



CONVEYOR CHAINS

FOR DEMANDING APPLICATIONS

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THE LEADING EUROPEAN MANUFACTURER OF HEAVY- DUTY WELDED CHAINS

Ketjurauma manufactures riveted and welded conveyor chains, paper roll chains and chain sprockets. The quality of Ketjurauma's conveyor chains has made a name for the company on every continent.

Ketjurauma's conveyor chains are manufactured at the company's modern facility in Rauma, Finland, on cutting edge automated production lines.

Ketjurauma's production lines and equipment have been developed to fulfill today's standards and to minimise downtime, thus ensuring maximum capacity and quality of service. Conveyor chains are assembled automatically and the finished product is made without temporary storage of components between production stages. Production procedures, such as bevelling, take place immediately before assembly; this ensures that the parts to be welded are clean and an optimal weld is achieved.

Chains are treated with a protective grease coating immediately after welding, and the product is then automatically loaded onto a pallet.

The side plates of **Ketjurauma's** conveyor chains are made from high quality structural steel, to which the necessary brackets or attachments can reliably be welded without the need for pre- or post-heating. If the side plates' durability needs to be further increased, the edges of the plates can be induction hardened. Induction hardening does not affect the plate pitch or the fittings in the plates.

The pins and bushings are manufactured using low carbon weldable mild steel. In order to achieve the best possible durability, pins and bushings are case hardened, the bushings also on their inside surface. Ketjurauma also manufactures conveyor chains for stainless and acid-proof steel joints.

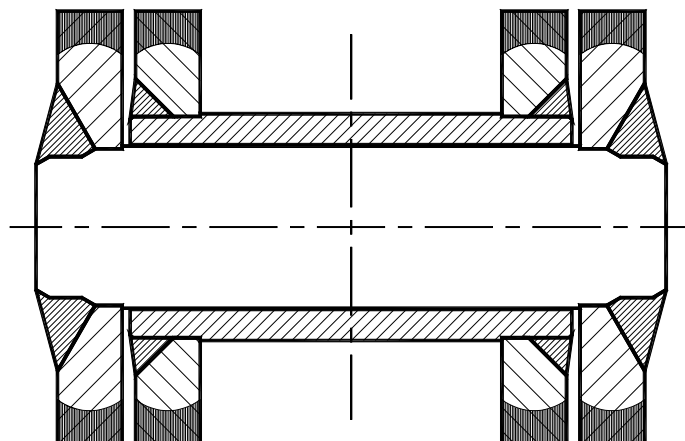
The pins and bushing feature shoulders to avoid unnecessary sideways movement. The clearance between the pins and the bushings is taken into account in the pitch of the outer plates, meaning that the chain's inner and outer links match its nominal pitch.

Ketjurauma's riveted chains are lubricated at the joints automatically during assembly. Welded chains are automatically lubricated after welding, by immersion in lubricant. Chain is also available with lubrication holes, whereby the joints are lubricated with special lubricant via a lubrication hole in either the pin or the bushing.

Ketjurauma's staff works closely with customers and monitors the condition of chains in the field. Regular measuring of chain stretch enables continuous improvement in materials and treatment processes.

