永利百合 您的动力·我来传动

二十年专注研制链传动

输送链
Conveyor Chains

杭州永利百合控股集团有限公司
Hangzhou Unibear Holding Group Co. Ltd

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官方网站：www.unibear.com

German Technology
德国技术

企业简介 Company Introduction

杭州永利百合控股集团有限公司，始创于1995年，建筑面积22万多平方米，员工 1200余人，注册商标有UNIBEAR®、SLCC®、Oditer®和Odiking®。公司采用国际先进的生产设备和工艺技术，专注研发生产链条链轮，产品性能优越、品质稳定，通过ISO、ANSI、BS、DIN和JIS质量标准认证，获得“国家火炬计划项目”、“浙江省企业技术中心”和“浙江省创新型试点企业”等诸多荣誉。公司产品二十年来畅销于欧洲、美洲、日本、东南亚、中东及非洲市场等60多个国家，受到世界各地客户的广泛赞誉。

公司生产包括传动链、输送链、农机链、提升链、特殊用途链、不锈钢链、摩托车链、摩托车链轮等八大类型、五十多个系列、几千种规格的链传动产品，广泛应用于工业、农业、林业、矿山、冶金、筑路、石油、建材、轻工、造纸、家电、日化、食品、陶瓷、环保、车库等国民经济众多行业的机械作业。

永利百合将始终秉承“质量为本、创新为魂”的方针、“客户满意的产品”的质量承诺，以不断完善的研发生产和售后服务来满足更多国内外客户的需求。

Hangzhou Unibear Industrial Co. Ltd. was founded in 1995, occupying an overall floorage of 220,000 square meters, hiring more than 1200 employees. It has several registered trademarks like UNIBEAR®, SLCC®, Oditer® and Odiking®.

Unibear boasts itself of advanced production equipments and processing technology that are paralleled with international level. It has been all along dedicated to conducting research and development on all kinds of chains and sprockets. Its products excellently pass major international quality standards of ISO, ANSI, BS, DIN and JIS, due to their superior performance and stable quality. Furthermore, it was crowned several reputations such as "National Torch Program Project", "The Entrepreneurial Technology Center of Zhejiang Province" and "Innovation-oriented Pilot Enterprise of Zhejiang Province", etc.For 20 years along Unibear's products were prevailingly spread all over Europe, America, Japan, Southeast Asia, Middle East and Africa, etc, attaining broad compliments from various customers of the world.

Unibear's product line consists of thousands of chains with 8 categories over 50 series, like transmission chain, conveyor chain, agriculture chain, hoist chain, specialized chain, steel-stainless chain, motorcycle chain, motorcycle sprocket, etc. They are broadly applied to machinery operation in mass industries of manufacturing, agriculture, forestry, mining, metallurgy, road-paving, oil-exploring, architecture, light industry, papermaking, household appliance, commodity, Foods, ceramics, environmental protection, garage, and so on.

Unibear will persist in the principle of "Quality assurance-oriented, in the spirit of continuous innovation", and guarantee for "Products to satisfy customers" to meet the various demand from both domestic and overseas customers with improved R&D and production capability, as well as upgraded after-sales service.

发展历程 Development Course

1995 成立永利电器、专业生产链条零件

Establish YongLi Electric Appliance, specialized in producing chain components;

1999
- 更名为杭州永利百合实业有限公司、“永利百合/ UNIBEAR”商标全球注册
- 开始生产摩链、工业链、农机链、非标链等
- 建设国内一期厂房，成立检测中心及市技术研发中心
- Renamed as Hangzhou Unibear Industrial Co. Ltd, Unibear Chinese and English logo registered globally
- Begin the production of motorcycle chain, industry chain, agriculture chain and non-standardized chain, etc.
- Construct domestic 1st stage factory building; set up Inspection Center and Technology R&D Center

2004 建设国内二期厂房, 成立公司党支部, 职工文化家园建成

Construct domestic 2nd stage factory building; Found company's CPC party branch; Set up staff entertainment cente

2010
- 成立欧迪泰尔贸易公司，及百合汇酒庄
- 成立链轮及冷镦分厂
- Establish Oditer Trading Company, and Baihehui wine cellar
- Set up sprocket and cold-heading plant

2014
- 荣获“杭州出口名牌”称号
- 成立永利百合集团公司
- 曹永年董事长荣获第十届杭州市优秀企业家
- Crowned as “Famous Brand in Hangzhou Exports”
- Establish Unibear Holding Group
- Chairman Clive Cao titled as “The 10th Outstanding Entrepreneur in Hangzhou”

2015 建设国内三期厂房、立项为科创园

Construct domestic 3rd stage factory building, approved as the S&T innovation park

2016
- 成立新链轮、板式链、扶梯链车间
- 曹永年董事长荣获“爱心慈善家”称号
- Set up new plants for sprocket, leaf chains, escalator chains
- Chairman Clive Cao crowned as “The Philanthropist”

企业简介 Company Introduction

国家级省级权威资质
National & Provincial Authoritative Qualification

品牌商标类
Brand & Trademark Class

行业协会类
Industry Association Class

社会责任与荣誉
Social Responsibility & Honor

质量管理体系认证
Quality Management System

环境管理体系认证
Environment Management System

职业健康安全管理体系认证
Occupational Health and Safety Management System

全球销售网络 Global Sales Network

二十年来，公司产品出口到全球*60*多个国家，畅销于欧洲、美洲、日本、东南亚、中东及非洲市场，受到世界各地客户广泛赞誉。

For two decades, our products were imported to over 60 countries worldwide, prevailingly spread all over Europe, America, Japan, Southeast Asia, Middle East and Africa, etc. attaining broad compliments from various customers of the world.

全球OEM合作伙伴 Global OEM Partners

iwis antriebssysteme · JOHN DEERE · TOYOTA · HONDA · NEW HOLLAND AGRICULTURE · XIZI-IUK 西子石川岛

PRO TORK · WIPPERMANN · KettenWulf · FORTTE · DIAMOND CHAIN COMPANY · D.I.D

KANA · FEELER · FSCM · STANFORTHS · Pakistan Chain Center

销售产品性能优越 Superior Products

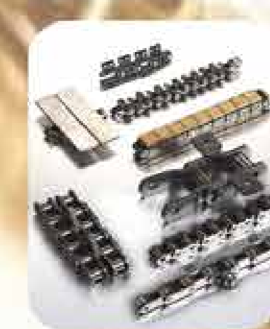
- 优质合金钢材料；
- 超耐磨长使用寿命；
- 更高抗拉和抗疲劳性能；
- 先进热处理和表面处理工艺；
- 链条100%预拉减少初期伸长率；
- 创新链轮“一次冲压成型”技术；
- Fine-quality alloy-steel material;
- Super wear-resistant and prolonged service life;
- Higher tensile strength and fatigue resistance;
- Advanced heat treatment and surface polishing technique;
- 100% pre-stretch, decreasing chain's elongation;
- Innovative sprocket fine blanking of "Once-Punch-Forming" technology;


传动链
Transmission Chain


输送链
Conveyor Chain


农机链
Agricultural Chain


提升链
Hoist Chain


特殊用途链
Specialized Chain


不锈钢链
Stainless Steel Chain


摩托车链
Motorcycle Chain


摩托车链轮
Motorcycle Sprocket

ADVANCED PRODUCTION EQUIPMENT
先进的生产设备


钢带 半成品仓库
Steel strip
Semi-finished products warehouse


200吨高速冲床
200T high speed press


自动切削机
Automatic pin cuting machine


布斯卷制车间
Bush-curling Workshop


全自动热处理(一厂)
Automatic mesh belt conveyor furnace
(Factory one)


全自动热处理(二厂)
Automatic mesh belt conveyor furnace
(Factory two)

日本进口慢走丝线割机
Japan-imported slow-feeding wire-cutting machine


数控车床
Digital controlled lathe


自动倒角机
Automatic chamfering machine


激光打标机
Laser marking machine


链轮-全自动数控高吨位精密冲床(1)
Sprocket - Automatic digital-controlled
large tonnage precise lathe(1)


链轮-全自动数控高吨位精密冲床(2)
Sprocket - Automatic digital-controlled
large tonnage precise lathe(2)

ADVANCED PRODUCTION EQUIPMENT
先进的生产设备

高速装配机
High speed assembling machine

缺零件检测
Inspetion of missing parts

全自动装配线
Automatic assembling line

高精度四方铆头机
Well-finished pin quad rivet machine

▲ 自动装配线流程图
AUTOMATIC ASSEMBLY LINE FLOW CHART

装配 ASSEMBLING → 铆头 RIVETING → 缺零件检测 INSPECTION OF MISSING PARTS → 预拉跑和 PRE-STRETCHING AND RUNNING → 上油 LUBRICATING → 数目 LINKS → 包装 PACKING

备注：1.预拉跑和，拉力达到链条拉力的50%，解决了链条初期的伸长；
Note: 1. Pre-stretching and running at 60% of the tensile strength, it solves the problem of elongation of the chain in the initial stage of use.
2.我司采用链条油脂为台湾进口JS003油脂，保证了耐磨效果；
2. We use the grease JS003 from Taiwan which guarantees the wear-resistance of the chain

