



# 输送用不锈钢平顶链

## Stainless Steel Flat Top Chain

传递安全与可靠  
Transmit Safety & Reliability



啤酒饮料领域链传动产品一揽子供应商

Supply Total Package of Chain Transmission Products for Beer & Beverage Industry

## 产品的多样性选择

### Product Diversity Choice

不锈钢平顶链规格多达60余种，其选型应根据输送机的使用工况来确定，涉及要素应包括但不限于如物品特性、物品对环境的要求、装载量、链条线速度、链条与导轨的摩擦系数、主从动轮间中心距、润滑条件、温度等。在润滑条件良好的条件下，平顶链的传送线速度最高可达到120m/min。

不锈钢平顶链的技术性能主要取决于其原材料和制造过程的工艺技术水平。不同的金属材料特性决定了平顶链产品的适用环境和工况条件。目前可供选择的链板材料有AISI 420、AISI 430、AISI 304和特殊铬镍钢四种，销轴材料有AISI 420、AISI 431、AISI 304三种。其中AISI 420链板与AISI 420销轴、AISI 430和特殊铬镍钢链板与AISI 431销轴、AISI 304链板与AISI 431或AISI 304销轴的基于材料匹配的五种装配方式。

There are more than 60 specifications of stainless steel flat-top chain, and its selection should be determined according to the working conditions of the conveyor. The factors involved should include, but not limited to, such as the characteristics of the goods, the requirements of the goods to the environment, the loading capacity, the speed of the chain, the friction coefficient between the chain and the guide rail, the center distance between the driver and driven wheels, lubrication conditions, temperature, etc. Under good lubrication conditions, the transmission line speed of flat top chain can reach 120 m/min.

The technical performance of stainless steel flat top chain mainly depends on its raw materials and technological level of manufacturing process. Different metal materials' characteristics determine the applicable environment and working conditions of flat-top chain products. At present, there are four kinds of chain chain materials for choices: AISI 420, AISI 430, AISI 304 and Special Chromium-nickel Steel. Pin materials are AISI 420, AISI 431 and AISI 304. Among them, AISI 420 chain chain with AISI 420 pin, AISI 430 and Special Chromium-nickel Steel with AISI 431 pin, AISI 304 chain chain with AISI 431 or AISI 304 pin are five assembly methods based on material matching.

### 链板、销轴材料匹配表 Chain and Pin materials Matching Table

链板材料 Chain Materials	AISI 420	AISI 430	AISI 304	AISI 304	特殊铬镍钢 Special Chromium-nickel Steel
销轴材料 Pin Materials	AISI 420	AISI 431	AISI 431	AISI 304	AISI 431

AISI 420为马氏体型铬不锈钢，样本中链号以C、CC和MS命名  
AISI 430为铁素体型铬不锈钢，样本中链号以SS命名  
AISI 304为奥氏体型铬不锈钢，样本中链号以SSA命名  
特殊铬镍钢为黄山链条开发的新型材料，样本中链号以SSH命名

AISI 420 is martensitic chromium stainless steel. The chain numbers are named C, CC and MS.

AISI 430 is a ferritic chromium stainless steel. The chain number is named SS.

AISI 304 is austenitic chromium stainless steel. The chain number is named SSA.

Special chromium-nickel steel is a new material developed for Huangshan chain. The chain number is named SSH.

# 不同材料牌号平顶链技术特性

## Technical Characteristics of Flat Top Chain with Different Material Grades

### 链条强度

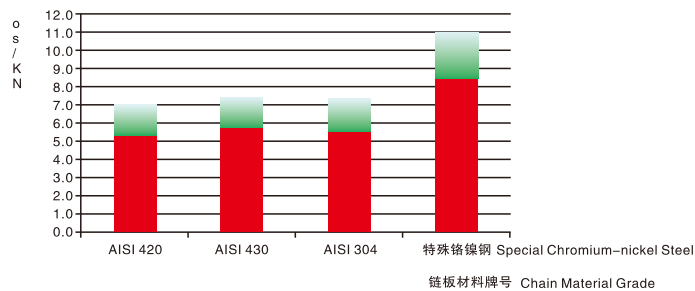
基于平顶链的卷制开式结构链板及失效伸长量不大于链条名义长度的3%的可靠性运行，其强度应定义为链条的实际屈服强度值。

以38.1\*82.6规格单铰式平顶链为例，不同材料链板的链条屈服强度（绿色区）如下图表。

### Chain strength

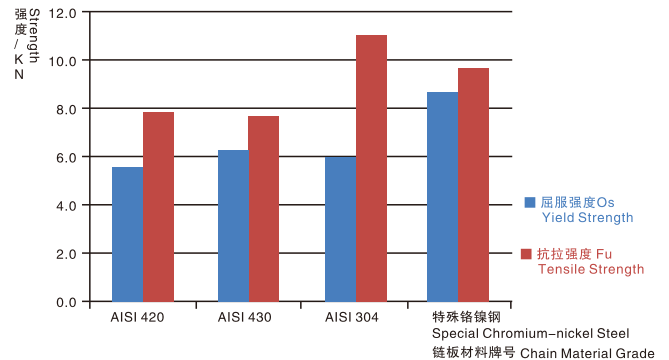
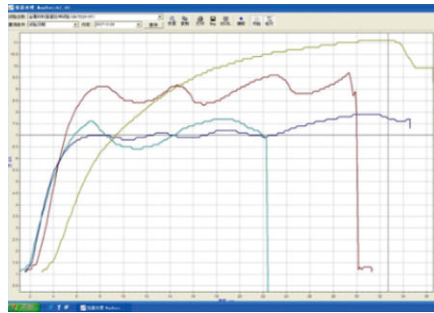
Based on the reliable operation of the open-loop structure chain chain with flat-top chain and the failure elongation not greater than 3% of the nominal length of the chain, its strength should be defined as the actual yield strength of the chain.