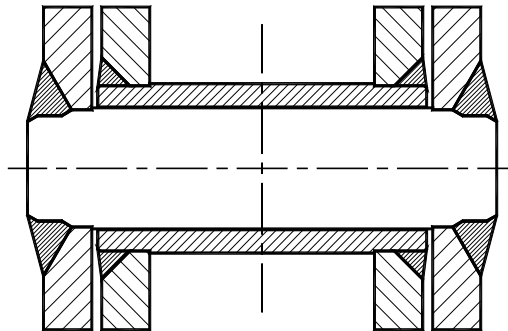


CHAIN M160 – M630 and A18 – A65

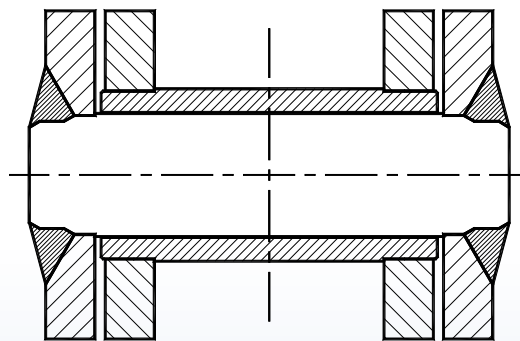


STRUCTURE

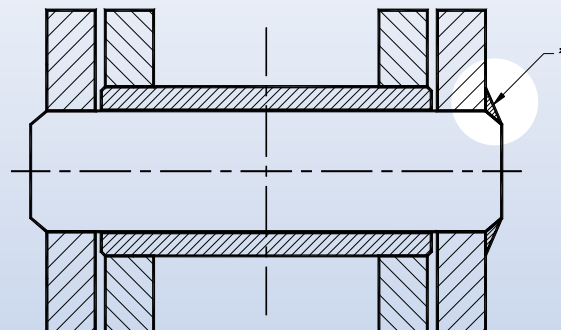
CHAIN M224 – M630 and A18 – A65

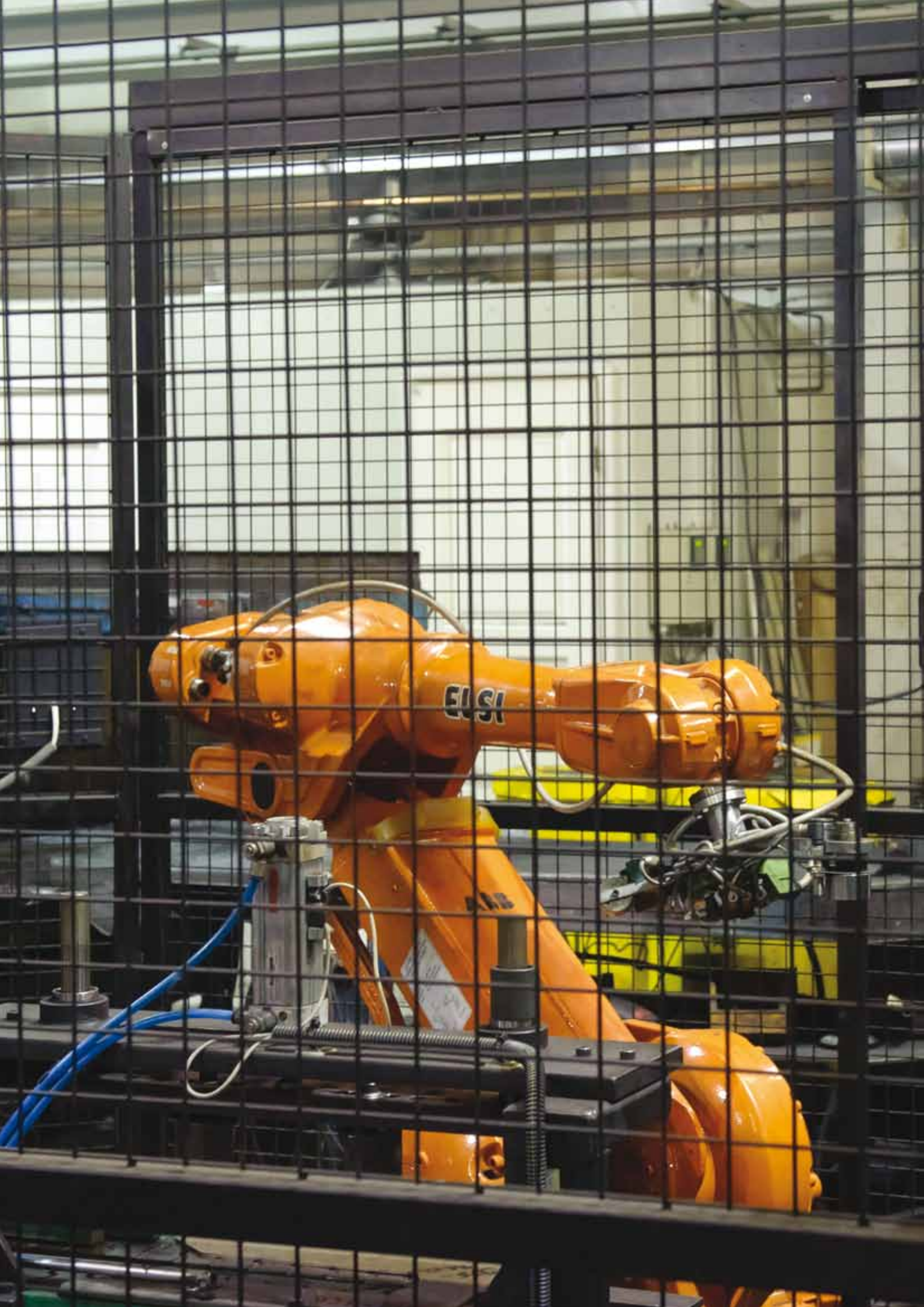


CHAIN M160 and A12,5



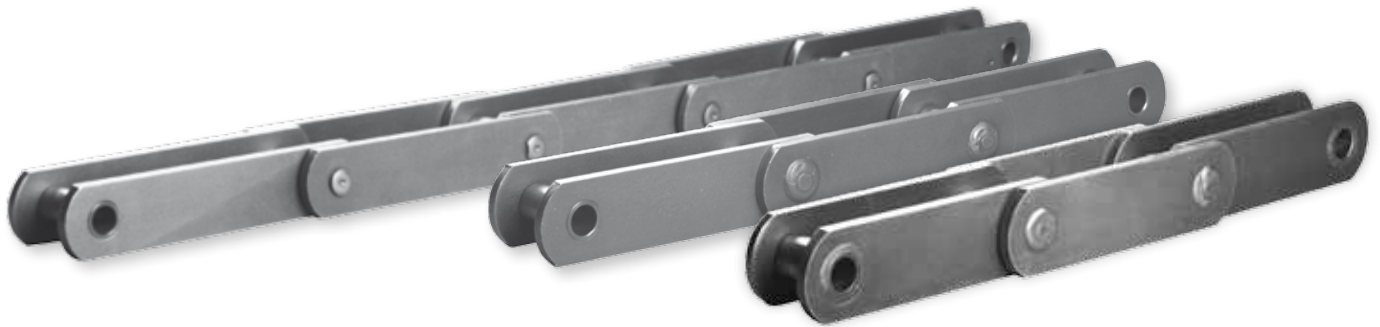
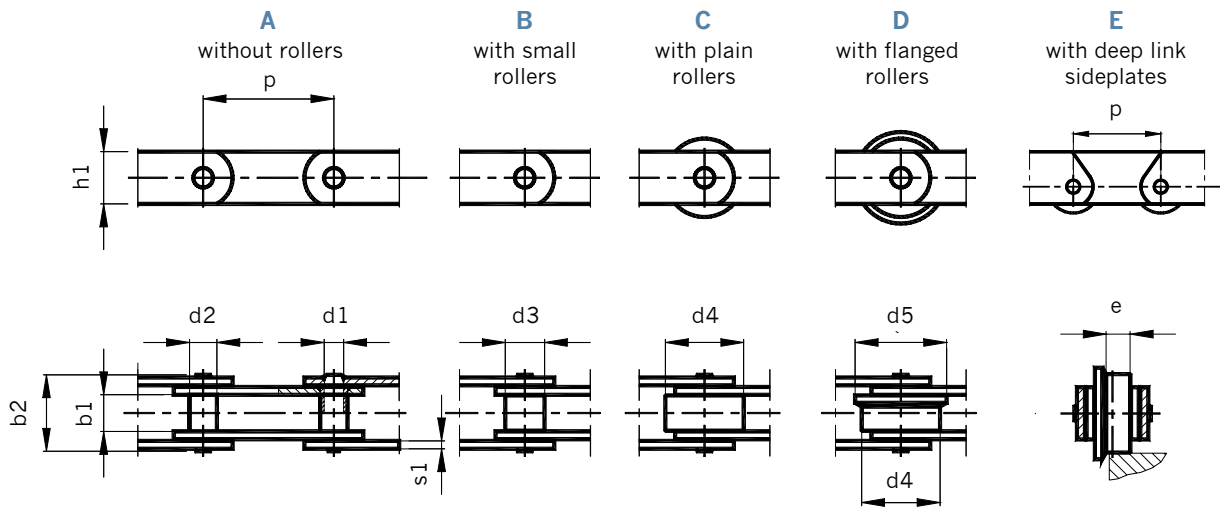
M80 – M112 and A5,5 – A8,5 (*Also available with welded pins)





CONVEYOR CHAIN

SFS 2380

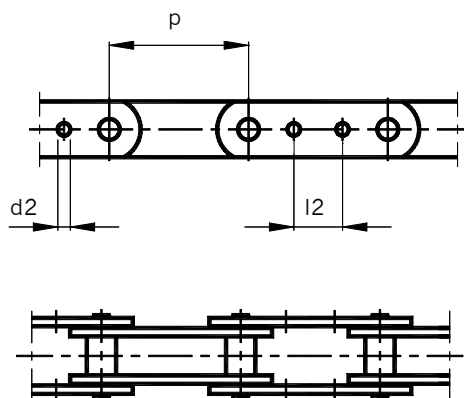


Chain no.	Breaking load kN	Pitch p	Inner width b1	Pin d1	Bush d2	Side plates A/E h1	Side plates s1	Small roller B d3	Plain roller C d4	Flanged roller D d5	Roller width e	Outer width b2
M80	80	80 100 125 160	28	12	18	35/50	5	25	50	60	20	55
M112	112	80 100 125 160	32	15	21	40/60	6	30	60	70	22	64
M160	180	100 125 160	37	18	25	50/70	7	36	70	85	25,5	73
M224	350	125 160 200	43	21	30	60/90	8	42	85	100	30	85
M315	500	160 200	48	25	36	70	10	50	100	120	33	99
M450	700	200 250	56	30	42	80	12	60	120	140	37	117
M630	900	200 250 315	66	36	50	100	14	70	140	170	45	136

Subscription to order: Conveyor chain no - type - pitch
Eg. Conveyor chain M450 - A - 250

ATTACHMENT HOLES R2

SFS 2380



R2, R22



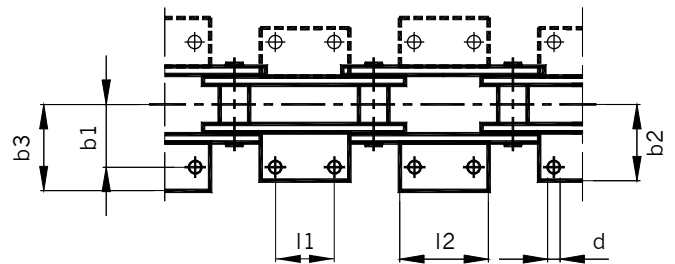
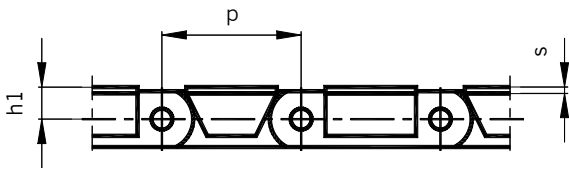
Chain no.	Breaking load kN	Pitch p	d2	l2
M80	80	80 100 125 160	9	30
M112	112	80 100 125 160	11	35
M160	180	100 125 160	11	40
M224	350	125 160 200	14/18	50/70
M315	500	160 200	14/18	60/70
M450	700	200 250	18	70
M630	900	200 250 315	18	100

Standard: direct hole.

Subscription to order: Conveyor chain, chain no. - type / hole type x pitch, location
Eg. Conveyor chain M450-A-200 / R2 x 400, in outer links