EXCELLENT TESTING DEVICES
完善的检测设备

检验中心
Testing Center

化学分析台
Chemical analysis platform

碳硫微机自动分析仪/分 光光度计
Material chemical analysis machine
Material chemical tester

金相显微镜
Metalloscope

HV-5 维氏硬度hardness tester

全自动显微维氏硬度计
Microh

EXCELLENT TESTING DEVICES

完善的检测设备

邵氏(橡胶)硬度计
Shore (Rubber) hardness tester

HV-1显微维氏硬度计
HV-1 Micro-Vickers hardness tester

喷丸强度测量仪
Shot peening strength tester

链条扭曲测量仪
Chain twist testing machine

200KN高频疲劳试验机
200KN high frequency fatigue testing machine

50KN压出力试验机
50KN Press-outforce tester

表面粗糙度测量仪
Surface roughness tester

数显碳硫自动分析仪
Carbon sulfur automatic analyzer
金相预磨机
Metallographic pre-grinding machine

金相抛光机
Metallographic polishing machine

数显链条测量仪
Instrument for measuring chain length

液压万能试验机
Hydraulic universal material testing machine

200KN材料拉力试验机
200KN material tensile strength testing machine

投影仪
Profile projector

影像测量仪
Image measuring instrument

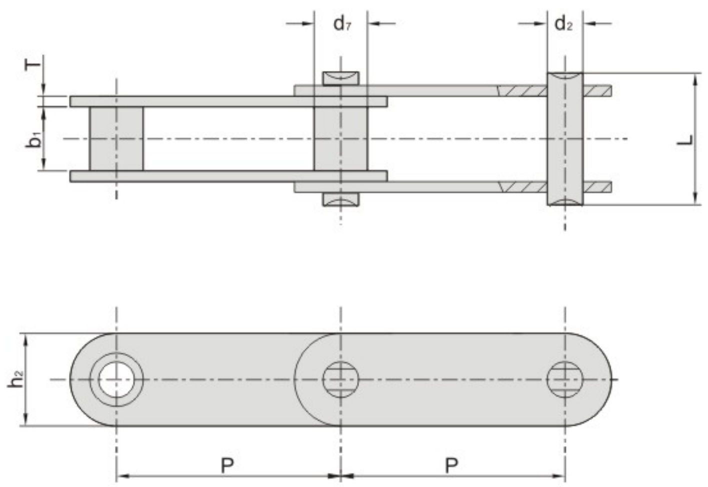
大型摄像金相显微镜
Large scale photographic metalloscop

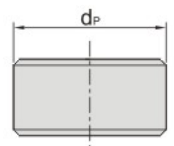
直读光谱仪
Spectromax

链条中速磨损实验机
Mid-speed chain abrasion testing machine

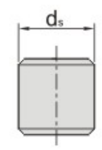
盐雾试验机
Mid-speed chain abrasion testing machine

FV型输送链
FV TYPE CONVEYOR CHAINS

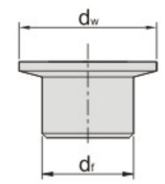




P型滚子
P type roller



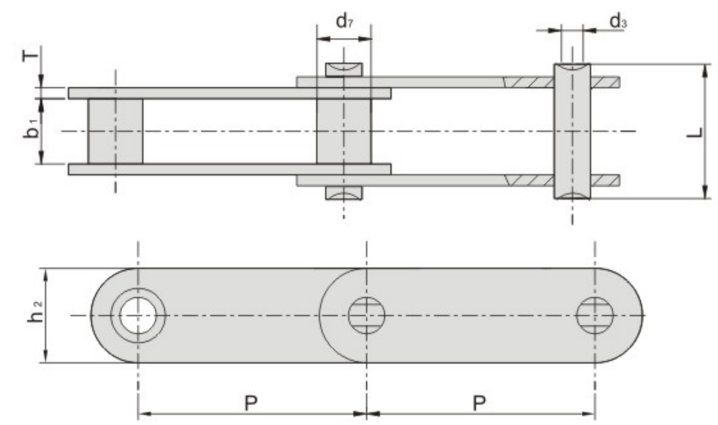
S型滚子
S type roller

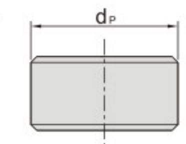


F型滚子
F type roller

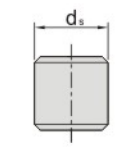
永利百合链号 UNIBear Chain No.	节距 Pitch	内节内宽 Width between inner plates	套筒直径 Bush diameter	销轴尺寸 Pin dimensions		链板尺寸 Plate dimensions		滚子尺寸 Roller dimensions			极限拉伸载荷 Ultimate tensile strength
	P	b_1 min	d_7 max	d_2 max	L max	h_2 max	T	d_s max	d_P/d_f max	dw max	Q min
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	KN
FV 40	40 63 100	18	15	10	37	26	3.0	20	32/40	48	40
FV 63	63 100 125 160	22	18	12	46	30	4.0	26	40/50	60	63
FV 90	63 100 125 160 200 250	25	20	14	53	35	5.0	30	48/63	73	90
FV 112	100 125 160 200 250	30	22	16	63	40	6.0	32	55/72	87	112
FV 140	100 125 160 200 250 315	35	26	18	68	45	6.0	36	60/80	95	140

FV型输送链
FV TYPE CONVEYOR CHAINS

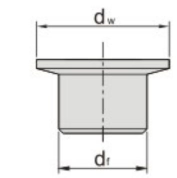




P型滚子
P type roller



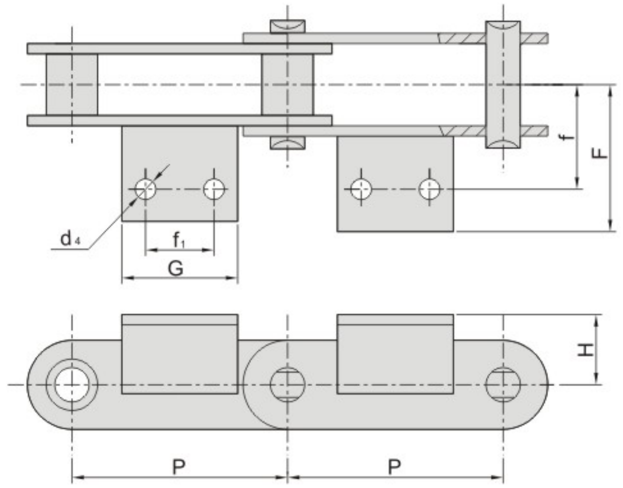
S型滚子
S type roller



F型滚子
F type roller

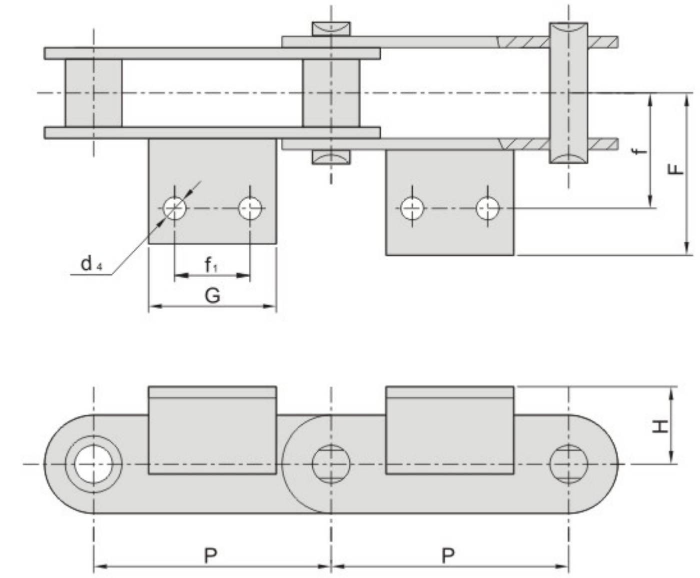
永利百合链号 UNIBear Chain No.	节距 Pitch	内节内宽 Width between inner plates	套筒直径 Bush diameter	销轴尺寸 Pin Dimensions		链板尺寸 Plates dimensions		滚子尺寸 Roller dimensions			极限拉伸载荷 Ultimate tensile strength
	P	b_1 min	d_7 max	d_2 max	L max	h_2 max	T	d_s max	d_P/d_f max	dw max	Q min
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	KN
FV 180	125 160 200 250 315 400	45	30	20	86	50	8.0	42	70/100	120	180
FV 250	125 160 200 250 315 400	55	36	26	98	60	8.0	50	80/125	145	250
FV 315	160 200 250 315 400	65	42	30	117	70	10.0	60	90/140	170	315
FV 400	160 200 250 315 400	70	44	32	131	70	12.0	60	100/150	185	400
FV 500	160 200 250 315 400	80	50	36	141	80	12.0	70	110/160	195	500
FV 630	200 250 315 400	90	56	42	153	100	12.0	80	120/170	210	630

FV型输送链附件
FV TYPE CONVEYOR CHAIN ATTACHMENTS



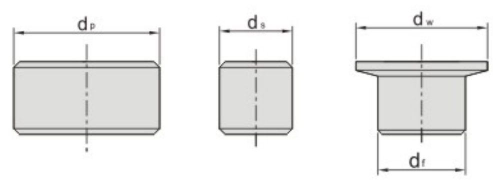
永利百合链号 UNIBear Chain No.	节距 Pitch	附件尺寸 Attachment dimension						角铁尺寸 Angle iron dimension	极限拉伸载荷 Ultimate tensile strength
	P	f	F	f_1	G	H	d_4		Q min
	mm	mm	mm	mm	mm	mm	mm	mmxmmxmm	KN
FV 40	40	25	50			20	6.0		40
	63				31				
	100			30	50				
FV 63	63	34	50		40	30	9.0	30X30X3	63
	100			30	50				
	125			40	60				
	160			50	70				
FV 90	63	40	65			35	9.0	40X40X4	90
	100			30	50				
	125			40	60				
	160			50	70				
	200			60	80				
	250			65	85				
FV 112	100	50	69	30	50	40	11	40X40X5	112
	125			40	65				
	160			50	75				
	200			65	90				
	250			80	105				
FV 140	100	50	80	30	55	45	11	50X50X5	140
	125			40	65				
	160			50	75				
	200			65	90				
	250			80	105				
	315			100	125				
FV 180	125	64	90	35	65	45	14	50X50X6	180
	160			50	80				
	200			65	95				
	250			80	110				
	315			100	130				
	400			100	130				