Taking 38.1\*82.6 single-hinged flat-top chains as an example, the yield strength (green zone) of chains with different materials is shown in the following chart.



下列图表为2017年3月份在产的38.1\*82.6规格单铰式平顶链，在WE-300万能材料试验机上测得的试验数据。

The following chart shows the test data of 38.1\*82.6 single-hinged flat-top chains produced in March 2017 on 300 Tons universal material testing machine.



### 链条抗磨损性能

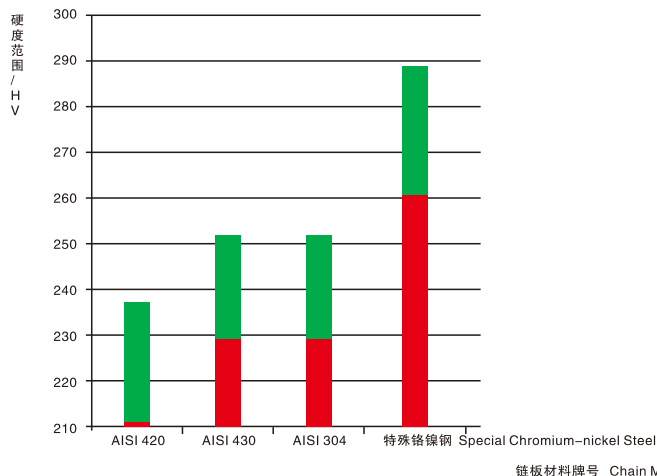
链条的抗磨损性能主要取决于链板的表面硬度和表面粗糙度值。

不同材料链板的表面硬度范围（绿色区）如下图表。

### Wear Resistance of Chains

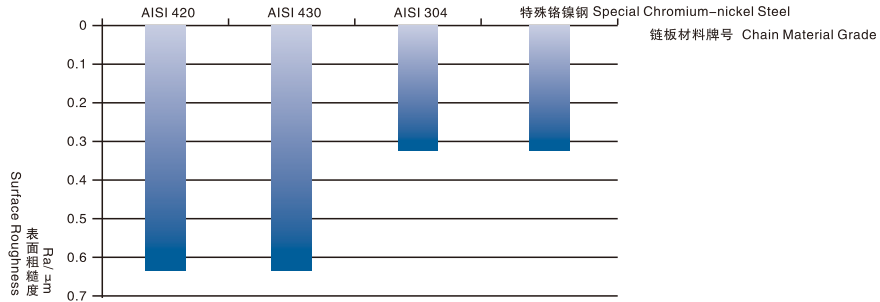
The wear resistance of the chain mainly depends on the surface hardness and roughness of the chain chain.

The surface hardness range (green zone) of chain incha with different materials is shown in the following chart.



### 链板表面粗糙度

通常以轮廓算术平均偏差Ra值判定链板表面光滑程度。不同材料链板的表面粗糙度最大值要求如下图。



### Surface roughness of chain chain

The surface smoothness of the chain chain is usually determined by the Ra value of the arithmetic mean deviation of the contour. The maximum surface roughness of chain incha with different materials is as follows.

### 链条运行的平稳性

链条运行平稳性涉及因素很多，对于链条本身而言，链板表面的形状和平整度、链条的侧弯与扭曲、链板与销轴间的间隙等因素相关。

以38.1\*82.6规格单铰式平顶链为例阐述工厂对于这一质量指标的控制。

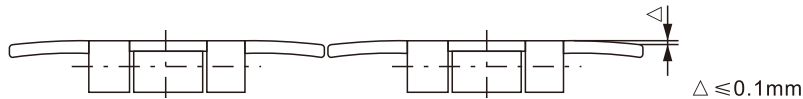
链板的形状适于多排链条之间的物品的横向移动。

### Stability of Chain Performance

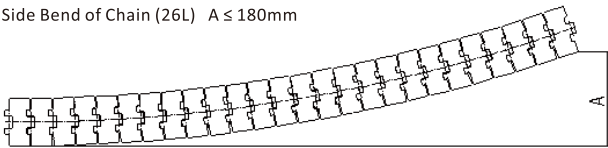
For the chain itself, the shape and smoothness of the surface of the chain chain, the side bending and twisting of the chain, and the gap between the chain chain and the pin shaft are related to many factors.

Taking 38.1\*82.6 single-hinged flat-top chain as an example, this paper expounds the control of this quality index in the factory.