ATTACHMENTS K2 K22

SFS 2380



K2 Attachments on one side of the chain

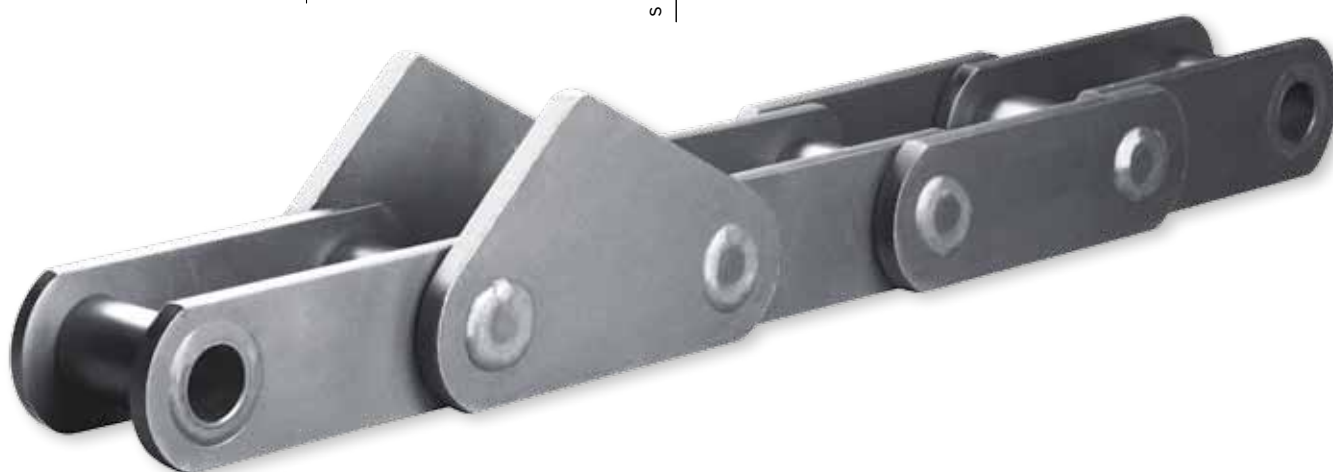
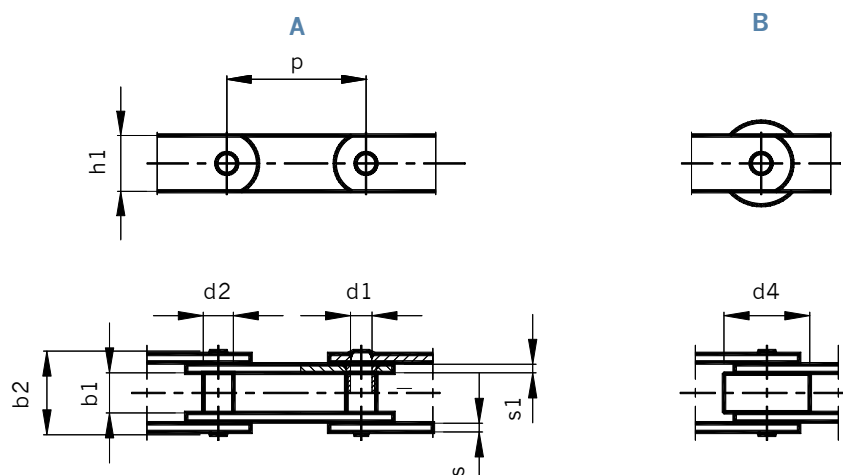
K22 Attachments on both sides of the chain

Chain no.	Breaking load kN	Pitch p	l1	l2	d	h1	b1	b2	b3	s	Weight kg/each
M80	80	80 100 125 160	50	75	11	22	48	59	65	4	0,18
M112	112	80 100 125 160	35	60	14	25	55	72	79	5	0,20
M160	180	100 125 160	50	80	14	30	62	76	84	6	0,36
M224	350	125 160 200	65	105	18	35	70	90	99	8	0,73
M315	500	160 200	50	90	18	41	80	99	111	9	1,06
M450	700	200 250	85	130	18	46	90	110	124	10	1,23
M630	900	200 250 315	100	150	24	58	115	147	164	12	2,25

Subscription to order: Conveyor chain, chain no. - type / type of attachments x pitch, location
Eg. Conveyor chain M450-A-200 / K2 x 500, in outer links

CONVEYOR CHAIN

SMS 1698

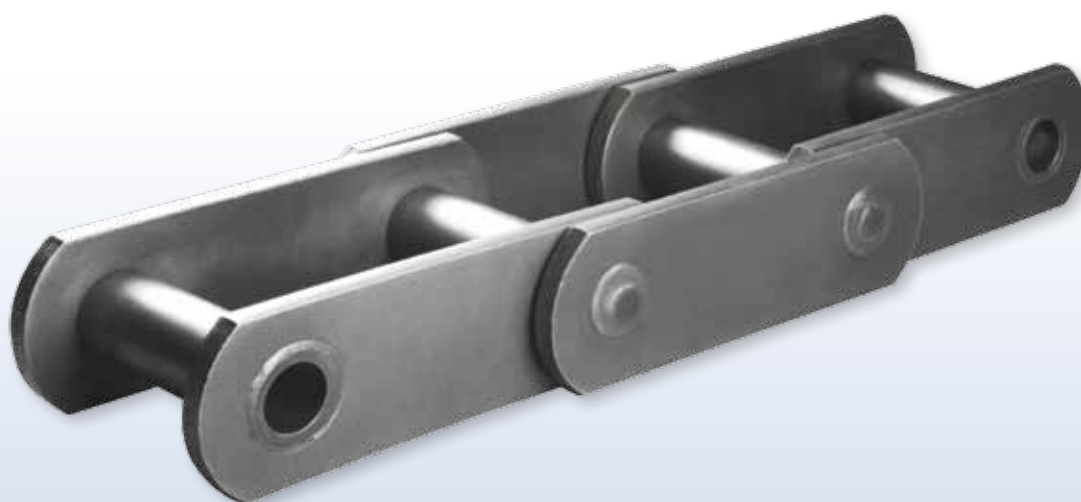
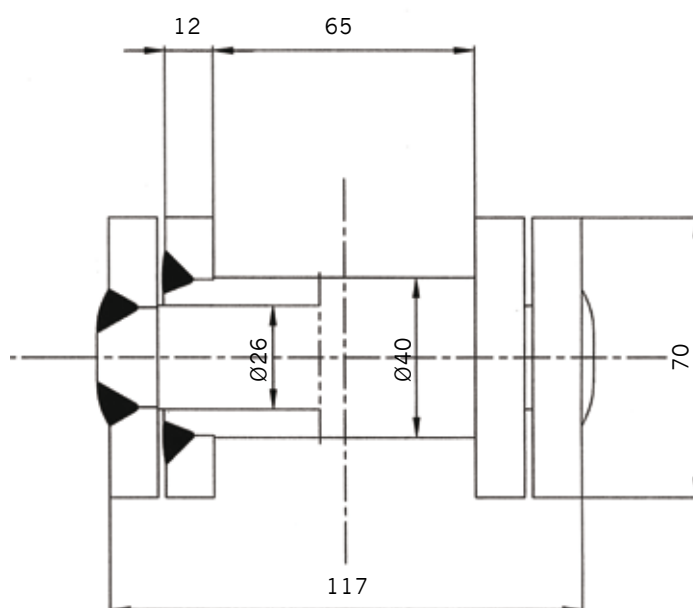


Chain no.	Breaking load kN	Pitch p	Inner width b1	Pin d1	Bush d2	Side plates h1	Side plates s1	Side plates s	Side plates s, Grov	Plain roller d3	Outer width b2
A5,5	55	63 80 100	22	12	18	30	5	4	6	40	50
A8,5	85	80 100 150	25	14	20	35	6	5	8	50	59
A12,5	125	100 150	35	18	25	40	8	6	8	60	75
A18	240	150 200	45	20	30	50	8	6	10	70	91
A24	350	150 200 250	55	26	36	60	10	8	12	80	110
A30	400	150 200 250	65	30	42	70	10	8	12	90	121
A40	520	200 250	80	36	50	80	12	10	12	110	142
A65	800	200 250	80	36	50	90	15		15	110	154

Subscription to order: Conveyor chain, chain no. - type x pitch
Eg. Conveyor chain A18 x 150 Grov

CONVEYOR CHAINS

PK500



Chain no.	Breaking load kN	Pitch p	Inner width b1	Pin d1	Bush d2	Side plate h1	Side plate s1	Small roller B d3	Outer width b2
PK 500	500	160 200	65	26	40	70	12	55	124

P50A200 replace PK500A200

P35A200 replace A24x200

Subscription to order: Conveyor chain, chain no. - type - pitch
Eg. Conveyor chain, PK500 - A - 200