FV型输送链附件
FV TYPE CONVEYOR CHAIN ATTACHMENTS

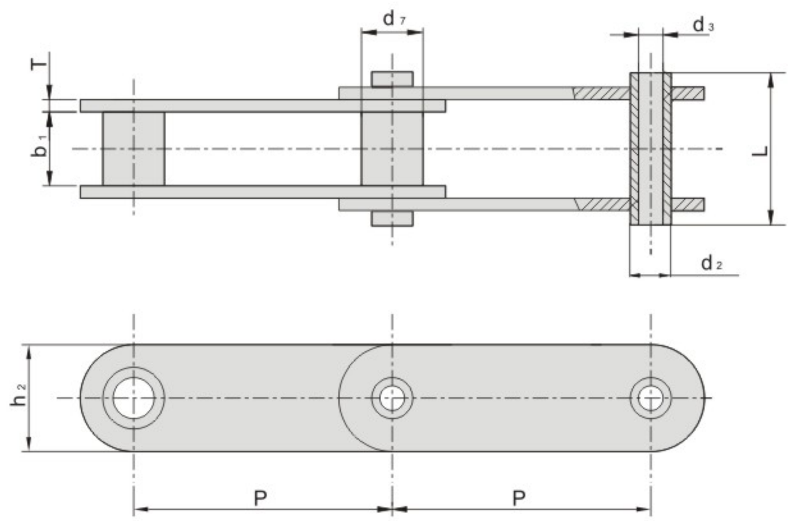


永利百合链号 UNIBear Chain No.	节距 Pitch	附件尺寸 Attachment dimension						角铁尺寸 Angle iron dimension	极限拉伸载荷 Ultimate tensile strength
	P	f	F	f_1	G	H	d_4		Q min
	mm	mm	mm	mm	mm	mm	mm	mmxmmxmm	KN
FV 250	125	69	110		50	55	14	65X65X7	250
	160			50	80				
	200			65	95				
	250			80	110				
	315			100	130				
	400			100	130				
FV 315	160	85	130		58	60	14	70X70X9	315
	200			65	95				
	250			80	110				
	315			100	130				
	400			100	130				
FV 400	160	95	145		50	65	18	80X80X10	400
	200			60	100				
	250			80	120				
	315			100	140				
	400			100	140				
FV 500	160	100	150		50	70	18	80X80X10	500
	200			50	100				
	250			80	120				
	315			100	140				
	400			100	140				
FV 630	200	115	175		50	80	18	100X100X10	630
	250			70	110				
	315			100	140				
	400			100	140				
	500			100	140				

FV型空心销轴输送链
FV TYPE HOLLOW PIN CONVEYOR CHAINS

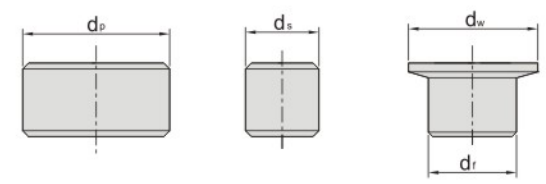


P型滚子 P type roller　S型滚子 S type roller　F型滚子 F type roller

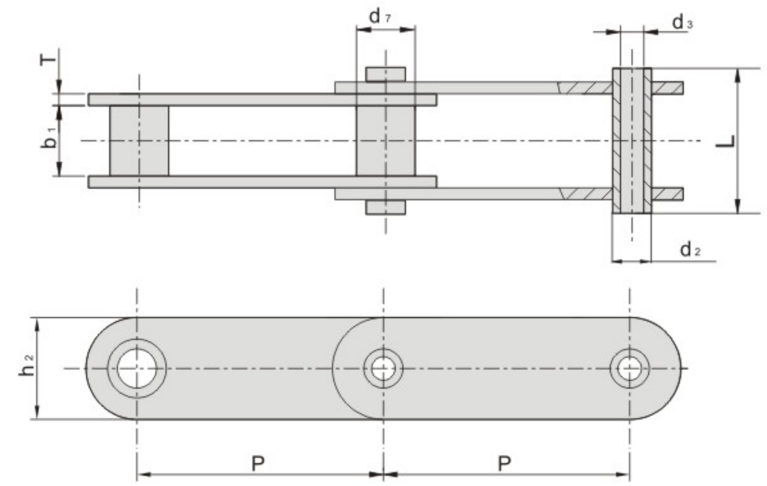


永利百合链号 UNIBear Chain No.	节距 Pitch P mm	内节内宽 Width between inner plates b₁ min mm	空心销轴尺寸 Hollow pin dimensions d_2 max mm	d_3 min mm	L max mm	套筒直径 Bush diameter d_7 max mm	滚子直径 Roller diameter d_s max mm	d_p max mm	d_f max mm	d_w max mm	链板尺寸 Plates dimensions h_2 max mm	T mm	极限拉伸载荷 Ultimate tensile strength Q min KN
FV63	63 100 125 160	22	12	8.2	46	18	26	40	50	60	30	4.0	46
FV 90	63 100 125 160 200 250	25	14	10.2	53	20	30	48	63	73	35	5.0	73
FV 112	100 125 160 200 250	30	16	11.2	63	22	32	55	72	87	40	6.0	90
FV 140	100 125 160 200 250 315	35	18	12.2	68	26	36	60	80	95	45	6.0	110
FV180	125 160 200 250 315 400	45	20	14.2	86	30	42	70	100	120	50	8.0	145

FV型空心销轴输送链
FV TYPE HOLLOW PIN CONVEYOR CHAINS

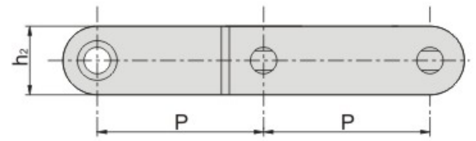


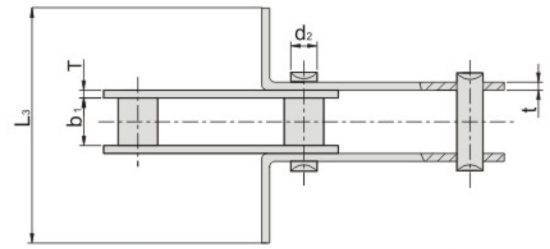
P型滚子 P type roller　S型滚子 S type roller　F型滚子 F type roller



永利百合链号 UNIBear Chain No.	节距 Pitch P mm	内节内宽 Width between inner plates b₁ min mm	空心销轴尺寸 Hollow pin dimensions d_2 max mm	d_3 min mm	L max mm	套筒直径 Bush diameter d_7 max mm	滚子直径 Roller diameter d_s max mm	d_p max mm	d_f max mm	d_w max mm	链板尺寸 Plates dimensions h_2 max mm	T mm	极限拉伸载荷 Ultimate tensile strength Q min KN
FV250	125 160 200 250 315 400	55	26	18.2	98	36	50	80	125	145	60	8.0	215
FV 315	160 200 250 315 400	65	30	20.2	117	42	60	90	140	170	70	10.0	290
FV 400	160 200 250 315 400	70	32	22.2	131	44	60	100	150	185	70	12.0	300
FV 500	160 200 250 315 400	80	36	26.2	141	50	70	110	160	195	80	12.0	440
FV630	200 250 315 400	90	42	30.2	153	56	80	120	170	210	100	12.0	520

FV型刮板输送链
FV TYPE SCRAPER CONVEYOR CHAINS

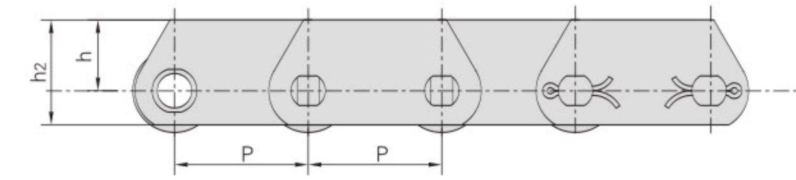


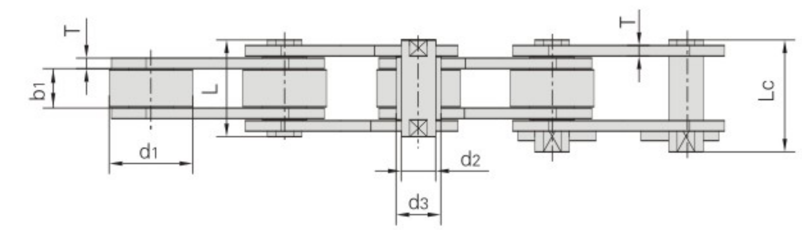


永利百合链号 UNIBear Chain No.	节距 Pitch P mm	内节内宽 Width between inner plates b1 min mm	销轴直径 Pin diameter d2 max mm	链板高度 Plate depth h2 max mm	链板厚度 Plate thickness T mm	链板厚度 Plate thickness t mm	极限拉伸载荷 Ultimate tensile strength Q min KN
FV 40	40 63 100	18	10	26	3	3	40
FV 63	63 100 125 160	22	12	30	4	4	63
FV 90	63 100 125 160 200 250	25	14	35	5	5	90
FV 112	100 125 160 200 250	30	16	40	6	6	112
FV 140	100 125 160 200 250 315	35	18	45	6	6	140
FV 180	125 160 200 250 315 400	45	20	50	8	8	180
FV 250	125 160 200 250 315 400	55	26	60	8	8	250
FV 315	160 200 250 315 400	65	30	70	10	10	315

刮板尺寸L_3按客户要求制作。 Scraper dimension L_3 can be made according to the customer's requirements.