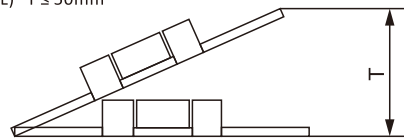
The shape of the chain chain is suitable for the transverse movement of objects between multiple chains.



链条的侧弯 (26L) A ≤ 180mm  
Side Bend of Chain (26L) A ≤ 180mm



链条的扭曲 (26L) T ≤ 50mm  
Chain twist (26L) T ≤ 50mm



同一链段，A、T的双向差值不大于30%。链段的侧弯和扭曲值集中体现较卷孔心距精度、链板较卷与销轴间的侧隙大小及链节框架的端正程度。

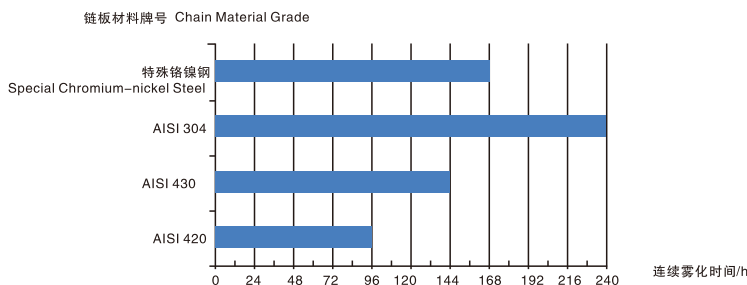
In the same chain segment, the difference between A and T is not more than 30%. The lateral bending and twisting values of the chain segment concentrate on the accuracy of the center distance of the hinge roll hole, the size of the backlash between the hinge roll and the pin shaft of the hinge chain, and the degree of the end alignment of the chain frame.

### 链条抗腐蚀性能

JW-60-SS盐雾喷雾试验机试验，符合GB/T 10125《人造气氛腐蚀试验 盐雾试验》标准中NSS中性盐雾试验条件，不同材料的链板首次出现点蚀现象的连续雾化时间如下图表：

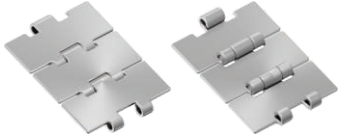
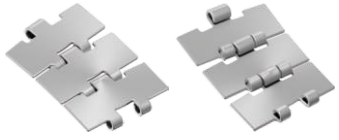



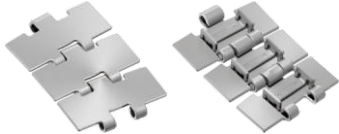

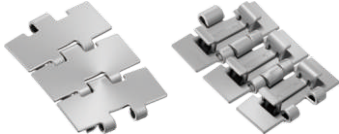

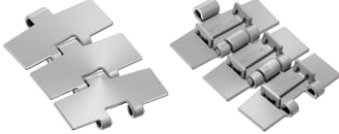
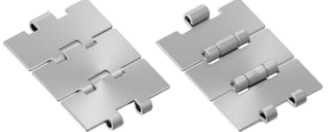
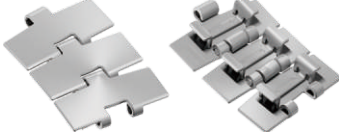

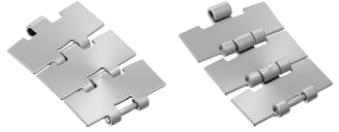


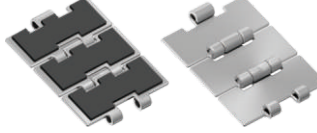
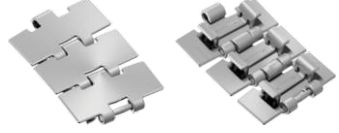
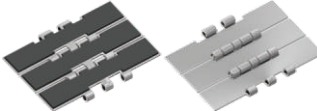
### Corrosion Resistance of Chains

The test of JW-60-SS salt spray test machine is consistent with the neutral salt spray test conditions of GB/T 10125 "artificial atmosphere corrosion test salt spray test" standard. The continuous atomization time of the pitting phenomenon for the first time of chain incha of different materials is as follows: Chart: NSS



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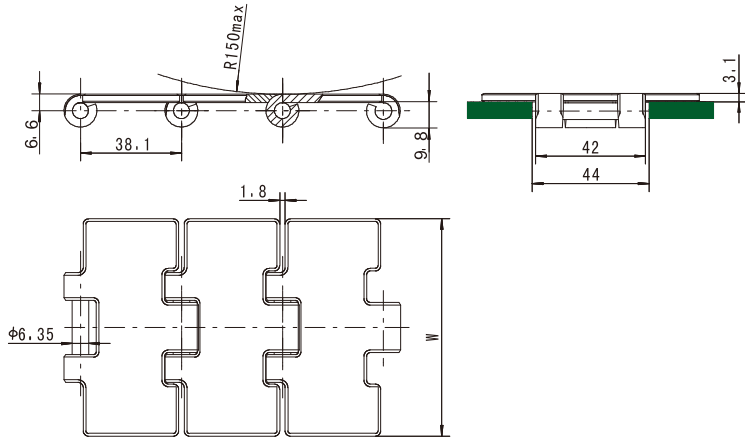
	page		page
812/815 	<b>A05</b>	8810M 	<b>A15</b>
802/805 	<b>A06</b>	8857M 	<b>A16</b>
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802GT/805GT 	<b>A14</b>		