CONVEYOR CHAINS

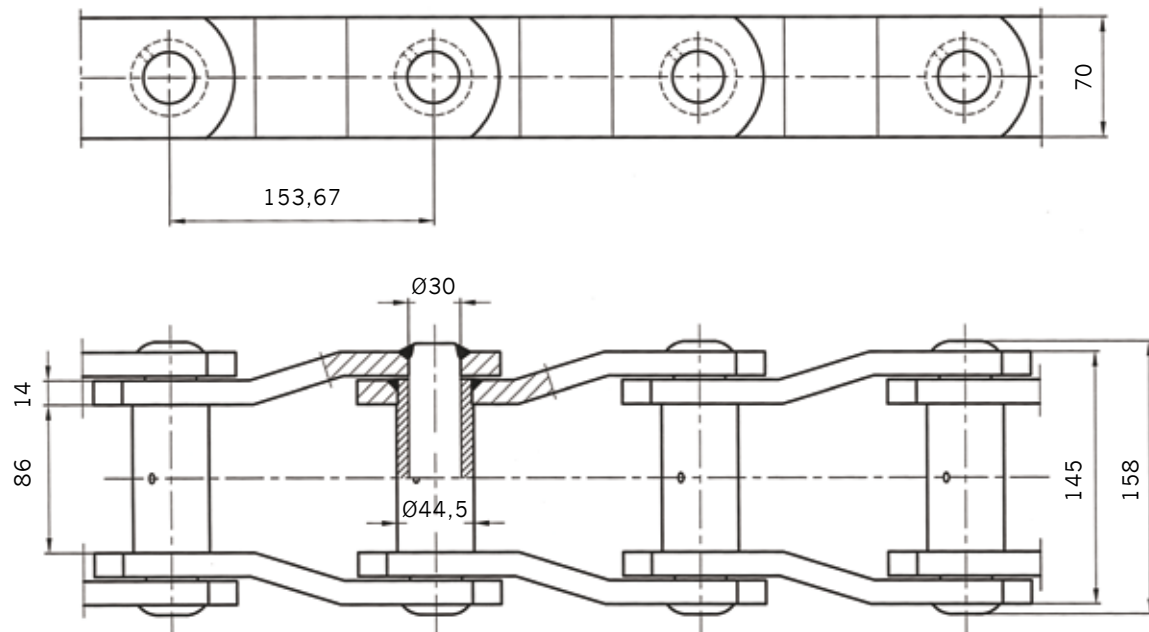
Weight kg/m

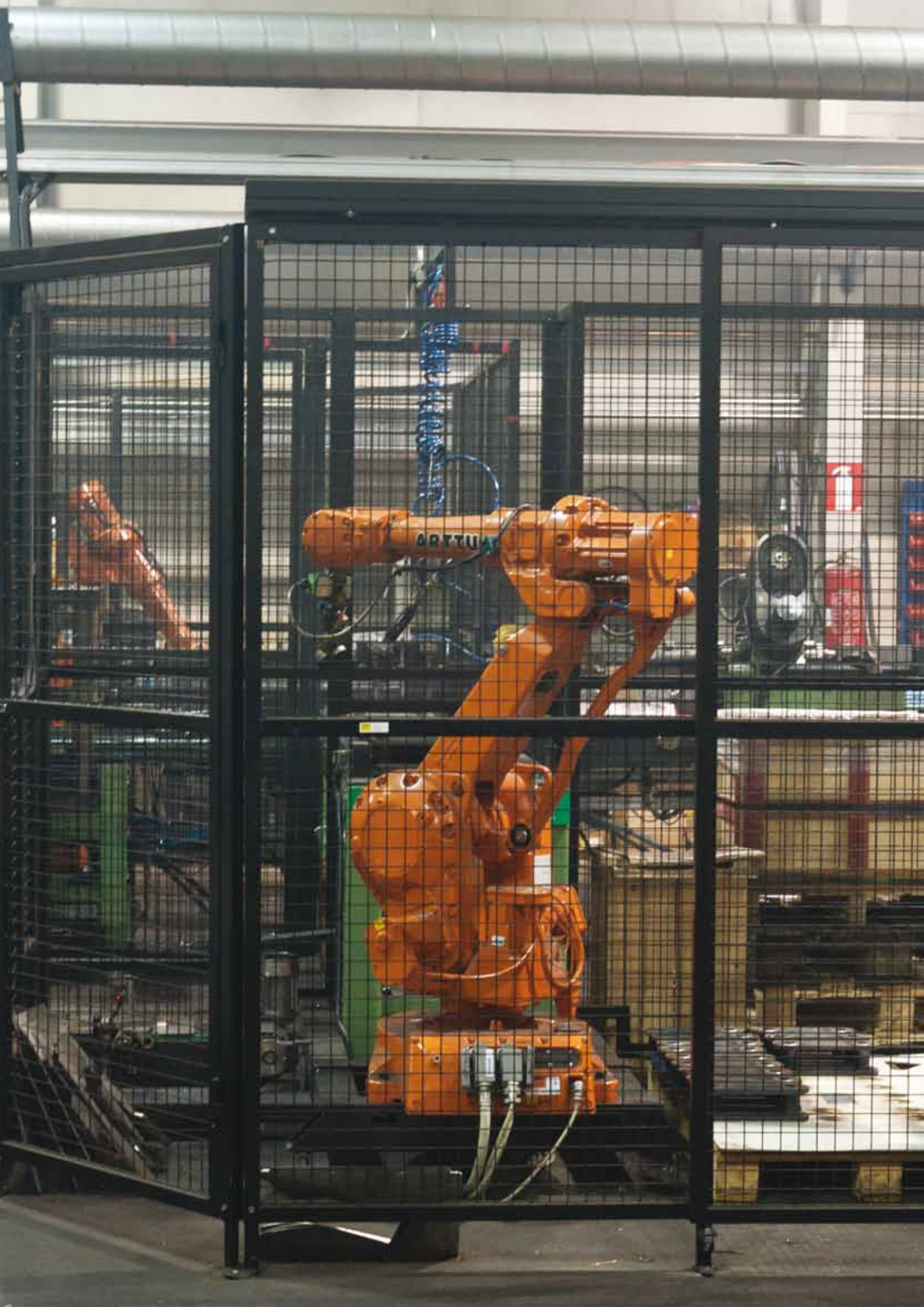
Chain no. SFS2380	Pitch p	A	B	C	D	E	Chain no. SMS1698	Pitch	A	A Grov	B	B Grov
M80	80 100 125 160	4,5 4,2 3,9 3,7	5,2 4,7 4,3 4,0	9,0 7,8 6,8 5,9	9,5 8,1 7,1 6,1	10,3 9,1 8,0 7,1	A5,5	63 80 100	4,0 3,6 3,4	4,6 4,2 4,0	5,0	5,6
M112	80 100 125 160	6,7 6,1 5,6 5,2	7,7 6,9 6,3 5,8	14,0 11,9 10,3 8,9	14,6 12,4 10,7 9,2	16,0 14,0 12,3 10,9	A8,5	80 100 150	5,2 4,8 4,2	6,4 5,8 5,2	8,0 6,4	9,0 7,4
M160	100 125 160	9,5 8,7 8,0	10,9 9,9 8,9	18,7 16,1 13,8	19,4 16,6 14,2	19,7 17,3 16,1	A12,5	100 150	7,8 6,6	8,6 7,4	11,4	12,2
M224	125 160 200	12,8 11,6 10,8	14,5 13,0 11,9	25,6 21,6 18,8	26,8 22,6 19,6		A18	150 200	9,2 8,2	11,2 10,2	16,4 13,8	18,4 15,8
M315	160 200	17,8 16,4	19,9 18,1	33,2 28,8	35,1 30,3		A24	150 200 250	14,5 13,5 12,5	17,0 16,0 14,5	26,0 22,0 19,5	28,5 24,5 21,5
M450	200 250	23,8 22,1	26,8 24,5	44,9 38,9	46,9 40,6		A30	150 200 250	19,0 17,0 15,5	22,5 20,0 18,5	36,0 29,5 26,0	39,5 32,5 29,0
M630	250 315	34,2 31,7	38,0 34,7	57,4 50,1	60,8 52,8		A40	200 250	26,0 23,5	27,5 25,0	49,0 41,5	50,5 43,0
PK500	160 200	22,5 20,8					A65	200 250	34,5 31,5	37,5 34,0	57,5 50,0	60,5 52,5

Options (*) Specifications (x)=basic	A5,5	M80 A8,5	M112 A12,5	M160 A18	M224 A24	M315 A30	M450 A40	M630 A65	PK500
* Side plates with induction hardened wear surfaces				*	*	*	*	*	*
With case hardened bushings	x	x	x	x	x	x	x	x	x
With case hardened pins				x	x	x	x	x	x
With induction hardened pins	x	x	x						
With welded pins	*	*	*/x	x	x	x	x	x	x
With welded bushings				*/x	x	x	x	x	x
With stainless pins + bushings	*	*	*	*	*	*	*	*	*
Side plates with smoothed corners	*	*	*	*	*	*	*	*	*
Lubricated joints	x	x	x	x	x	x	x	x	x