FVT型输送链
FVT TYPE CONVEYOR CHAINS



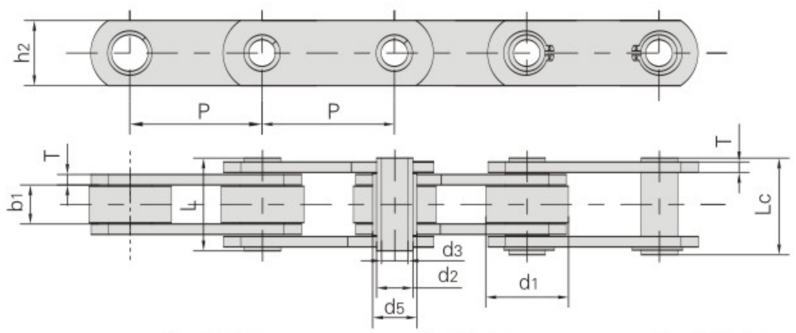


DIN 链号 DIN Chain No.	节距 Pitch P mm							滚子直径 Roller diameter d1 max mm	销轴直径 Pin diameter d2 max mm	套筒直径 Bush diameter d3 max mm	链板厚度 Plate thickness T max mm
FVT40	50.0	63.0	80.0	100.0	125.0			32.0	10.0	15.0	3.0
FVT63	63.0	80.0	100.0	125.0	160.0			40.0	12.0	18.0	4.0
FVT90	63.0	80.0	100.0	125.0	160.0	200.0	250.0	48.0	14.0	20.0	5.0
FVT112	100.0	125.0	160.0	200.0	250.0			55.0	16.0	22.0	6.0
FVT140	100.0	125.0	160.0	200.0	250.0			60.0	18.0	25.0	6.0
FVT180	125.0	160.0	200.0	250.0	315.0			70.0	20.0	30.0	8.0
FVT250	160.0	200.0	250.0	315.0				80.0	26.0	36.0	8.0
FVT315	160.0	200.0	250.0	315.0	400.0			90.0	30.0	42.0	10.0

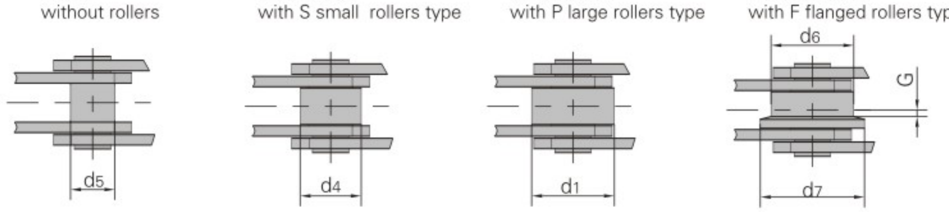
DIN 链号 DIN Chain No.	内节内宽 Width between inner plates b1 min mm	销轴长度 Pin length L max mm	销轴长度 Pin length Lc max mm	链板高度 Plate depth h2 max mm	链板高度 Plate depth h max mm	极限拉伸载荷 Ultimate tensile strength Q min KN	极限拉伸载荷 Ultimate tensile strength *Q min KN
FVT40	18.0	36.0	39.0	35.0	22.5	40.0	47.0
FVT63	22.0	45.0	48.5	40.0	25.0	63.0	75.0
FVT90	25.0	53.0	56.5	45.0	27.5	90.0	115.0
FVT112	30.0	62.0	66.0	50.0	30.0	112.0	170.0
FVT140	35.0	67.0	71.5	60.0	37.5	140.0	180.0
FVT180	45.0	86.0	92.0	70.0	45.0	180.0	250.0
FVT250	55.0	97.0	103.5	80.0	50.0	250.0	300.0
FVT315	65.0	113.0	126.5	90.0	55.0	315.0	480.0

＊Q表示链板要热处理
＊Q Higher breaking load with hardened plates

FVC型空心销轴输送链
FVC TYPE HOLLOW PIN CONVEYOR CHAINS



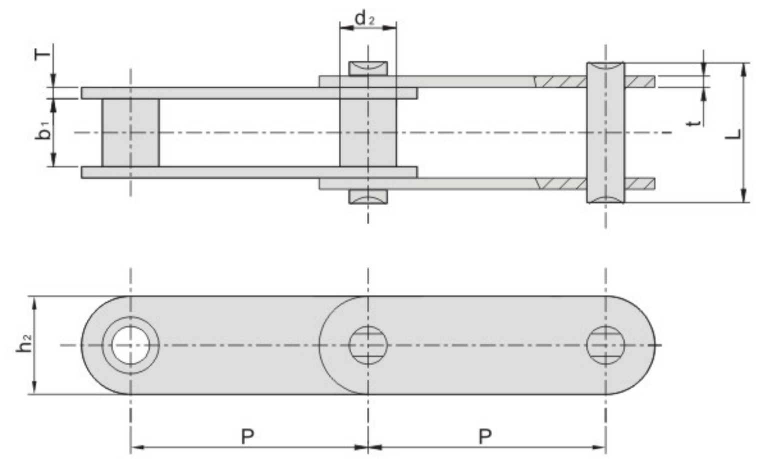
无滚子 without rollers | 带S型小滚子 with S small rollers type | 带P型大滚子 with P large rollers type | 带F型带肩滚子 with F flanged rollers type

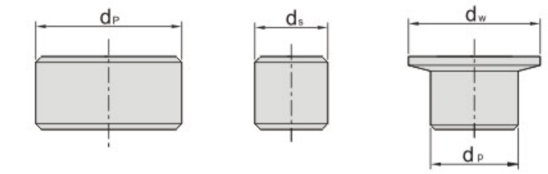


DIN 链号 DIN Chain No.	节距 Pitch							滚子尺寸 Roller dimension				
	P							d1 max	d4 max	d6 max	d7 max	G
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
FVC63	63.0	80.0	100.0	125.0	160.0			40.0	26.0	50.0	63.0	5.0
FVC90	63.0	80.0	100.0	125.0	160.0	200.0	250.0	48.0	30.0	63.0	78.0	6.5
FVC112	100.0	125.0	160.0	200.0	250.0			55.0	32.0	72.0	90.0	7.5
FVC140	100.0	125.0	160.0	200.0	250.0			60.0	36.0	80.0	100.0	9.0
FVC180	125.0	160.0	200.0	250.0	315.0			70.0	42.0	100.0	125.0	13.0
FVC250	160.0	200.0	250.0	315.0	400.0			80.0	50.0	125.0	155.0	15.0
FVC315	160.0	200.0	250.0	315.0	400.0			90.0	60.0	140.0	175.0	18.0

DIN 链号 DIN Chain No.	内节内宽 Width between inner plates	销轴直径 Pin diameter		套筒直径 Bush diameter	销轴长度 Pin length		链板厚度 Plate thickness	链板高度 Plate depth	极限拉伸载荷 Ultimate tensile strength
	b1 min	d2 max	d3 min	d5 max	L max	Lc max	T max	h2 max	Q min
	mm	mm	mm	mm	mm	mm	mm	mm	KN
FVC63	22.0	12.0	8.0	18.0	45.0	50.5	4.0	30.0	46.0
FVC90	25.0	14.0	10.0	20.0	53.0	56.5	5.0	35.0	73.0
FVC112	30.0	16.0	11.0	22.0	62.0	63.0	6.0	40.0	90.0
FVC140	35.0	18.0	12.0	26.0	67.0	68.5	6.0	45.0	110.0
FVC180	45.0	20.0	14.0	30.0	86.0	88.0	8.0	50.0	145.0
FVC250	55.0	26.0	18.0	36.0	97.0	103.5	8.0	60.0	215.0
FVC315	65.0	30.0	20.0	42.0	117.0	121.5	10.0	70.0	295.0

M型输送链
M TYPE CONVEYOR CHAINS

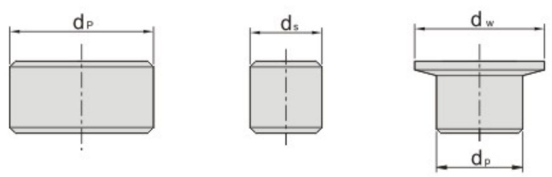




P型滚子 P type roller | S型滚子 S type roller | F型滚子 F type roller

永利百合链号 UNIBear Chain No.	节距 Pitch	内节内宽 Width between inner plates	套筒直径 Bush diameter	销轴尺寸 Pin dimensions		链板尺寸 Plates dimensions		滚子尺寸 Roller dimensions			极限拉伸载荷 Ultimate tensile strength
	P	b_1 min	d_7 max	d_2 max	L max	h_2 max	t/T	ds max	d_P max	dw max	Q min
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	KN
M20	40 50 63 80 100	16.0	9.0	6.0	35.0	18.0	2.5	12.5	25.0	30.0	20
M28	63 80 100 125 160	18.0	10.0	7.0	40.0	20.0	3.0	15.0	30.0	36.0	28
M40	63 80 100 125 160	20.0	12.5	8.5	45.0	25.0	3.5	18.0	36.0	42.0	40
M56	63 80 100 125 160	24.0	15.0	10.0	52.0	30.0	4.0	21.0	42.0	50.0	56
M80	80 100 125 160 200 250 315	28.0	18.0	12.0	62.0	35.0	5.0	25.0	50.0	60.0	80