## 不锈钢单铰链式直输平顶链 Stainless Steel Single Hinge Straight Running Flat Top Chains

节距 P=38.1mm 812/815 系列

Pitch P=38.1mm 812/815 Series

### 812/815



链号 Chain No.	链板 Chain			屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight		
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width ( W )					
		$\mu m$	mm	inch	kN	lbf	kg/m	lb/ft
C12S	马氏体型铬不锈钢 Martensitic Chromium Stainless Steel	0.8	76.2	3	6.25	1406	2.47	1.66
C13S			82.5	3 1/4			2.62	1.76
C14S			88.9	3 1/2			2.64	1.78
C16S			101.6	4			2.76	1.85
C18S			114.3	4 1/2			3.05	2.05
C20S			127	5			3.34	2.24
C24S			152.4	6			4.20	2.82
C30S			190.5	7 1/2			5.07	3.40
SS 812-K300			铁素体型铬不锈钢 Ferritic Chromium Stainless Steel	0.6			76.2	3
SS 812-K320	82.5	3 1/4			2.60	1.75		
SS 812-K330	83.8	3 19/64			2.63	1.77		
SS 812-K350	88.9	3 1/2			2.74	1.84		
SS 812-K400	101.6	4			3.03	2.04		
SS 812-K450	114.3	4 1/4			3.32	2.23		
SS 812-K600	152.4	6			4.18	2.81		
SS 812-K750	190.5	7 1/2			5.04	3.38		
SSH 815-K300	特殊铬镍钢 Special Chromium-Nickel Steel	0.3			76.2	3	8.5	1912
SSH 815-K325			82.5	3 1/4	2.62	1.76		
SSH 815-K330			83.8	3 19/64	2.64	1.78		
SSH 815-K350			88.9	3 1/2	2.76	1.85		
SSH 815-K400			101.6	4	3.05	2.05		
SSH 815-K450			114.3	4 1/2	3.34	2.24		
SSH 815-K600			152.4	6	4.20	2.82		
SSH 815-K750			190.5	7 1/2	5.07	3.40		
SSA 815-K300			奥氏体型铬镍不锈钢 Austenitic Chromium-Nickel Stainless Steel	0.3	76.2	3		
SSA 815-K325	82.5	3 1/4			2.65	1.79		
SSA 815-K330	83.8	3 19/64			2.68	1.81		
SSA 815-K350	88.9	3 1/2			2.80	1.89		
SSA 815-K400	101.6	4			3.10	2.09		
SSA 815-K450	114.3	4 1/2			3.39	2.29		
SSA 815-K600	152.4	6			4.28	2.89		
SSA 815-K750	190.5	7 1/2			5.16	3.48		

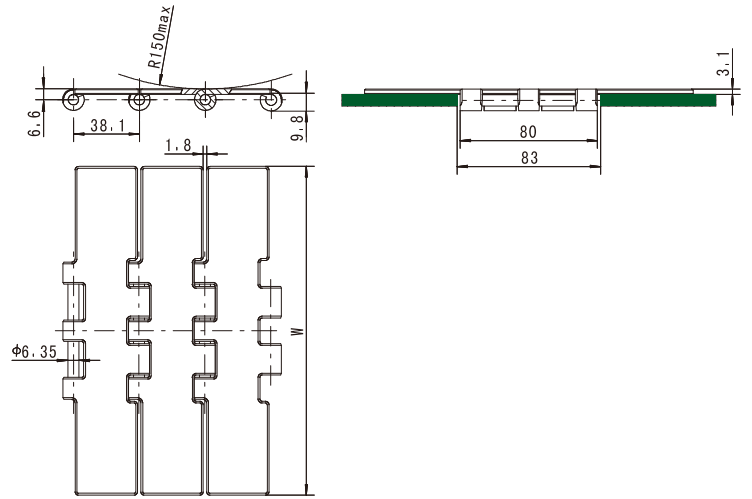
说明: 1.链条遵循GB/T 4140和DIN 8153标准制造;  
 2.同一宽度的链板有四种不同的材料可供选择, 以适用不同的工作场合;  
 3.供货时, 每条链条的标准长度为3.048m ( 10ft ), 计80节。

Note: 1.These chains are built in accordance with Standard GB/T 4140 and DIN 8153;  
 2.For the incha with the same width, there are 4 kinds of different materials to be available as an option, using to many different workplaces;  
 3.When supplied, the standard length of each chain is 3.048m (10ft), total 80links.