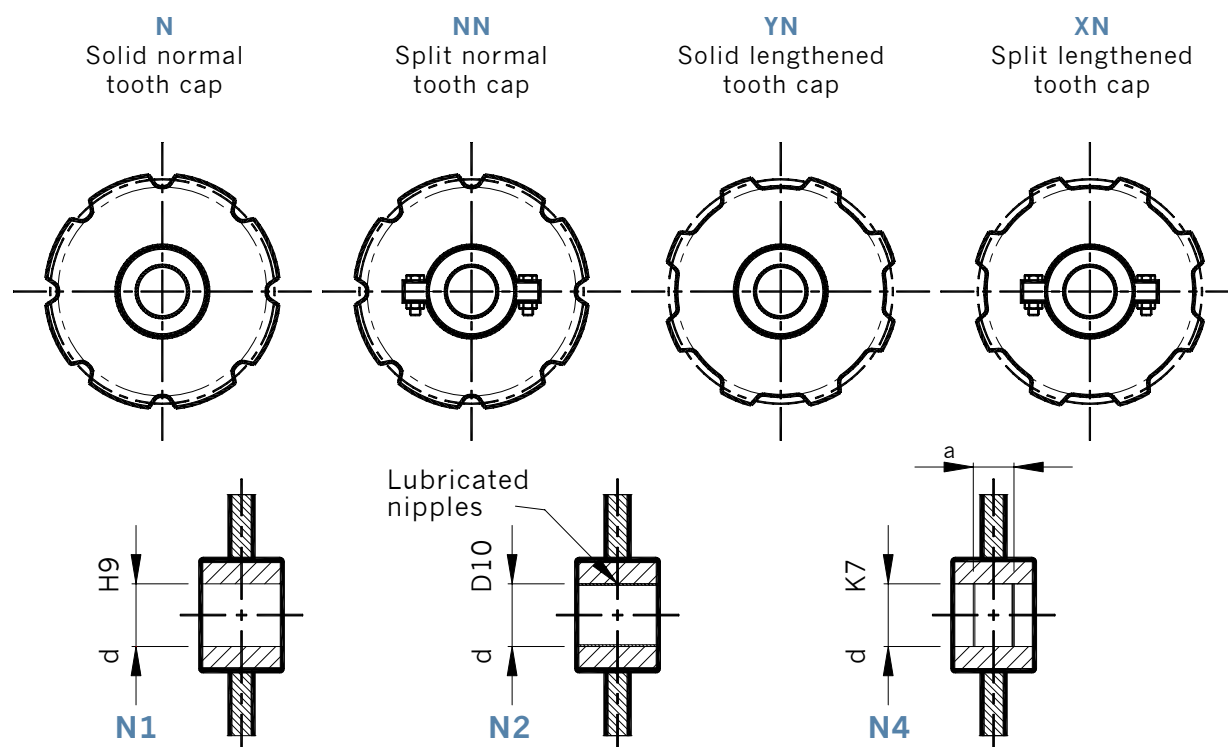
Y-CHAINS

KRX 155





CHAIN SPROCKETS WITH SOLID RIMS

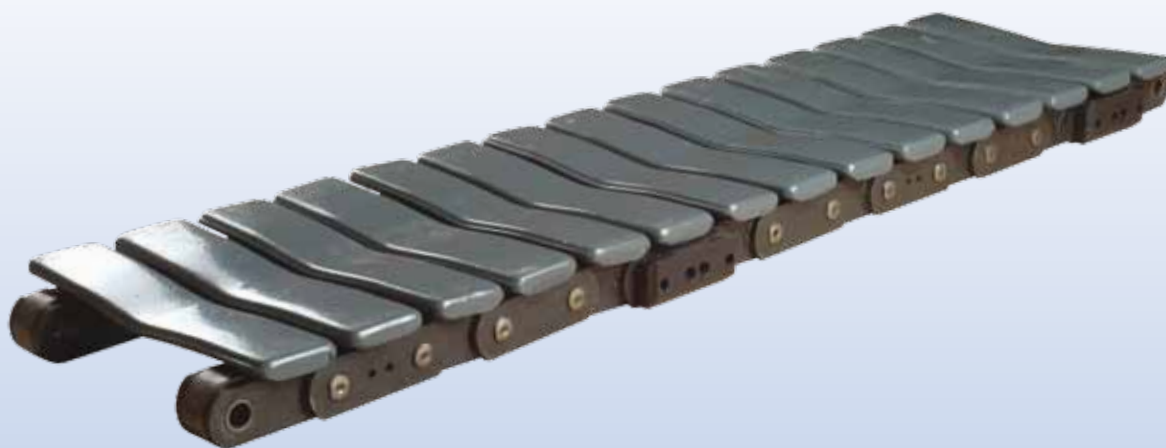
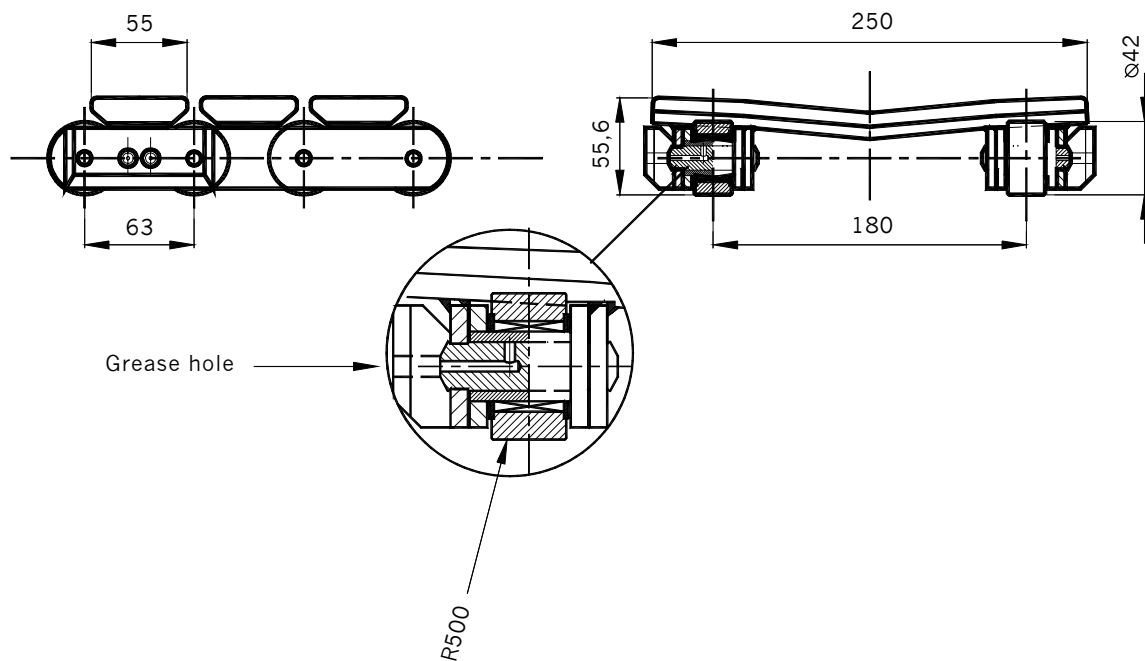


	M80	M112	M160	M224	M315	M450	M630
S355	x	x	x	x	x	x	x
HARDOX 400	x	x	x	x	x	x	x
N1 keyway	x	x	x	x	x	x	x
N2 bearing bush	x	x	x	x	x	x	x
N4 fit for ball bearings	x	x	x	x	x	x	x

Subscription to order: Chain sprocket, hub type, keyway, d, / conveyor chain no-type-pitch, material, pcs.
Eg. Conveyor chain YN1-8-100 / M450-A-200 Hardox, pcs.