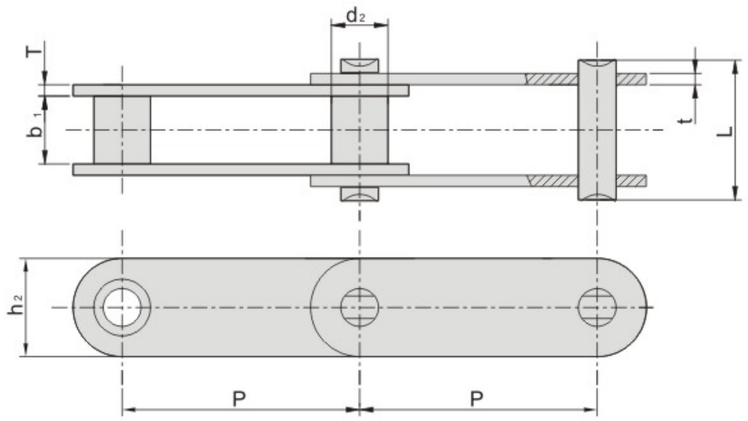
M型输送链
M TYPE CONVEYOR CHAINS



P型滚子
P type roller

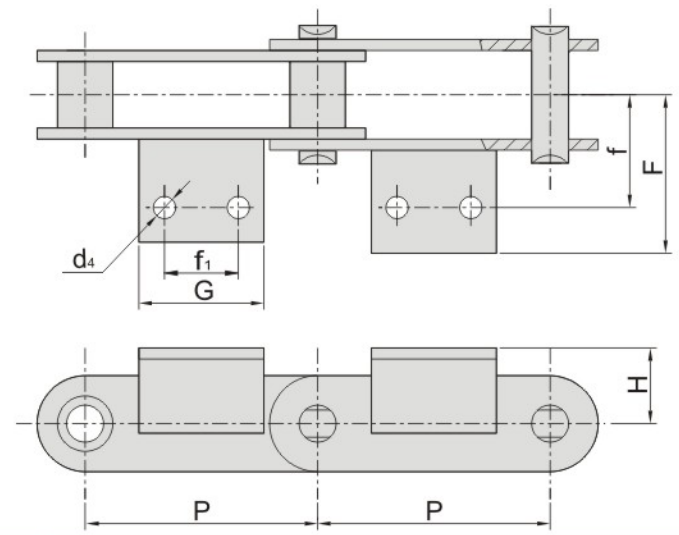
S型滚子
S type roller

F型滚子
F type roller



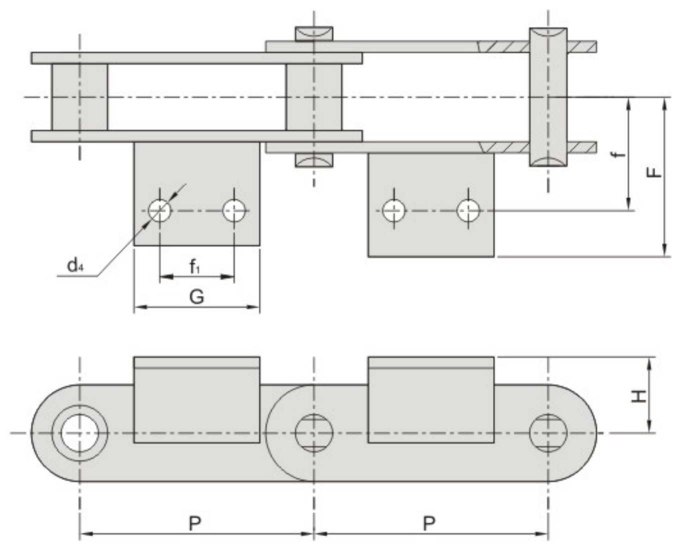
永利百合链号 UNIBear Chain No.	节距 Pitch P mm	内节内宽 Width between inner plates b_1 min mm	套筒直径 Bush diameter d_7 max mm	销轴尺寸 Pin dimensions d_2 max mm	销轴尺寸 Pin dimensions L max mm	链板尺寸 Plates dimensions h_2 max mm	链板尺寸 Plates dimensions t/T mm	滚子尺寸 Roller dimensions d_s max mm	滚子尺寸 Roller dimensions d_p max mm	滚子尺寸 Roller dimensions d_w max mm	极限拉伸载荷 Ultimate tensile strength Q min KN
M112	80	32	21	15	73	40	6.0	30	60	70	112
	100										
	125										
	160										
	200										
	250										
	315										
M160	100	37	25	18	85	50	7.0	36	70	85	160
	125										
	160										
	200										
	250										
	315										
	400										
M224	125	43	30	21	98	60	8.0	42	85	100	224
	160										
	200										
	250										
	315										
	400										
M315	160	48	36	25	112	70	10.0	50	100	120	315
	200										
	250										
	315										
	400										
M450	200	56	42	30	135	80	12.0	60	120	140	450
	250										
	315										
	400										
	500										
M630	250	66	50	36	154	100	14.0	70	140	170	630
	315										
	400										
	500										
M900	250	78	60	44	180	120	16.0	85	170	210	900
	315										
	400										
	500										

M型输送链附件
M TYPE CONVEYOR CHAIN ATTACHMENTS



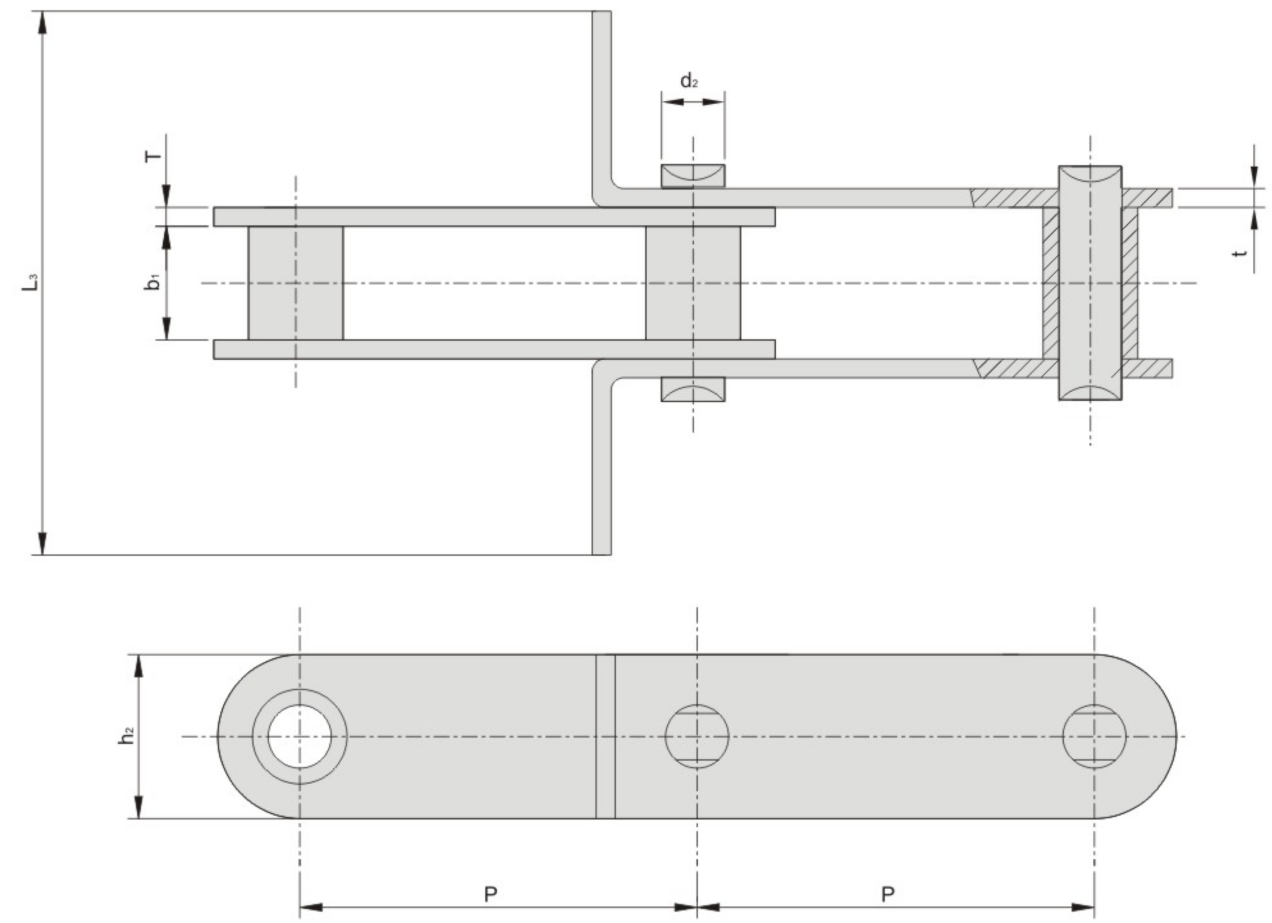
永利百合链号 UNIBear Chain No.	节距 Pitch P mm	附件尺寸 Attachment dimension f mm	F mm	f_1 mm	G mm	H mm	d_4 mm	角铁尺寸 Angle iron dimension mmxmmxmm	极限拉伸载荷 Ultimate tensile strength Q min KN
M20	40	27	42	*	14	16	6.6	25X25X3	20
	50			*	14				
	63			20	35				
	80			35	50				
	100			30	65				
M28	50	32	50	*	20	20	9.0	20X20X3	28
	63			*	20				
	80			25	45				
	100			40	60				
	125			65	85				
M40	63	35	56	*	20	25	9.0	30X30X3	40
	80			20	40				
	100			40	60				
	125			60	85				
	160			85	105				
M56	63	44	70	*	22	30	11	40X40X4	56
	80			*	22				
	100			25	50				
	125			50	75				
	160			85	110				
M80	80	48	80	*	22	35	11	40X40X4	80
	100			*	22				
	125			50	75				
	160			85	110				
	200			125	150				
	250			125	150				
	315			125	150				
M112	80	55	92	*	28	40	14	50X50X6	112
	100			*	28				
	125			35	65				
	160			65	95				
	200			100	130				
	250			100	130				
	315			100	130				

