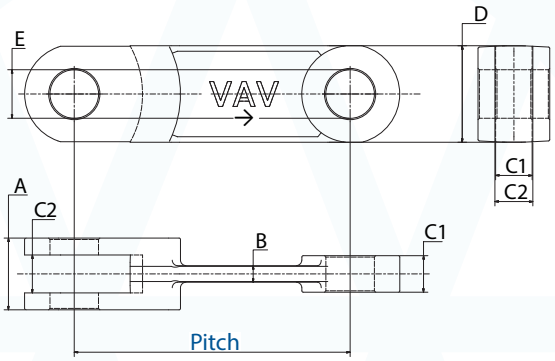


Drop forged chain

The drop forged chains supplied by VAV are made of heat treated high grade alloy steel. The links can be equipped with plastic flights and/or steel scrapers. The following table shows various types of drop forged chains ex stock, together with the respective breaking loads and core/surface hardness.

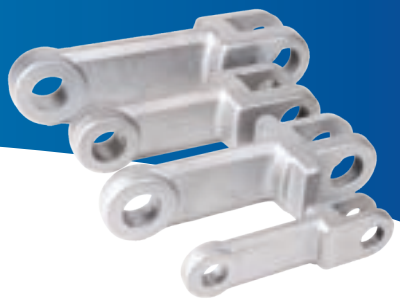






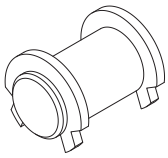
Drop forged chain (parameters in mm)								
Pitch	A	B	C1	C2	D	E	Breaking loads available ex stock	
							58 HRC Case hardened	Q&T 40 HRC
102	32	10	14	15	36	18	150 kN	
102	27	11	12	13	36	16		170 kN
102	30	8	13	13,5	36	14		140 kN
102	24	6	8	9	36	14	100 kN	
125	36	10	15	16	36	16		140 kN
142	42	13	19	20	50	25	250 kN	350 kN
142	54	16	25	26	50	25	300 kN	380 kN
142	62	15	29	30	50	25	350 kN	600 kN
150	36	13	15	16	50	25		200 kN
150	36	13	15	16	50	25		300 kN
150	36	13	15	16	50	25		400 kN
160	42	13	20	21	46	20		300 kN
160	50	14	25	26	50	25	300 kN	380 kN
175	62	15	29	30	50	25		600 kN
200	68	18	30	31	60	30	500 kN	
200	70	24	30	31	60	30		700 kN
250	70	20	30	33	70	32		750 kN
260	70	20	30	33	70	32	600 kN	

Materials: 20MnCr5, 42CrM04, Stainless steel 304/316, 1.4713. The breaking load depends on the choice of material.

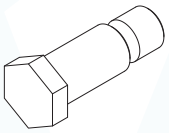


Pins

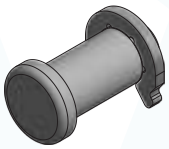
Pins are available in different executions and the following materials:
16MnCr5, 42CrMo4i, 1.4034i, 1.4122i, 1.4462, 1.4713. Other materials are available on request.



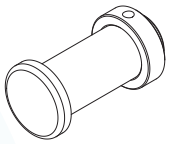
Circlips



hex pin with thread



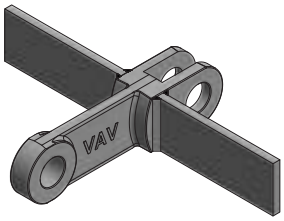
Head pin with circlips



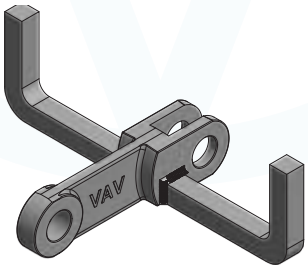
Head pin with
collar and dowel pin

Examples of drop forged chain with scrapers

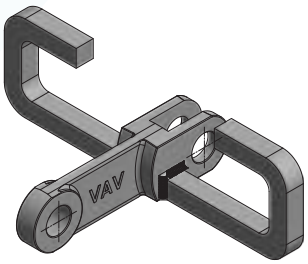
VAV can supply all kinds of scrapers. Whether it is horizontal, inclined or vertical transport, there is a special version for every type of transport and a solution for every capacity. Below you will find a number of examples of steel scrapers and plastic flights.