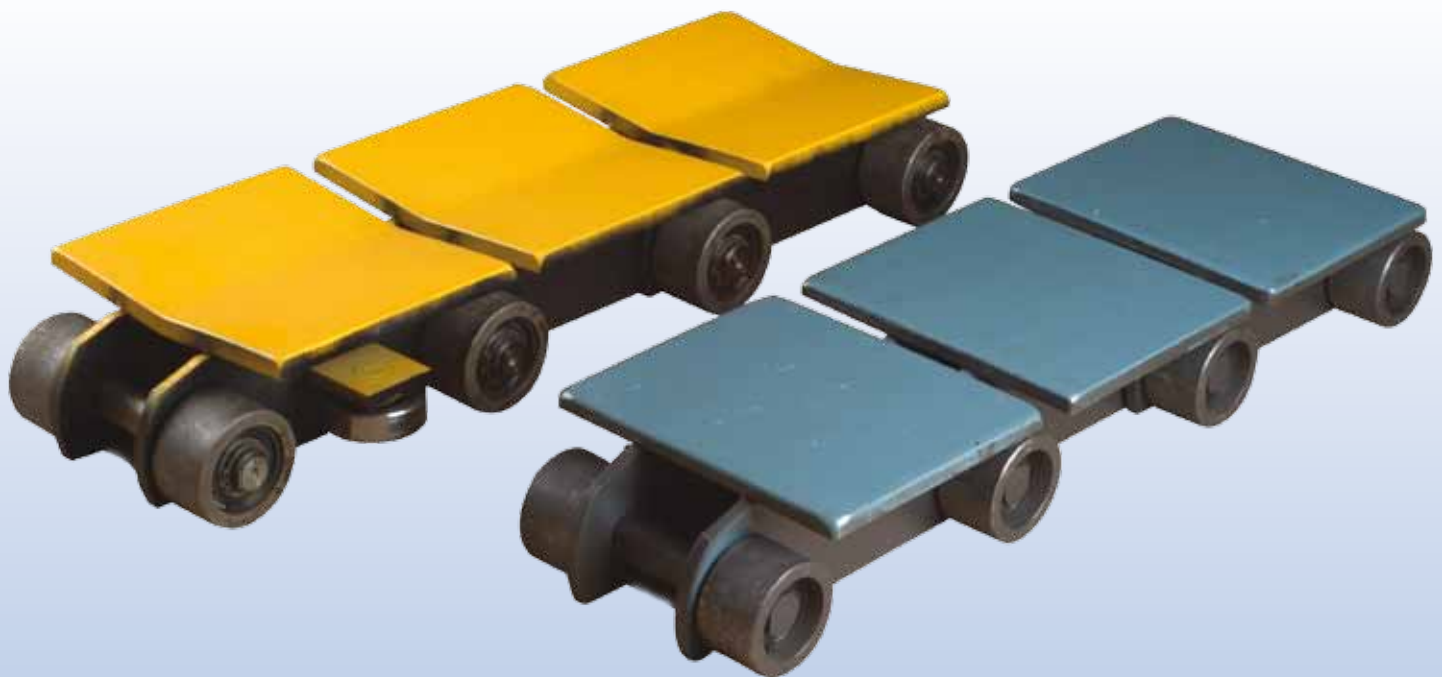
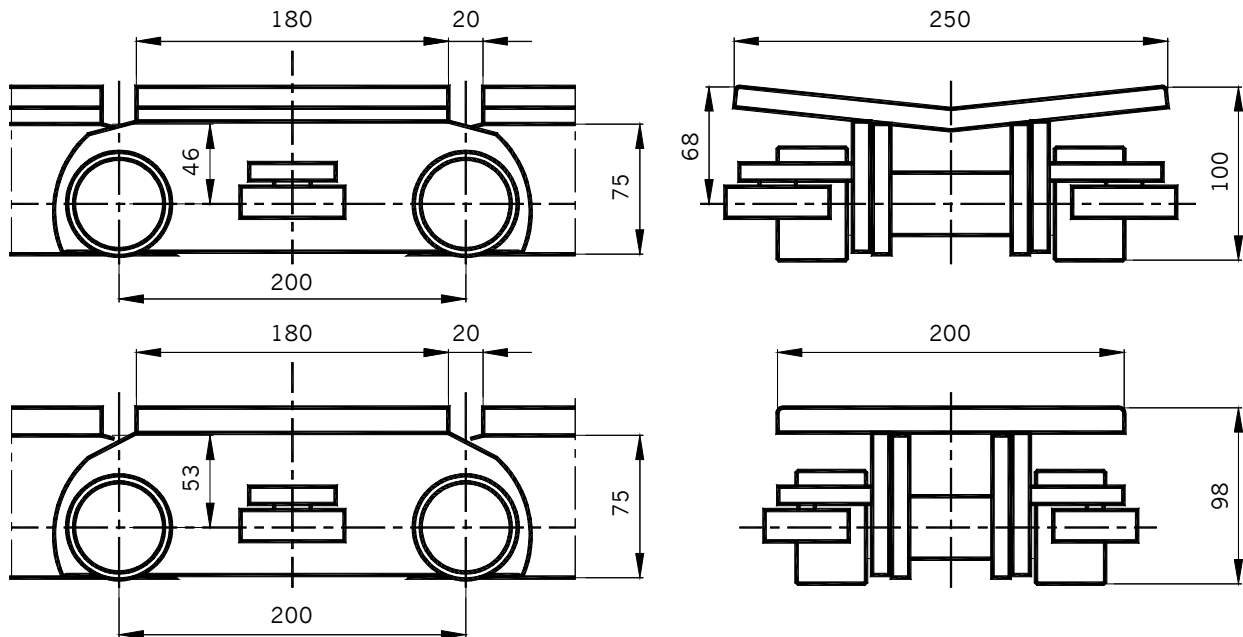
CONVEYOR CHAIN FOR PAPER ROLLS