M型输送链附件
M TYPE CONVEYOR CHAIN ATTACHMENTS



永利百合链号 UNIBear Chain No.	节距 Pitch	附件尺寸 Attachment dimension						角铁尺寸 Angle iron dimension	极限拉伸载荷 Ultimate tensile strength
	P	f	F	f1	G	H	d4		Q min
	mm	mm	mm	mm	mm	mm	mm	mmxmmxmm	KN
M160	100	62	100	*	30	45	14	50X50X6	160
	125			*	30				
	160			50	80				
	200			85	115				
	250			145	175				
	315			145	175				
	400			145	175				
M224	125	70	114	*	35	55	18	60X60X8	224
	160			*	35				
	200			65	100				
	250			125	160				
	315			190	225				
	400			190	225				
M315	160	80	125	*	35	65	18	70X70X9	315
	200			50	85				
	250			100	135				
	315			155	190				
	400			155	190				
M450	200	90	140	*	40	75	18	70X70X9	450
	250			85	125				
	315			155	195				
	400			240	280				
	500			240	280				
M630	250	115	190	*	50	90	24	100X100X12	630
	315			100	150				
	400			190	240				
	500			300	350				
M900	250	140	240	*	60	110	30	120X120X15	900
	315			65	125				
	400			155	215				
	500			240	300				

M型刮板输送链
M TYPE SCRAPER CONVEYOR CHAINS



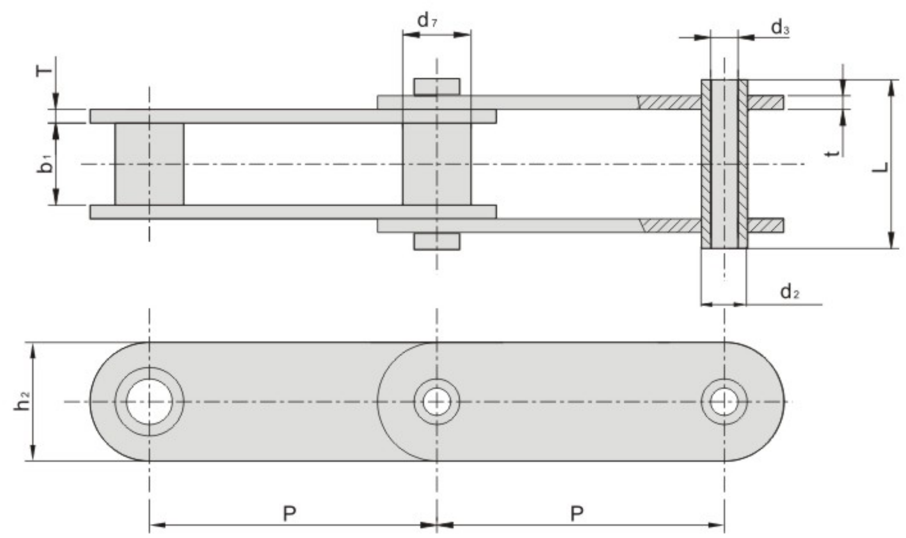
永利百合链号 UNIBear Chain No.	节距 Pitch	内节内宽 Width between inner plates	销轴直径 Pin diameter	链板高度 Plate depth	链板厚度 Plate thickness		极限拉伸载荷 Ultimate tensile strength
	P	b_1 min	d_2 max	h_2 max	T	t	Q min
	mm	mm	mm	mm	mm	mm	KN
M 56	63	24	10	30	4	4	56
	80						
	100						
	125						
	160						

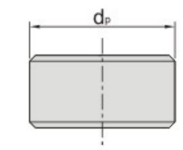
M型刮板输送链
M TYPE SCRAPER CONVEYOR CHAINS

永利百合链号 UNIBear Chain No.	节距 Pitch	内节内宽 Width between inner plates	销轴直径 Pin diameter	链板高度 Plate depth	链板厚度 Plate thickness		极限拉伸载荷 Ultimate tensile strength
	P	b_1 min	d_2 max	h_2 max	T	t	Q min
	mm	mm	mm	mm	mm	mm	KN
M 80	80	28	12	35	5	5	80
	100						
	125						
	160						
	200						
	250						
	315						
M 112	80	32	15	40	6	6	112
	100						
	125						
	160						
	200						
	250						
	315						
M 160	100	37	18	50	7	7	160
	125						
	160						
	200						
	250						
	315						
	400						
M 224	125	43	21	60	8	8	224
	160						
	200						
	250						
	315						
	400						
M 315	160	48	25	70	10	10	315
	200						
	250						
	315						
	400						

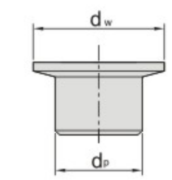
刮板尺寸L_3按客户要求制作。 Scraper dimension L_3 can be made according to the customer's requirements.

M型空心销轴输送链
M TYPE HOLLOW PIN CONVEYOR CHAINS





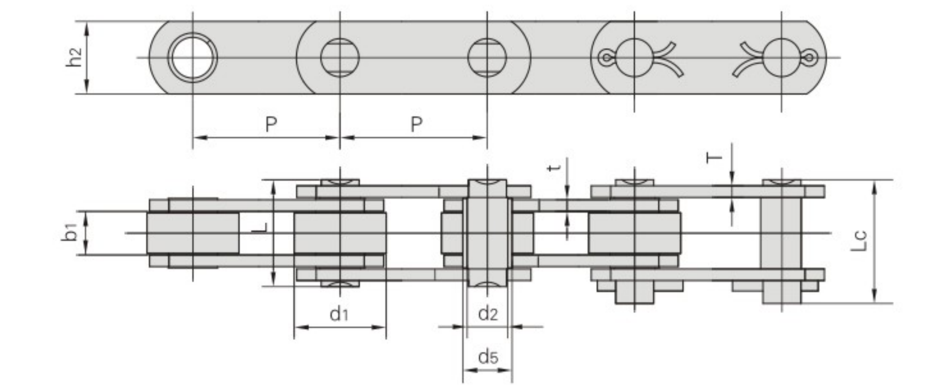
P型滚子
P type roller



F型滚子
F type roller

永利百合链号 UNIBear Chain No.	节距 Pitch	内节内宽 Width between inner plates	空心销轴尺寸 Hollow pin dimensions			套筒直径 Bush diameter	滚子直径 Roller diameter		链板尺寸 Plates dimensions		极限拉伸载荷 Ultimate tensile strength
	P	b_1 min	d_2 max	d_3 min	L max	d_7 max	d_p max	d_w max	h_2 max	t/T	Q min
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	KN
MC 28	63	22	13	8.2	40	17.5	25	30	25	3.0	28
	80										
	100										
	125										
	160										
MC 56	63	30	15.5	10.2	45	21	36	42	35	4.0	56
	80										
	100										
	125										
	160										
MC 112	80	32	22	14.3	64	29	60	70	50	6.0	112
	100										
	125										
	160										
	200										
	250										
	315										
MC 224	125	43	31	20.3	84	41	85	100	70	8.0	224
	160										
	200										
	250										
	315										
	400										

