.00	–	–	11.0	3.00	–	34
WHX157	–	–	3.00	–	–	11.5	3.00	–	35
WHX159	–	–	4.00	–	–	11.0	3.00	–	47

Dimensions are in inches. Weights are in pounds.

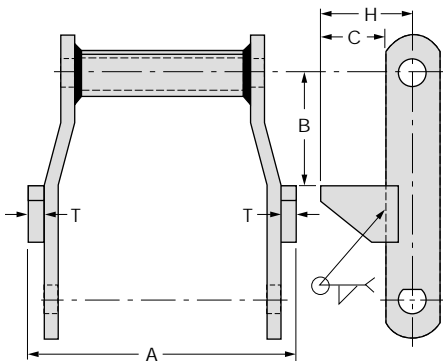


C1, C3, C4

Chain Number	H	K	L	T	Average Weight per Ft.
C1 – WIDE SERIES					
WD & WDH102	1.50	0.38	6.38	0.38	15
WD & WDH104	2.38	0.38	4.13	0.38	11
WD & WDH110	2.38	0.38	9.13	0.38	17
WD & WDH112	2.38	0.38	9.13	0.38	14
WD & WDH116	2.63	0.38	12.75	0.38	20
C3 – WIDE SERIES					
WD & WDH113	2.25	0.50	9.13	0.50	19
WD & WDH118	3.00	0.50	13.00	0.50	25
WD & WDH120	3.00	0.50	8.63	0.50	26
WD & WDH122	3.00	0.50	8.63	0.50	21
WD & WDH480	3.00	0.50	11.13	0.50	26
WDH580	3.00	0.50	11.13	0.50	26
C4 – WIDE SERIES					
WD & WDH102	3.75	0.38	6.38	0.38	18
WD & WDH104	3.75	0.38	4.13	0.38	12
WD & WDH110	3.75	0.38	9.13	0.38	21
WD & WDH112	3.75	0.38	9.13	0.38	17
WD & WDH113	4.75	0.50	9.13	0.50	28
WD & WDH116	4.88	0.38	12.75	0.38	25
WD & WDH480	5.00	0.50	11.13	0.50	33
WDH580	5.00	0.50	11.13	0.50	33

Note: Dimensions are subject to change. Certified dimensions of ordered material are furnished upon request.

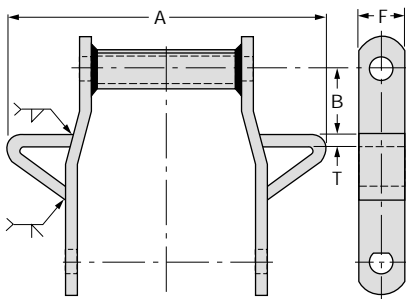
WELDED STEEL CHAINS – Attachments



RR

Dimensions are in inches. Weights are in pounds.

Chain Number	A	B	C	H	T	Average Weight per Ft.
RR – WIDE SERIES						
WD & WDH102	9.25	1.25	1.75	2.50	0.38	13
WD & WDH104	6.94	3.00	1.75	2.50	0.38	9
WD & WDH110	11.94	3.00	1.75	2.50	0.38	14
WD & WDH112	11.94	3.00	1.75	2.50	0.38	12
WD & WDH113	12.69	3.00	1.75	2.50	0.50	16
WD & WDH116	15.69	3.00	2.25	3.13	0.38	17
WD & WDH118	16.94	3.00	2.25	3.25	0.50	22
WD & WDH120	12.34	3.00	2.25	3.25	0.50	23
WD & WDH122	12.34	3.00	2.25	3.25	0.50	19
WD & WDH480	14.88	3.00	2.25	3.25	0.50	21
WDH580	14.88	3.00	2.25	3.25	0.50	21
WDH2210	12.09	3.00	–	2.50	0.38	13
WDH2316	15.91	3.00	–	3.00	0.38	16
WDH2380	14.78	3.00	–	3.25	0.50	21



WING (Wide)

Dimensions are in inches. Weights are in pounds.

Chain Number	A	B	F	T	Average Weight per Ft.
WING – WIDE SERIES					
WD & WDH102	14.38	1.75	1.50	0.38	15
WD & WDH104	11.50	2.75	1.50	0.38	11
WD & WDH110	17.00	2.63	1.50	0.38	16
WD & WDH112	17.00	3.25	1.50	0.38	13
WD & WDH113	17.00	2.50	1.50	0.50	17
WD & WDH116	22.00	3.25	1.75	0.38	18
WD & WDH120	17.00	3.25	2.00	0.50	28
WD & WDH122	17.00	3.25	2.00	0.50	24
WD & WDH480	22.00	3.25	2.00	0.50	25
WDH580	22.00	3.25	2.00	0.50	25
WDH2210	17.00	2.25	1.50	0.38	16
WDH2316	22.00	3.25	1.75	0.38	18
WDH2380	22.00	3.25	2.00	0.38	26