P=63

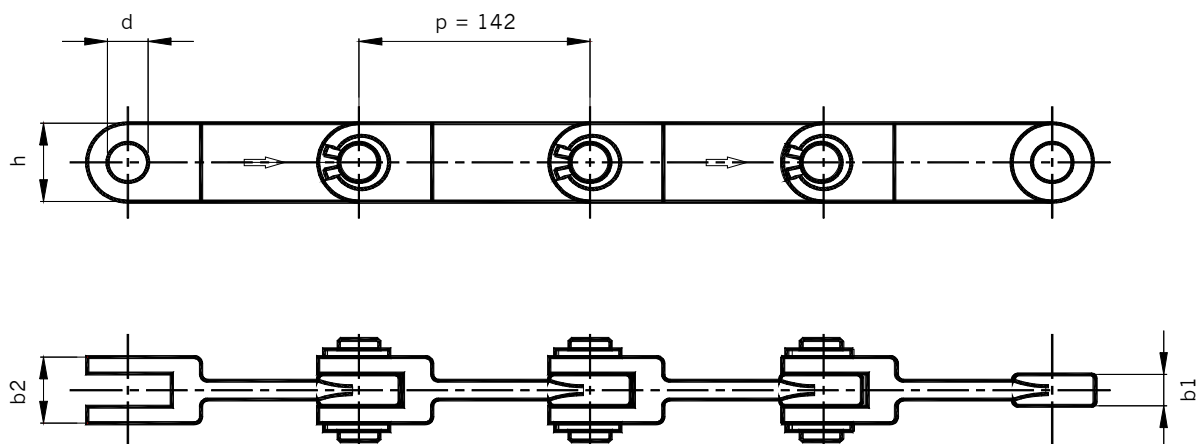


CONVEYOR CHAIN FOR PAPER ROLLS

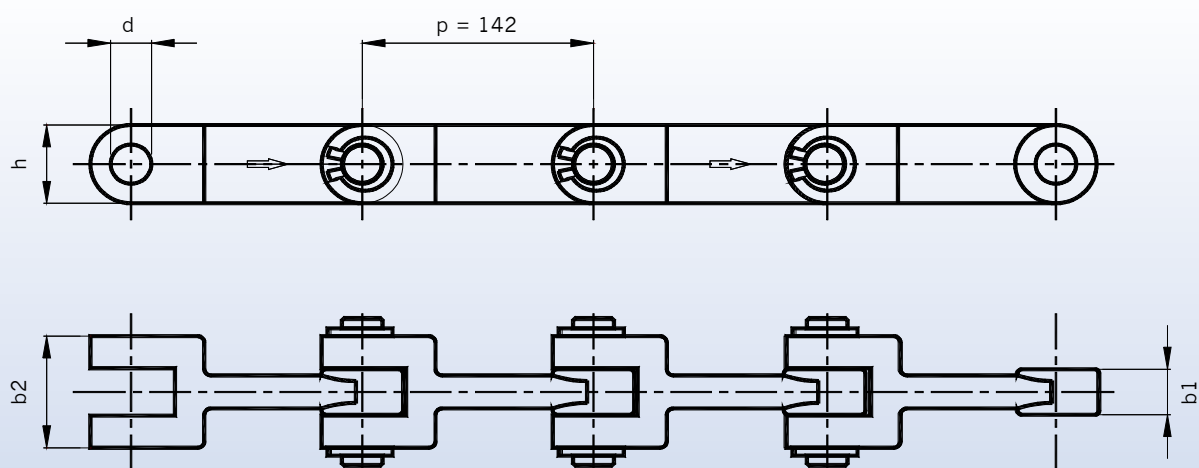
P=200



SCRAPER CHAINS WITH FORGED LINKS



T142N

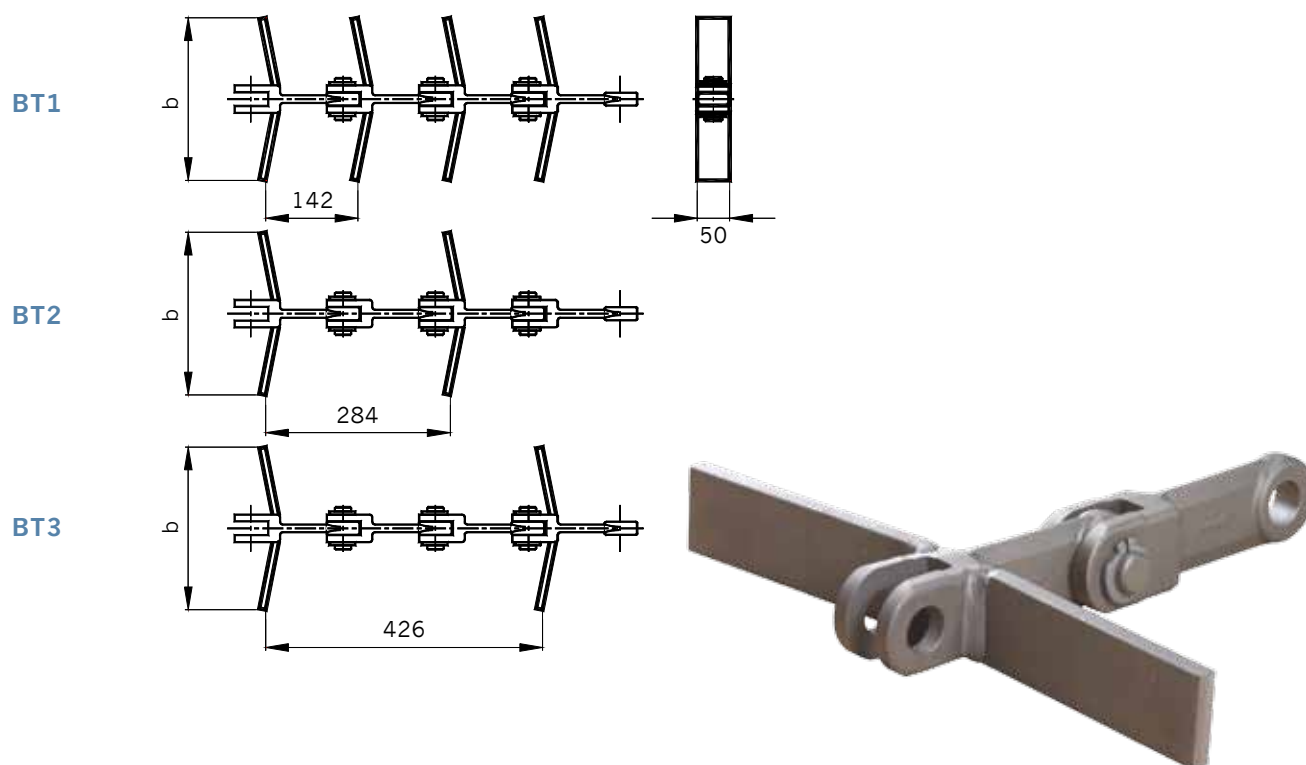


T142V

CHAIN NO.	PITCH p	d	h	$b1$	$b2$	kN	kg/m
142N	142	25	50	21	42	390	10,4
142V	142	25	50	30	62	500	15,1

Subscription to order: Scraper chain, chain no.
Eg. Scraper chain 142N

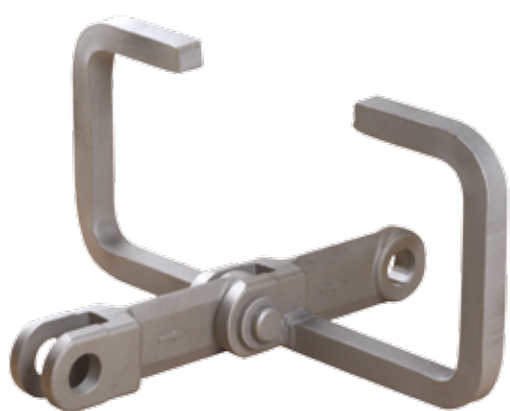
DRAG CHAIN TYPE BT



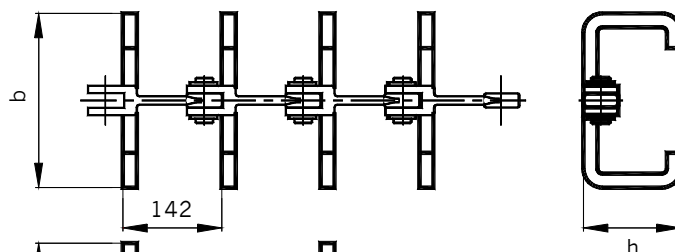
Width conveyor	Width of chain b	Type of flight	Dimension of flight	Weight kg/m	
				142N	142V
250	235	BT1	12 x 50	16,8	20,9
		BT2		13,6	18,0
		BT3		12,5	17,0
320	305	BT1	12 x 50	19,1	23,1
		BT2		14,8	19,1
		BT3		13,3	17,8
400	380	BT1	12 x 50	21,6	25,7
		BT2		16,0	20,4
		BT3		14,1	18,6
500	480	BT1	15 x 50	29,8	33,6
		BT2		20,1	24,4
		BT3		16,9	21,3
600	580	BT1	15 x 50	34,2	38,0
		BT2		22,3	26,5
		BT3		18,3	22,7
700	680	BT1	15 x 50	38,6	42,4
		BT2		24,5	28,8
		BT3		19,8	24,2

Subscription to order: Drag chain, drag chain no. - width of chain b - type of flight
 Eg. Drag chain 142V - 380 - BT2

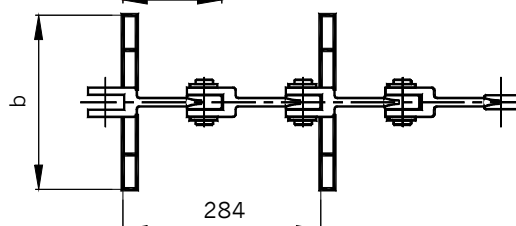
DRAG CHAIN TYPE O



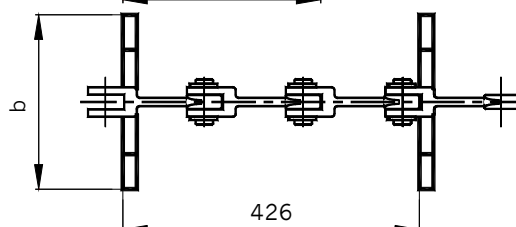
01



02



03



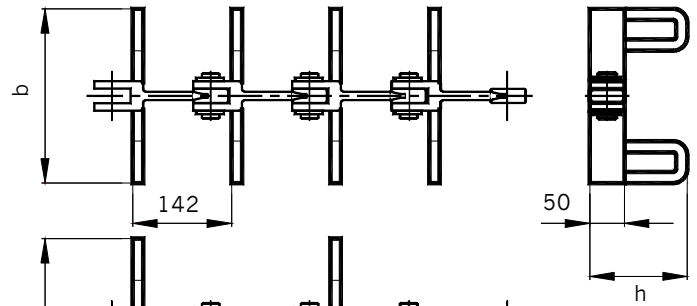
Width conveyor	Width of chain b	Heigh of chain h	Type of flight	Dimension of flight	Weight kg/m	
					142N	142V
250	235	140	01	20 x 20	19,9	24,6
			02		15,2	19,9
			03		13,6	18,3
320	305	180	01	20 x 20	23,6	28,1
			02		16,9	21,6
			03		14,7	19,4
400	380	180	01	20 x 20	25,7	30,4
			02		18,0	22,7
			03		15,5	20,2
400	380	230	01	20 x 20	26,0	30,7
			02		18,3	23,0
			03		15,8	20,5
500	480	230	01	25 x 25	42,9	47,6
			02		26,7	31,4
			03		21,3	26,0
600	580	230	01	25 x 25	49,4	54,1
			02		29,9	34,6
			03		23,4	28,1

Subscription to order: Drag chain, drag chain no. - width of chain b - type of flight
 Eg. Drag chain 142V-380-02