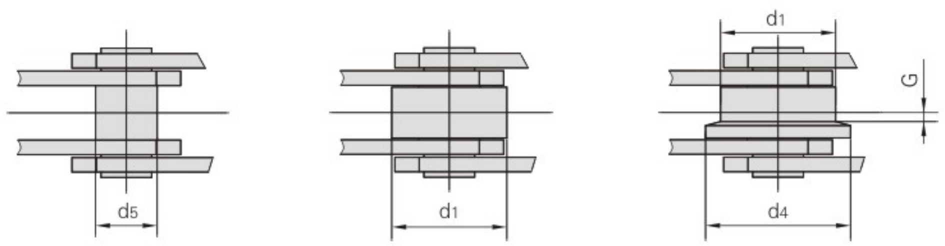
Z型输送链
Z TYPE CONVEYOR CHAINS



无滚子
without roller

带P型大滚子
With P type large roller

带F型带肩滚子
with F type langed roller

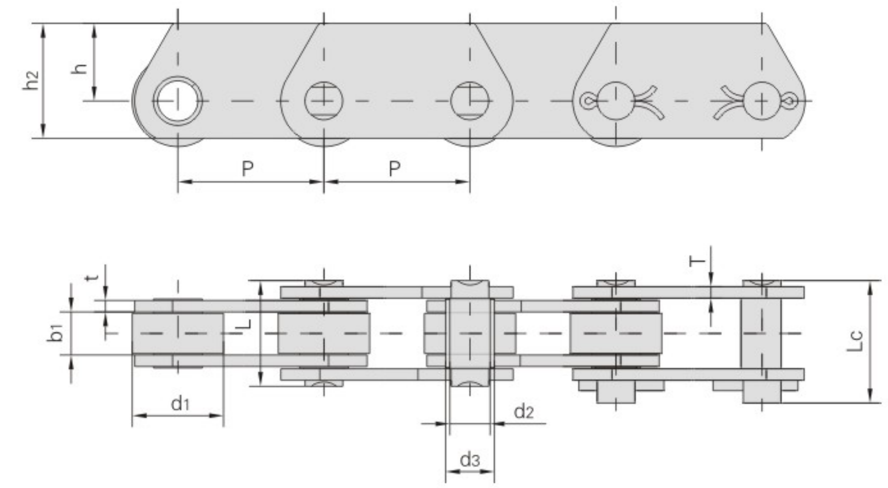


永利百合链号 UNIBER Chain No.	节距 Pitch							滚子尺寸 Roller dimension			套筒直径 Bush diameter
	P							d_1 max	d_4 max	G	d_5 max
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
Z40	50.8	63.5	76.2	88.9	101.6	127.0	152.4	31.75	40.0	2.5	17.0
Z100	76.2	88.9	101.6	127.0	152.4	177.8	203.2	47.50	60.0	3.5	23.0
Z160	101.6	127.0	152.4	177.8	203.2	228.6	254.0	66.70	82.0	3.5	33.0
Z300	152.4	177.8	203.2	254.0	304.8			88.90	114.0	8.5	38.0

永利百合链号 UNIBER Chain No.	内节内宽 Width between inner plates	销轴直径 Pin diameter	链板高度 Plate depth	销轴长度 Pin length		链板厚度 Plate thickness	破断载荷 Breaking load	
	b_1 min	d_2 max	h_2 min	L max	Lc max	t/T max	Q min	*Q min
	mm	mm	mm	mm	mm	mm	KN	KN
Z40	15.0	14.0	25.0	37.0	40.5	4.0	40.0	50.0
Z100	19.0	19.0	40.0	45.0	50.5	5.0/4.0	100.0	130.0
Z160	26.0	26.9	50.0	58.0	63.5	7.0/5.0	156.0	200.0
Z300	38.0	32.0	60.0	84.0	94.0	10.0/8.0	300.0	380.0

*Q表示链板要热处理
*Q Higher breaking load with hardened plates

ZE型输送链
ZE TYPE CONVEYOR CHAINS

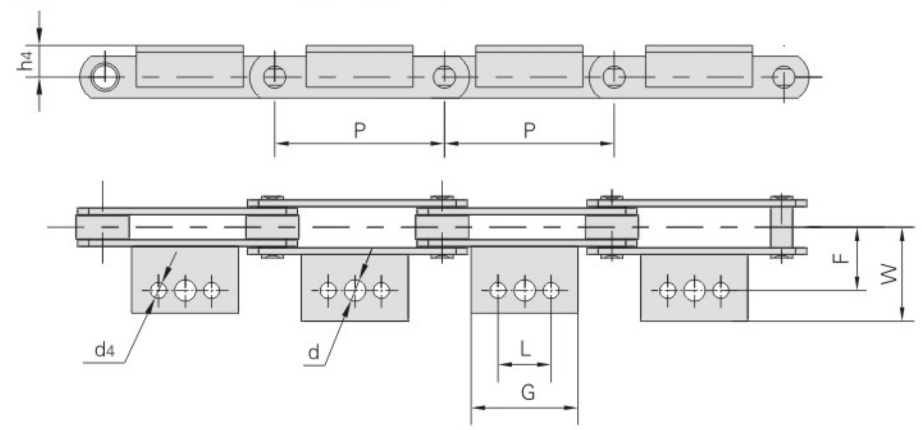


永利百合链号 UNIBER Chain No.	节距 Pitch							滚子直径 Roller diameter	销轴直径 Pin diameter	套筒直径 Bush diameter
	P							d_1 max	d_2 max	d_3 max
	mm							mm	mm	mm
ZE40	50.8	63.5	76.2	88.9	101.6	127.0	152.4	31.75	14.0	17.0
ZE100	76.2	88.9	101.6	127.0	152.4	177.8	203.2	47.50	19.0	23.0
ZE160	101.6	127.0	152.4	177.8	203.2	228.6	254.0	66.70	26.9	33.0
ZE300	152.4	177.8	203.2	254.0	304.8			88.90	32.0	38.0

永利百合链号 UNIBER Chain No.	内节内宽 Width between inner plates	销轴长度 Pin length		链板高度 Plate depth		链板厚度 Plate thickness	破断载荷 Breaking load	
	b_1 min	L max	Lc max	h_2 max	h max	t/T max	Q min	*Q min
	mm	mm	mm	mm	mm	mm	KN	KN
ZE40	15.0	37.0	40.5	40.0	27.0	4.0	40.0	60.0
ZE100	19.0	45.0	50.5	50.0	30.0	5.0/4.0	100.0	160.0
ZE160	26.0	58.0	63.5	70.0	45.0	7.0/5.0	160.0	200.0
ZE300	38.0	84.0	94.0	90.0	60.0	10.0/8.0	300.0	380.0

*Q表示链板要热处理
*Q Higher breaking load with hardened plates

Z型带附板输送链
Z TYPE CONVEYOR CHAIN WITH ATTACHMENTS



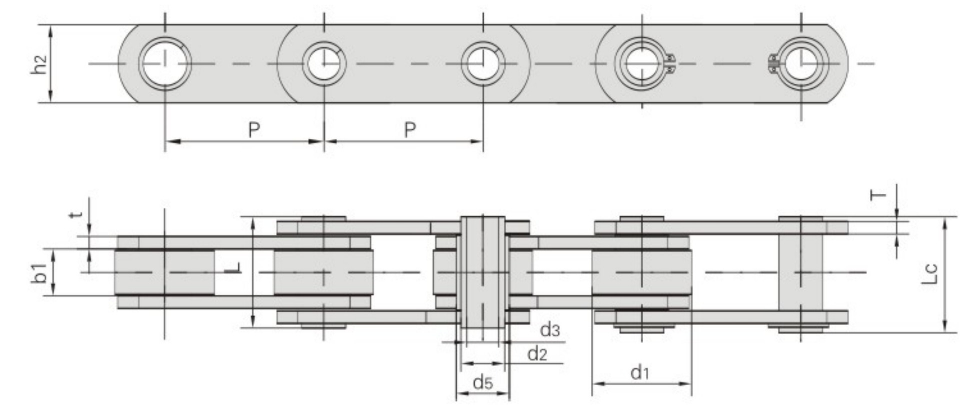
永利百合链号 UNIBER Chain No.		P mm	L mm	G mm	d mm	d4 mm	F mm	W mm	h4 mm
Z40	△	50.8	–	45.0	10.7	9.3	38.1	64.5	19.0
	△ ☆	63.5	22.2	43.0				56.0	
	△ ☆	76.2						68.0	
	▲	88.9	31.8	50.0				56.0	
	▲	101.6		64.0				55.0	
	▲	127.0	57.2	84.0				56.0	
	▲	152.4							
Z100	△	76.2	–	30.0	14.0	10.5	44.5	65.0	32.0
	△	88.9							
	▲	101.6	31.8	64.0					
	△ ☆	127.0	57.2	84.0					
	▲	152.4		114.5					
	△ ☆	177.8	80.0	110.0					
	△ ☆	203.2							
Z160	△	101.6	–	35.0	15.5	12.3	54.0	77.0	38.0
	△ ☆	127.0	31.7	56.0					
	△ ☆	152.4	57.2	84.0					
	△ ☆	177.8							
	△ ☆	203.2	100.0	130.0					
	△ ☆	228.6		150.0					
	△ ☆	254.0	135.0	170.0					
Z300	△	152.4	38.1	70.0	17.0	14.0	73.0	100.0	51.0
	△	177.8							
	△ ☆	203.2	76.2	100.0					
	△ ☆	254.0	90.0	152.4					
	△ ☆	304.8	190.0	225.0					