## 不锈钢双铰链式直输平顶链 Stainless Steel Double Hinge Straight Running Flat Top Chains

节距 P=38.1mm 802/805 系列

Pitch P=38.1mm 802/805 Series

802/805


链号 Chain No.	链板 Chain			屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight		
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width (W)					
		$\mu\text{m}$	mm	inch	kN	lbf	kg/m	lb/ft
C30D	马氏体型铬不锈钢 Martensitic Chromium Stainless Steel	0.8	190.5	7 1/2	12.5	2812	5.72	3.84
SS 802-K750	铁素体型铬不锈钢 Ferritic Chromium Stainless Steel	0.6			10.3	2317	5.68	3.82
SSH 805-K750	特殊铬镍钢 Special Chromium-Nickel Steel	0.3			15	3374	5.72	3.84
SSA 805-K750	奥氏体型铬镍不锈钢 Austenitic Chromium-Nickel Stainless Steel	0.3			10.6	2385	5.81	3.90

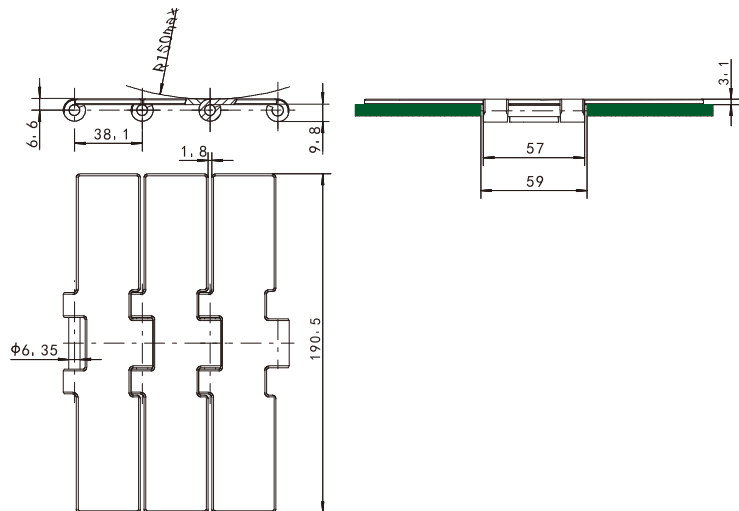
- 说明：1.链条遵循GB/T 4140和DIN 8153标准制造；
- 2.与单铰链式链条相比，具有近2倍的胶卷宽度，因此拥有更高的屈服强度，属重载链条。主要应用在堆码机和重负载的输箱线上；
- 3.同一宽度的链板有四种不同的材料可供选择，以适用不同的工作场合；
- 4.供货时，每条链条的标准长度为3.048m (10ft)，计80节。

- Note: 1.These chains are built in accordance with Standard GB/T 4140 and DIN 8153;
- 2.The Series feature a hinge width approx. twice that of single hinge chains, so they have a much higher yield strength and are a heavy-duty chains, being mainly used on palletizers and heavy crate conveyor;
- 3.For the incha with the same width, there are 4 kinds of different materials to be available as an option, using to many different workplaces;
- 4.When supplied, the standard length of each chain is 3.048m (10ft), total 80links.

## 不锈钢单铰链式直输平顶链 Stainless Steel Single Hinge Straight Running Flat Top Chains

节距 P=38.1mm 8157 系列

Pitch P=38.1mm 8175 Series

8157


链号 Chain No.	链板 Chain				屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight	
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width (W)					
		$\mu\text{m}$	mm	inch	kN	lbf	kg/m	lb/ft
SS 8157-K750	铁素体型铬不锈钢 Ferritic Chromium Stainless Steel	0.6	190.5	7 1/2	7.2	1620	5.30	3.56
SSH 8157-K750	特殊铬镍钢 Special Chromium-Nickel Steel	0.3			10.5	2362	5.33	3.58
SSA 8157-K750	奥氏体型铬镍不锈钢 Austenitic Chromium-Nickel Stainless Steel	0.3			7.0	1575	5.45	3.66

说明: 1.重载链条, 相比于普通链条, 具有更宽的铰卷和更高的屈服强度;  
 2.同一宽度的链板有三种不同的材料可供选择, 以适用不同的工作场合;  
 3.供货时, 每条链条的标准长度为3.048m (10ft), 计80节。

Note: 1.Compared with regular chains, the heavy-duty chains have a much wider hinge and much higher yield strength;  
 2.For the incha with the same width, there are 3 kinds of different materials to be available as an option, using to many different workplaces;  
 3.When supplied, the standard length of each chain is 3.048m (10ft), total 80links.

