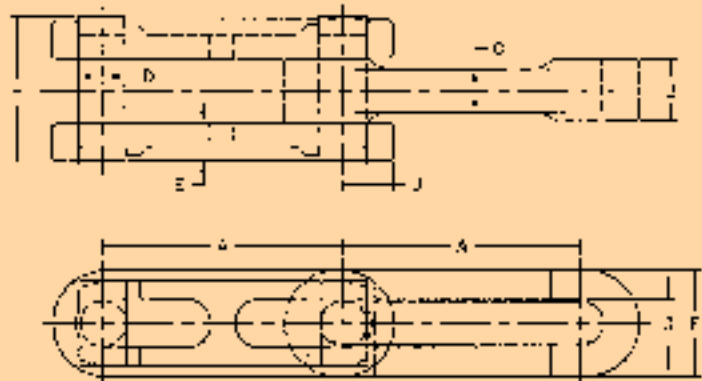
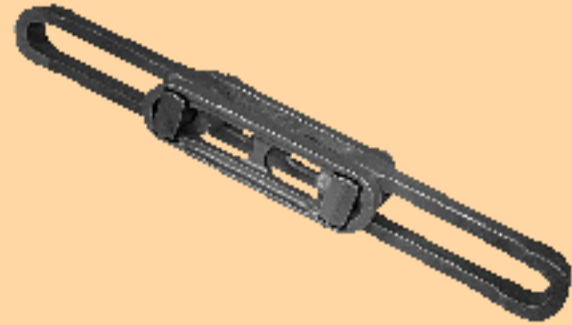




# CAST MANGANESE STEEL RIVETLESS CHAIN

Allied-Locke Rivetless Chain is a patented design with many industrial applications. This chain is cast by the shell mold process to ensure buyers of a sound casting with an extraordinarily smooth surface finish and excellent fit. The unique side bar design contributes significantly to the life and strength of the chain by providing additional surface contact area and offering protection to the pin head. Other design features include easy assembly and a simplified method of adding the various attachments which are described on the pages immediately following. Coupling pins are available for simplifying the installation of long chain strands.



CHAIN NO.	PITCH IN INCHES A	AVER. WEIGHT PER FT. IN LBS.	AVERAGE ULTIMATE STRENGTH IN LBS.	RECOM. WORKING LOAD IN LBS.	DIMENSIONS IN INCHES							
					B	C	D	E	F	G	H	J
678	6.031	7.5	95,000	8,900	1 <sup>5</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>16</sub>	7 <sup>8</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>16</sub>
698	6.031	13.5	145,000	13,000	1 <sup>9</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>5</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>4</sub>	3 <sup>7</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>16</sub>
998	9.031	10.5	145,000	24,000	1 <sup>9</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>5</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>4</sub>	3 <sup>7</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>16</sub>
9118	9.031	17.5	230,000	36,000	2 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	3	1 <sup>1</sup> / <sub>2</sub>	3 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>

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... the company that delivers

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# CAST MANGANESE STEEL RIVETLESS CHAIN



## Cast Manganese Steel Rivetless Chain with Attachments

### PLAIN CHAIN



## For Coal Preparation and Sliding Chain Applications

**11%-14% Manganese Steel . . .**  
Manganese Steel work hardens to provide greater wear life in coal processing applications.

**27% Greater Surface Contact Area . . .**  
Compared to drop forged rivetless chain.

**2% chrome to resist corrosion.**

### DIMENSIONS (INCHES) AND WEIGHTS

ALLIED-LOCKE CHAIN NUMBER	ALLIED-LOCKE PART NUMBER	APPROX. LINKS IN 10 FT.	AVG. PITCH INCHES	RECOM. WORKING LOAD LBS.	WIDTH OVERALL A	HEIGHT OF SIDEBAR F	SIDEBAR THICKNESS EE	DIAMETER OF PIN G	WIDTH OF LINK J	BETWEEN SIDEBARS K	OPENING IN LINK S	LENGTH OF FLAT ON LINK Y	WEIGHT PER FOOT, LBS.
678	29001	20	6.031	8,500	3 <sup>3</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>16</sub>	7 <sup>3</sup> / <sub>8</sub>	1 <sup>5</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>8</sub>	1 <sup>5</sup> / <sub>16</sub>	3 <sup>25</sup> / <sub>32</sub>	7.5
698	29002	20	6.031	13,000	3 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	3 <sup>21</sup> / <sub>32</sub>	13.5
998	29003	13 <sup>1</sup> / <sub>3</sub>	9.031	13,000	3 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	6 <sup>3</sup> / <sub>16</sub>	10.5
9118	29004	13 <sup>1</sup> / <sub>3</sub>	9.031	22,000	4 <sup>7</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>8</sub>	1 <sup>5</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	6 <sup>3</sup> / <sub>16</sub>	17.5

NOTE: Dimensions subject to change. Certified dimensions of ordered material furnished on request.