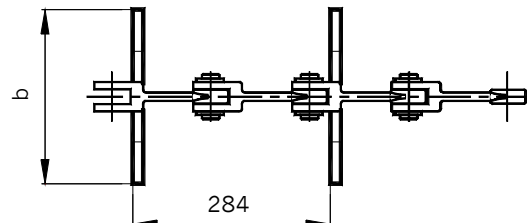
DRAG CHAIN TYPE T00



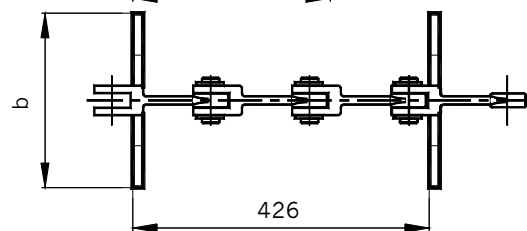
T001



T002



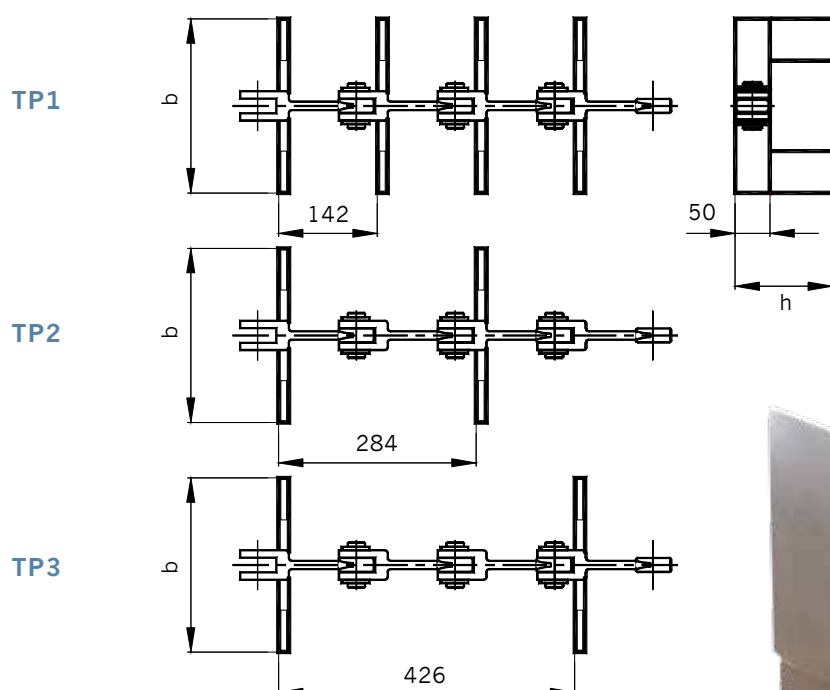
T003



Width conveyor	Width of chain b	Height of chain h	Type of flight	Dimension of flight	Weight kg/m	
					142N	142V
400	380	180	T001 T002 T003	15 x 50 + 16 x 16	35,7 23,1 18,9	39,7 27,4 23,3
400	380	230	T001 T002 T003	15 x 50 + 16 x 16	36,1 23,5 19,4	40,1 27,8 23,7
500	480	180	T001 T002 T003	15 x 50 + 16 x 16	41,0 25,7 20,6	55,9 35,5 28,7
500	480	230	T001 T002 T003	20 x 50 + 20 x 20	56,2 33,3 25,7	60,2 37,6 30,1
600	580	180	T001 T002 T003	20 x 50 + 20 x 20	66,0 38,2 29,0	70,0 42,6 33,4
600	580	230	T001 T002 T003	20 x 50 + 20 x 20	66,4 39,4 29,6	70,6 43,2 34,0

Subscription to order: Drag chain, drag chain no. - width of chain b - type of flight
Eg. Drag chain 142V-380-T002

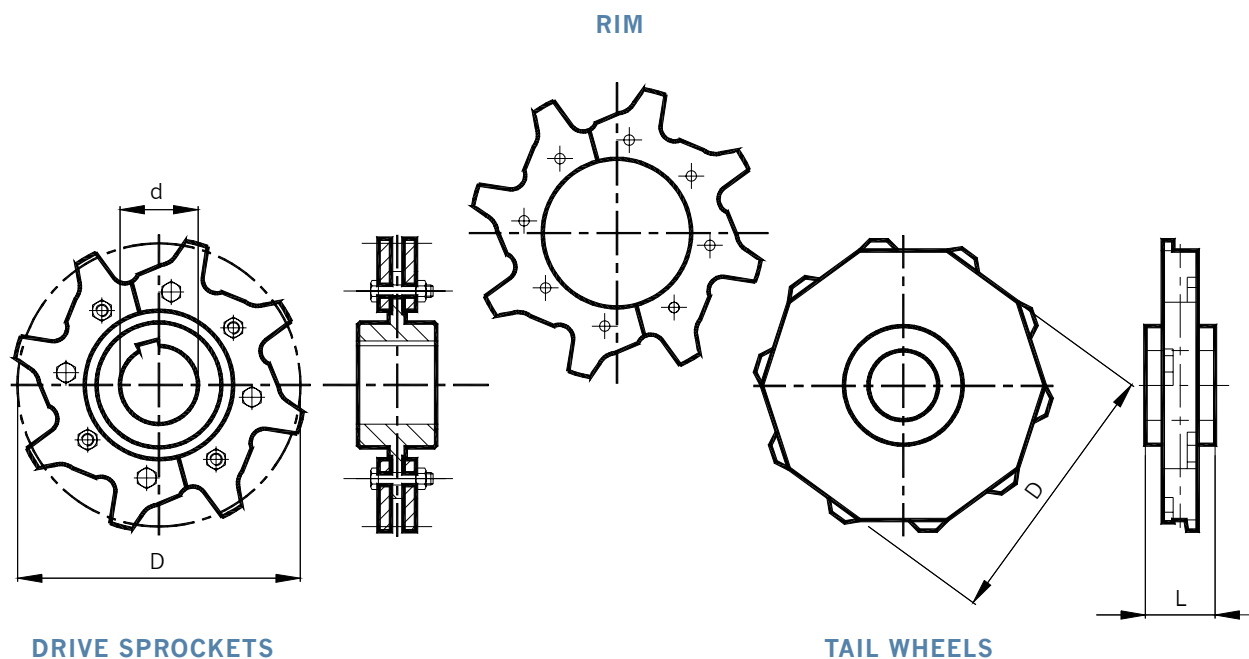
DRAG CHAIN TYPE TP



Width conveyor	Width of chain b	Height of chain h	Type of flight	Dimension of flight	Weight kg/m	
					142N	142V
250	235	140	TP1 TP2 TP3	12 x 50 + PL6	20,5 15,4 13,7	24,5 19,8 18,2
320	305	180	TP1 TP2 TP3	12 x 50 + PL6	27,0 18,7 15,9	31,0 23,1 20,4
400	380	180	TP1 TP2 TP3	15 x 50 + PL8	39,3 24,8 20,0	43,3 29,2 24,5
500	480	230	TP1 TP2 TP3	15 x 50 + PL8	47,4 28,9 22,7	51,2 33,2 27,2

Subscription to order: Drag chain, drag chain no. - width of chain b - type of flight
 Eg. Drag chain 142V-380-TP2

CHAIN WHEELS FOR SCRAPER CHAINS WITH FORGED LINKS



	z	D	d H8		T142N				T142V			
			min.	max.	L	kg	ord.no.	rim	L	kg	ord.no.	rim
DRIVE SPROCKETS with replaceable rims, HB 400	8	371,1	50	115	100	43	301520	201680	120	49	301530	201684
	10	459,6	60	135	120	58	301521	201681	120	67	301531	201685
	11	504,0	80	150	140	68	301522	201682	140	78	301532	201686
	13	593,4	80	150	140	82	301523	201683	140	94	301533	201687
TAIL WHEELS, solid , Fe 52C	6	196,0	50	110	100	16	301524		120	19	301534	
	7	244,8	50	120	100	23	301525		120	27	301535	
	8	292,0	50	120	100	31	301526		120	37	301536	
	9	340,0	50	120	100	41	301527		120	48	301537	
	10	386,0	70	120	100	51	301528		120	61	301538	
	13	526,0	70	120	100	73	301529		120	88	301539	

Subscription to order: Type of sprocket - ord.no. - shaft hole
Eg. Drive sprocket 301520 - 80 or drive sprocket z=8 hole 80



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