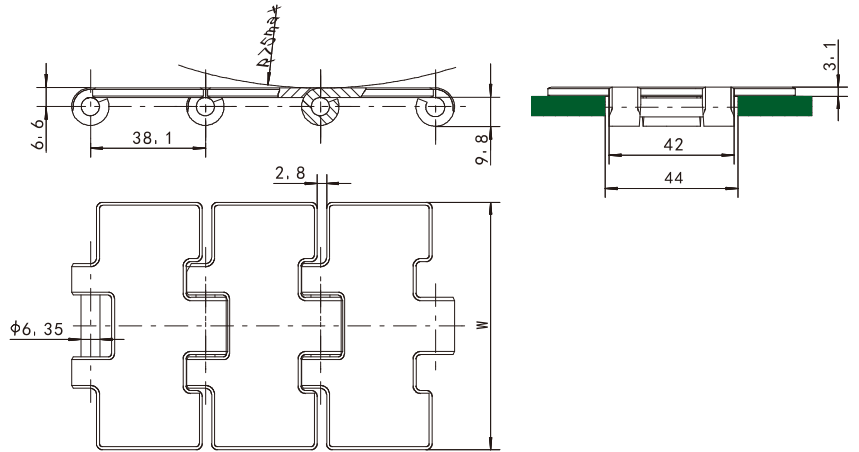


## 不锈钢单铰链式直输平顶链 Stainless Steel Single Hinge Straight Running Flat Top Chains

节距 P=38.1mm 812/815 系列

Pitch P=38.1mm 812/815 Series

### R812/815



链号 Chain No.	链板 Chain			屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight		
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width (W)		kN	lbf	kg/m	lb/ft
		$\mu\text{m}$	mm	inch				
MS R815-K300	马氏体型铬不锈钢 Martensitic Chromium Stainless Steel	0.8	76.2	3	6.25	1406	2.45	1.65
MS R815-K325			82.5	3 1/4			2.59	1.74
MS R815-K330			83.8	3 19/64			2.62	1.76
MS R815-K350			88.9	3 1/2			2.73	1.84
MS R815-K400			101.6	4			3.01	2.02
MS R815-K450			114.3	4 1/4			3.29	2.21
MS R815-K600			152.4	6			4.13	2.78
MS R815-K750			190.5	7 1/2			4.97	3.34
SS R812-K300	铁素体型铬不锈钢 Ferritic Chromium Stainless Steel	0.6	76.2	3	5.8	1305	2.44	1.64
SS R812-K325			82.5	3 1/4			2.58	1.73
SS R812-K330			83.8	3 19/64			2.60	1.75
SS R812-K350			88.9	3 1/2			2.72	1.82
SS R812-K400			101.6	4			2.99	2.01
SS R812-K450			114.3	4 1/2			3.27	2.20
SS R812-K600			152.4	6			4.11	2.76
SS R812-K750			190.5	7 1/2			4.94	3.32
SSH R815-K300	特殊铬镍钢 Special Chromium-Nickel Steel	0.3	76.2	3	8.5	1912	2.45	1.65
SSH R815-K325			82.5	3 1/4			2.59	1.74
SSH R815-K330			83.8	3 19/64			2.62	1.76
SSH R815-K350			88.9	3 1/2			2.73	1.84
SSH R815-K400			101.6	4			3.01	2.02
SSH R815-K450			114.3	4 1/2			3.29	2.21
SSH R815-K600			152.4	6			4.13	2.78
SSH R815-K750			190.5	7 1/2			4.97	3.34
SSA R815-K300	奥氏体型铬镍不锈钢 Austenitic Chromium-Nickel Stainless Steel	0.3	76.2	3	5.6	1260	2.50	1.68
SSA R815-K325			82.5	3 1/4			2.64	1.78
SSA R815-K330			83.8	3 19/64			2.67	1.80
SSA R815-K350			88.9	3 1/2			2.79	1.87
SSA R815-K400			101.6	4			3.08	2.07
SSA R815-K450			114.3	4 1/2			3.36	2.26
SSA R815-K600			152.4	6			4.22	2.84
SSA R815-K750			190.5	7 1/2			5.08	3.42

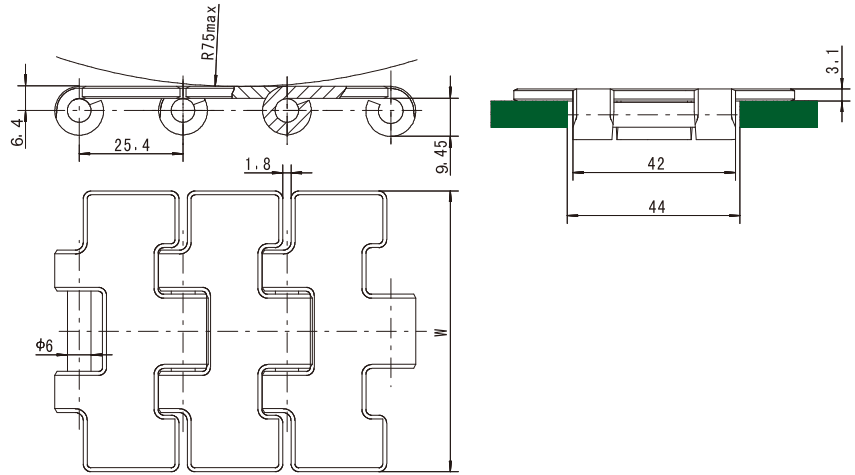
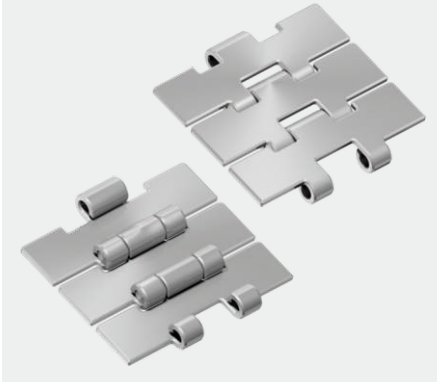
- 说明: 1.链条遵循GB/T 4140和DIN 8153标准制造;
- 2.同一宽度的链板有四种不同的材料可供选择, 以适用不同的工作场合;
- 3.供货时, 每条链条的标准长度为3.048m (10ft), 计80节;
- 4.由于链板间的间隙为2.8mm, 因此这种链条具有更小的反向弯曲半径。

- Note: 1. These chains are built in accordance with Standard GB/T 4140 and DIN 8153;
2. For the incha with the same width, there are 4 kinds of different materials to be available as an option, using to many different workplaces;
3. When supplied, the standard length of each chain is 3.048m (10ft), total 80links;
4. As the gap between incha is 2.8mm, the chains has a much smaller backflexing radius.