### CHAIN ATTACHMENTS

Allied-Locke provides the most complete line of attachments for the Rivetless Chain. Coupler pins for simplifying installation are also available.

#### EXTENDED PINS

#### D1, D2, D3, D4, D5, D6, D7, D8, D9, D10, D11

	678			698			998			9118	
	D4	D5	D6	D7	D8	D9	D7	D8	D9	D10	D11
G (Diameter)	7 <sup>3</sup> / <sub>8</sub>	7 <sup>3</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>	7 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	7 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>8</sub>
L (Length)	1 <sup>1</sup> / <sub>2</sub>	2	1 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>4</sub>	2	2
Wgt (Lbs.)	1.0	1.1	1.1	1.5	1.7	2.0	1.5	1.7	2.0	2.9	3.6

Extended pins can be finished (a) plain, (b) plain, with hole and collar, (c) threaded with orifice, collar, and castle nut. Extended lengths listed are maximum; shorter lengths (by cutting off) can be finished at slight additional charge. D1 thru D11 listed above are threaded national coarse thread supplied with lock washer and heavy hex nut.

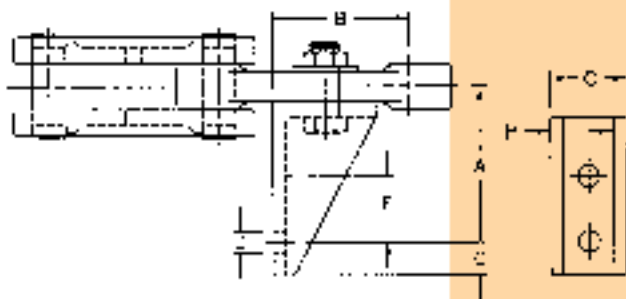
Allied-Locke Industries Inc.  
... reach for the star of quality  
[www.alliedlocke.com](http://www.alliedlocke.com)

Segmental sprockets are available with cast manganese steel teeth and cast or fabricated steel bodies.

Teeth can easily be replaced without removing the chain from sprockets.



# CAST MANGANESE STEEL RIVETLESS CHAIN



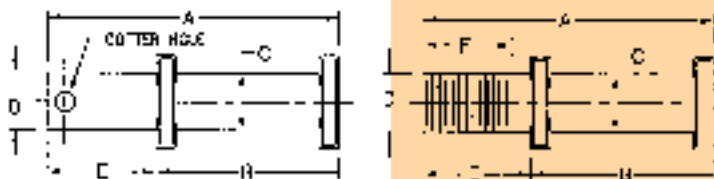
## S22

ALLIED-LOCKE CHAIN NUMBER	ALLIED-LOCKE PART NUMBER	E	D*	F	H	B	C	T	WEIGHT EA., LBS.
S22 STYLE 1									
078	29001	2 <sup>31</sup> / <sub>32</sub>	5/8	1 <sup>13</sup> / <sub>16</sub>	4 <sup>15</sup> / <sub>16</sub>	4 <sup>11</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>4</sub>	5/16	4.7**
098	29002	3 <sup>9</sup> / <sub>32</sub>	3/4	2 <sup>3</sup> / <sub>8</sub>	6 <sup>5</sup> / <sub>8</sub>	4 <sup>1</sup> / <sub>4</sub>	5 <sup>3</sup> / <sub>8</sub>	1/2	9.8**
998	29003	3 <sup>9</sup> / <sub>32</sub>	3/4	2 <sup>3</sup> / <sub>8</sub>	6 <sup>7</sup> / <sub>8</sub>	7 <sup>1</sup> / <sub>4</sub>	5 <sup>3</sup> / <sub>8</sub>	3/8	11.3**

\*Indicates diameter of hole, all holes are round and straight.

\*\* Including filler.

Ø Including filler Nook.



## EXTENDED PINS

CHAIN NO.	PIN STYLE	WT. EA. LBS.	A	B	C	D	E	F
078	1	1.0	4 <sup>11</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	7/8	7/8	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>
078	1	1.1	5 <sup>3</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	7/8	7/8	2	1 <sup>3</sup> / <sub>4</sub>
078	1	1.1	5 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	7/8	3/4	1 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>
078	2	1.0	4 <sup>11</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	7/8	7/8	1 <sup>1</sup> / <sub>2</sub>	—
078	2	1.1	5 <sup>3</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	7/8	7/8	2	—
078	2	1.1	5 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	7/8	3/4	1 <sup>7</sup> / <sub>8</sub>	—
098 & 998	1	1.5	5 <sup>3</sup> / <sub>8</sub>	3 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	3/4	1 <sup>1</sup> / <sub>2</sub>	1
098 & 998	1	1.7	5 <sup>3</sup> / <sub>8</sub>	3 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	7/8	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>
098 & 998	1	2.0	5 <sup>3</sup> / <sub>8</sub>	3 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>

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... chain - sprockets - buckets

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