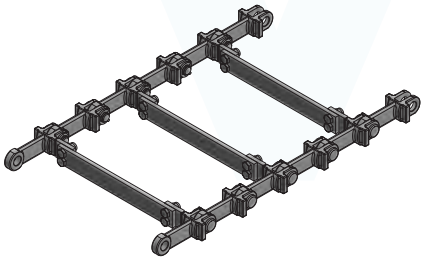
Horizontal transport



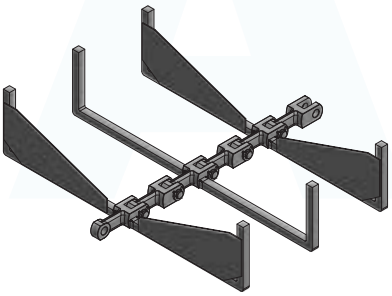
"U" scraper for
inclined transport



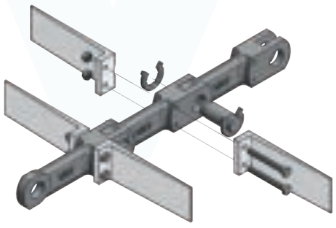
"O" scraper
for vertical transport



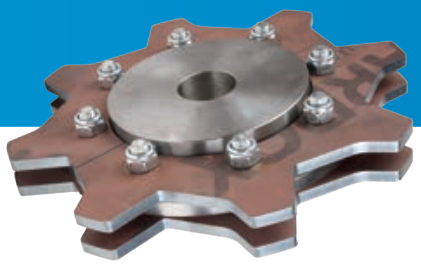
Double drop forged chain scraper



"U" scraper with welded plates



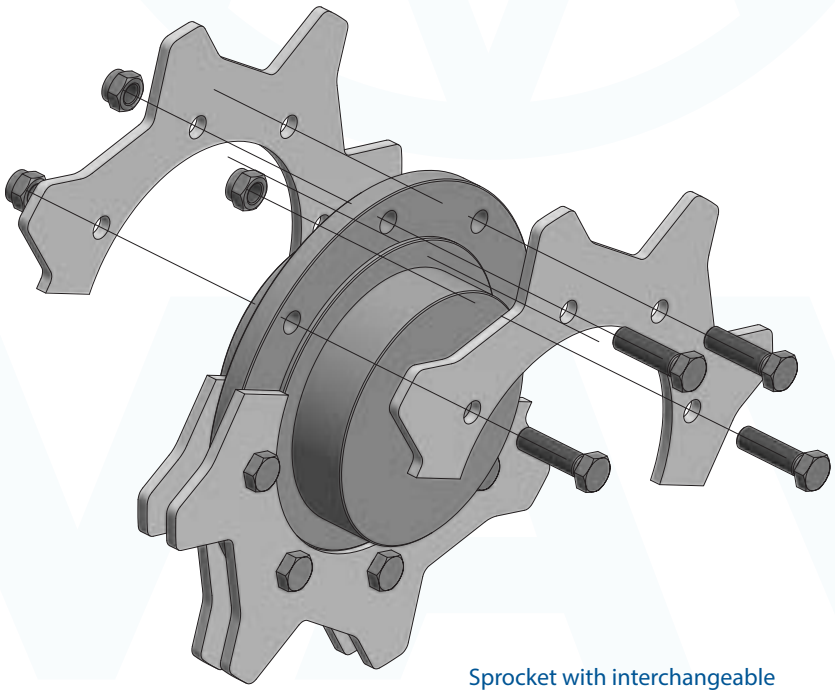
Easy to (dis)assemble
plastic flights



Sprockets for drop forged chain

Sprockets for drop forged chain consist of a body with symmetrical hub and interchangeable teeth segments. This has the advantage that, when the sprockets wear out, only the wear-resistant teeth segments need to be replaced. Sprockets can be made to your specifications on request. The following versions are available ex stock.

Sprockets for drop forged chain available ex stock (parameters in mm)					
Pitch	Pitch Ø / number of segments per complete set				
	6 teeth	7 teeth	8 teeth	9 teeth	10 teeth
102	Ø 204,00 / 4	Ø 235,09 / 4	Ø 265,49 / 4	Ø 298,23 / 4	Ø 330,08 / 4
125	Ø 250,00 / 4	Ø 288,10 / 4	Ø 326,64 / 4	Ø 365,48 / 4	Ø 404,51 / 4
142	Ø 284,00 / 4	Ø 327,28 / 4	Ø 371,06 / 8	Ø 415,18 / 6	Ø 459,52 / 4
150	Ø 300,00 / 6	Ø 345,71 / 4	Ø 391,97 / 8	Ø 438,57 / 4	Ø 485,42 / 10
160	Ø 320,00 / 4	Ø 368,76 / 4	Ø 418,10 / 8	Ø 467,81 / 4	Ø 517,77 / 4
200	Ø 400,00 / 4	Ø 460,95 / 4	Ø 522,62 / 8	Ø 584,76 / 4	Ø 647,21 / 4



Sprocket with interchangeable teeth segments (8 teeth)