## 不锈钢单铰链式直输平顶链 Stainless Steel Single Hinge Straight Running Flat Top Chains

节距 P=25.4mm 512/515 系列

Pitch P=25.4mm 512/515 Series

**512/515**


链号 Chain No.	链板 Chain			屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight		
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width ( W )					
		$\mu\text{m}$	mm	inch	kN	lbf	kg/m	lb/ft
MS 515-K217	马氏体型铬不锈钢 Martensitic Chromium Stainless Steel	0.8	55	22 1/6	4.5	1012	2.33	1.56
MS 515-K250			63.5	2 1/2			2.52	1.69
MS 515-K283			72	2 5/6			2.71	1.82
MS 515-K297			75.5	2 35/36			2.78	1.87
MS 515-K325			82.5	3 1/4			2.94	1.97
MS 515-K350			88.9	3 1/2			3.08	2.07
MS 515-K388			98.5	3 36/41			3.29	2.21
MS 515-K400			101.6	4			3.36	2.26
SS 512-K217	铁素体型铬不锈钢 Ferritic Chromium Stainless Steel	0.6	55	1/6	4.7	1057	2.33	1.56
SS 512-K250			63.5	2 1/2			2.52	1.69
SS 512-K283			72	2 5/6			2.71	1.82
SS 512-K297			75.5	2 35/36			2.78	1.87
SS 512-K325			82.5	3 1/4			2.94	1.97
SS 512-K350			88.9	3 1/2			3.08	2.07
SS 512-K388			98.5	3 36/41			3.29	2.21
SS 512-K400			101.6	4			3.36	2.26
SSA 515-K217	奥氏体型铬镍不锈钢 Austenitic Chromium-Nickel Stainless Steel	0.3	55	2 1/6	4.5	1012	2.33	1.60
SSA 515-K250			63.5	2 1/2			2.52	1.73
SSA 515-K283			72	2 5/6			2.71	1.85
SSA 515-K297			75.5	2 35/36			2.78	1.91
SSA 515-K325			82.5	3 1/4			2.94	2.01
SSA 515-K350			88.9	3 1/2			3.08	2.11
SSA 515-K388			98.5	3 36/41			3.29	2.26
SSA 515-K400			101.5	4			3.36	2.30

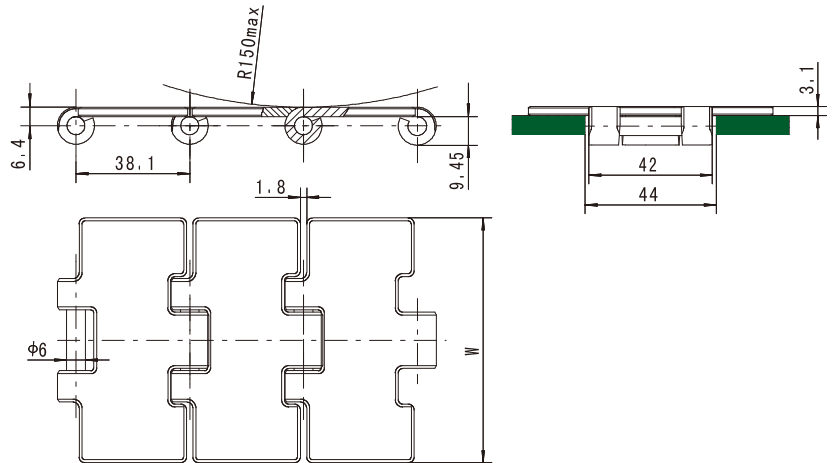
说明: 1.链条节距为25.4mm, 比标准链条的节距小, 是一种紧凑性设计, 适于窄尺寸零件输送。在啤酒行业, 主要是应用在洗瓶机设备的进出瓶装置上;  
2.同一宽度的链板有三种不同的材料可供选择, 以适应不同的工作场合;  
3.供货时, 每条链条的标准长度为3.048m(10ft), 计120节。

Note: 1.The pitch of the chain is 25.4mm, and it is a compact conveyor design, suitable for the transportation of narrow dimensional components. In beer industry, these chains are mainly used on bottle input and output device of bottle washing equipment;  
2.For the incha with the same width, there are 3 kinds of different materials to be available as an option, using to many different workplaces;  
3.When supplied, the standard length of each chain is 3.048m (10ft), total 120 links.

## 不锈钢单铰链式直输平顶链 Stainless Steel Single Hinge Straight Running Flat Top Chains

节距 P=38.1mm C※S-6 系列

Pitch P=38.1mm C※S-6 Series

C※S-6


链号 Chain No.	链板 Chain				屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight	
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width (W)		kN	lbf	kg/m	lb/ft
		$\mu\text{m}$	mm	inch				
C12S-6	马氏体型铬不锈钢 Martensitic Chromium Stainless Steel	0.8	76.2	3	6.25	1406	2.43	1.63
C13S-6			82.5	3 1/4			2.57	1.73
C14S-6			88.9	3 1/2			2.71	1.82
C16S-6			101.6	4			3.00	2.02
C18S-6			114.3	4 1/2			3.29	2.21
C20S-6			127	5			3.58	2.40
C24S-6			152.4	6			4.15	2.79
C30S-6			190.5	7 1/2			5.02	3.37

说明：1.销轴直径  $\phi 6$ ，铰链直径略小于GB/T4140标准系列，可直接匹配使用GB/T4140标准链轮；  
 2.此系列只适合中国市场使用；  
 3.供货时，每条链条的标准长度为3.048m（10ft），计80节。

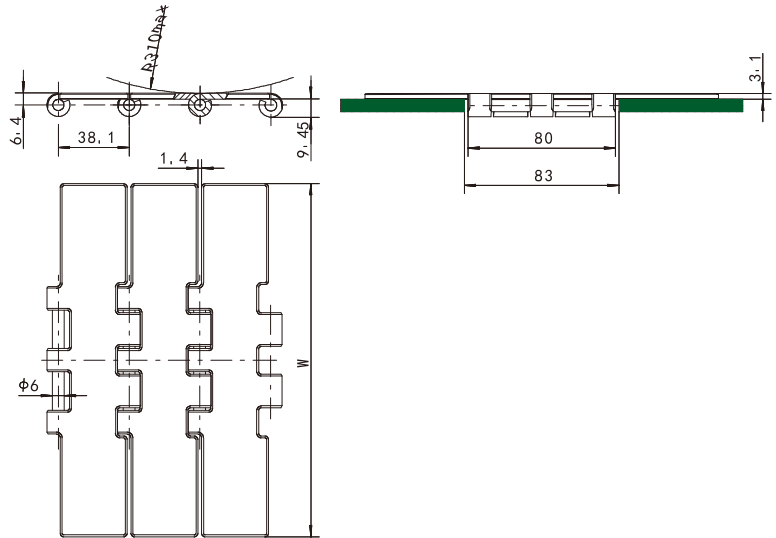
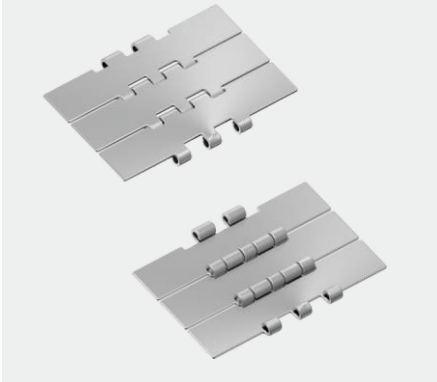
Note: 1.The dia. of pin is  $\phi 6$ , the hinge is slightly smaller than the dia. of the one of Standard GB/T4140, so the chains can match using the sprockets of Standard GB/T4140 directly;  
 2.The series are only suitable for using on the Chinese market;  
 3.When supplied, the standard length of each chain is 3.048m (10ft), total 80links.

## 不锈钢双铰链式直输平顶链 Stainless Steel Double Hinge Straight Running Flat Top Chains

节距 P=38.1mm C※D-6 系列

Pitch P=38.1mm C※D-6 Series

## C※D-6



链号 Chain No.	链板 Chain				屈服强度 Yield Strength $\sigma_{0.2}$		重量 Weight			
	材料 Material	表面粗糙度 Surface Roughness	宽度 Width (W)		kN	lbf	kg/m	lb/ft		
		$\mu\text{m}$	mm	inch						
C18D-6	马氏体铬不锈钢 Martensitic Chromium Stainless Steel	0.8	114.3	4 1/2	12.5	2812	3.97	2.67		
C24D-6			152.4	6					4.85	3.26
C30D-6			190.5	7 1/2					5.72	3.85

说明：1.销轴直径  $\phi 6$ ，铰卷直径略小于GB/T4140标准系列，可直接匹配使用GB/T4140标准链轮；  
 2.与单铰链式链条相比，具有近2倍的胶卷宽度，因此拥有更高的屈服强度，属重载链条。主要应用在堆码机和重负载的输箱线上；  
 3.供货时，每条链条的标准长度为3.048m（10ft），计80节。

Note: 1.The dia. of pin is  $\phi 6$ , and the one. of the hinge is slightly smaller than the dia. of the one of the series chains of Standard GB/T4140, so the chains can match using the sprockets of Standard GB/T4140 directly;  
 2.The Series feature a hinge width approx. twice that of the single hinge chains, so they have a much higher yield strength and are a heavy-duty chains, being mainly used on palletizers and heavy crate conveyor;  
 3.When supplied, the standard length of each chain is 3.048m (10ft), total 80links.