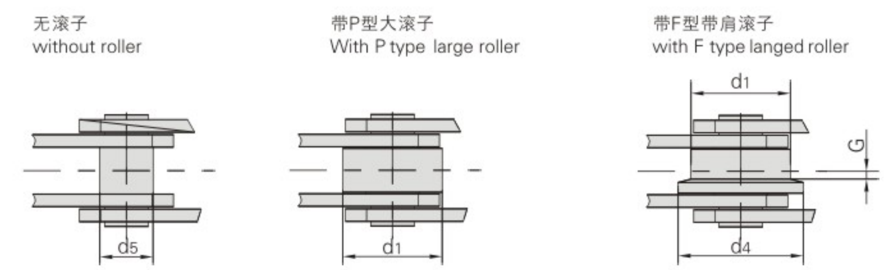
△表示附板带1个孔
△attachments with 1 hole

☆表示附板带2个孔
☆attachments with 2 holes

▲表示附板带3个孔
▲attachments with 3 holes

ZC型输送链
ZC TYPE CONVEYOR CHAINS



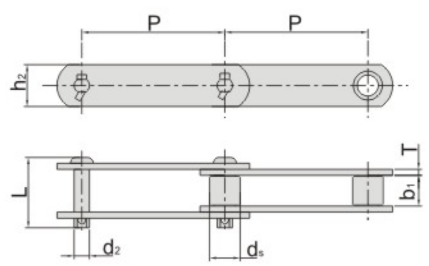


永利百合链号 UNIBER Chain No.	节距 Pitch P mm							滚子尺寸 Roller dimension d1 max mm	滚子尺寸 d4 max mm	滚子尺寸 G mm	套筒直径 Bush diameter d5 max mm	链板高度 Plate depth h2 max mm
ZC21	38.1	50.8	63.5	76.2				25.40			11.0	18.0
ZC40	50.8	63.5	76.2	88.9	101.6	127.0	152.4	31.75	40.0	2.5	17.0	25.0
ZC60	76.2	88.9	101.6	127.0	152.4	177.8	203.2	47.50	60.0	3.5	23.0	40.0
ZC150	101.6	127.0	152.4	177.8	203.2	228.6	254.0	66.70	82.0	4.0	33.0	50.0
ZC300	152.4	177.8	203.2	254.0	304.8			88.90	114.0	8.5	38.0	60.0

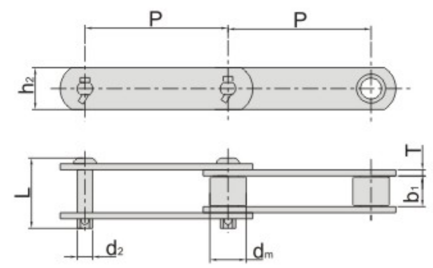
永利百合链号 UNIBER Chain No.	内节内宽 Width between inner plates b1 min mm	销轴直径 Pin diameter d2 max mm	销轴直径 Pin diameter d3 min mm	销轴长度 Pin length L max mm	销轴长度 Pin length Lc max mm	链板厚度 Plate thickness t/T max mm	破断载荷 Breaking load Q min KN	破断载荷 Breaking load *Q min KN
ZC21	12.7	9.0	6.5	26.0	27.5	2.5	21.0	
ZC40	15.0	14.0	10.2	36.4	37.7	4.0	40.0	50.0
ZC60	19.0	19.0	13.2	45.0	46.0	5.0/4.0	60.0	120.0
ZC150	26.0	26.9	20.2	58.0	60.5	7.0/5.0	150.0	190.0
ZC300	38.0	32.0	22.5	83.0	85.0	10.0/8.0	300.0	380.0

*Q表示链板要热处理
*Q Higher breaking load with hardened plates

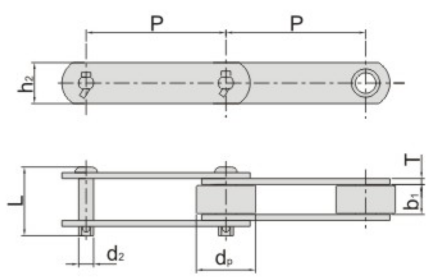
YS型输送链
YS TYPE CONVEYOR CHAINS



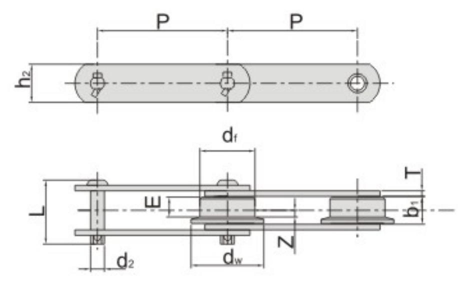
S 型滚子 S type roller



M 型滚子 M type roller



P 型滚子 P type roller

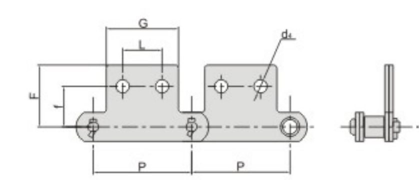


F 型滚子 F type roller

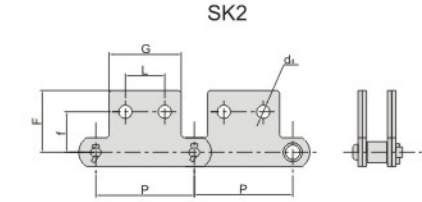
永利百合链号 UNIBear Chain No.	节距 Pitch P	滚子型式 Roller type	内节内宽 Width between inner plates b_1 min	销轴尺寸 Pin dimensions d_2 max	L max	链板尺寸 Plate Dimensions h_2 max	T max	滚子尺寸 Plates dimensions d_s max	d_m max	d_p max	d_f/d_w max	平均拉伸载荷 Ultimate tensile strength Q min
	mm		mm	mm	mm	mm	mm	mm	mm	mm	mm	KN
YS03075	75	S.P.F	16.1	8.0	38.0	22.0	3.2	15.9		31.8	31.8/42	29.0
YS03100	100	S.P.F										
YS05075	75	S	22.0	11.3	53.5	32.0	4.5	22.2		40.0	40/50	69.0
YS05100	100	S.P.F										
YS05150	150	S.P.F										
YS10100	100	S.P.M	30.0	14.5	69.0	38.1	6.3	29.0	31.8	50.8	50.8/65	113.0
YS10150	150	S.P.M.F										
YS12200	200	S.P.M.F	37.1	15.9	83.5	44.5	7.9	34.9	38.1	65.0	65/80	186.0
YS12250	250	S.P.M.F										
YS17200	200	S.P.M.F	51.4	19.1	109.5	50.8	9.5	40.1	44.5	80.0	80/100	245.0
YS17250	250	S.P.M.F										
YS17300	300	S.P.M.F										
YS26200	200	S.M	57.2	22.2	116.35	63.5	9.5	44.5	50.8	100.0	100/125	314.0
YS26250	250	S.P.M.F										
YS26300	300	S.P.M.F										
YS26450	450	S.P.M.F										
YS36250	250	S.M	66.7	25.4	146.0	76.3	12.7	50.8	57.2	125.0	125/150	475.0
YS36300	300	S.P.M.F										
YS36450	450	S.P.M.F										
YS36600	600	S.P.M.F										

YS型输送链附件
YS TYPE CONVEYOR CHAIN ATTACHMENTS

SA2

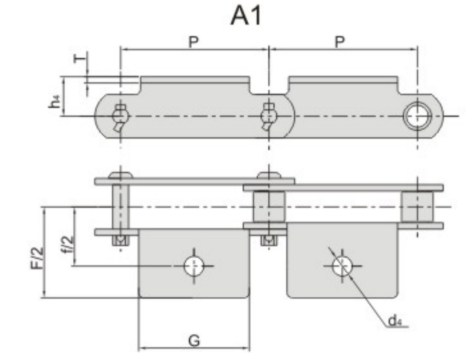


SK2

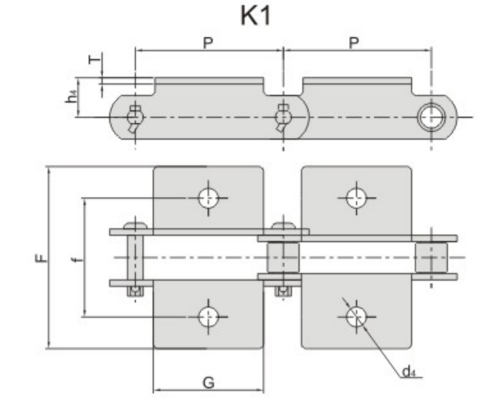


永利百合链号 UNIBear Chain No.	节距 Pitch P	滚子型式 Roller type	附件尺寸 Attachment dimensions f	F	G	L	T	d_3	使用螺栓 bolt
	mm		mm	mm	mm	mm	mm	mm	mm
YS03075	75	S.P	33.0	49.0	55	30	3.2	10	M8
YS03100	100	S.P			65	40			
YS05100	100	S.P	33.4	50.7	65	40	4.5	10	M8
YS05150	150	S.P			85	60			
YS10100	100	S.P.M	46.1	61.0	90	40	6.3	12	M10
YS10150	150	S.P.M			90	60			
YS12200	200	S.P.M	55.0	75.7	120	80	7.9	15	M12
YS12250	250	S.P.M			170	125			

A1



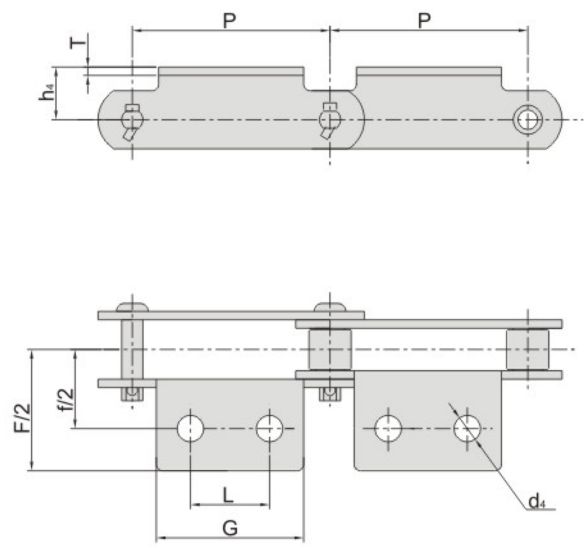
K1



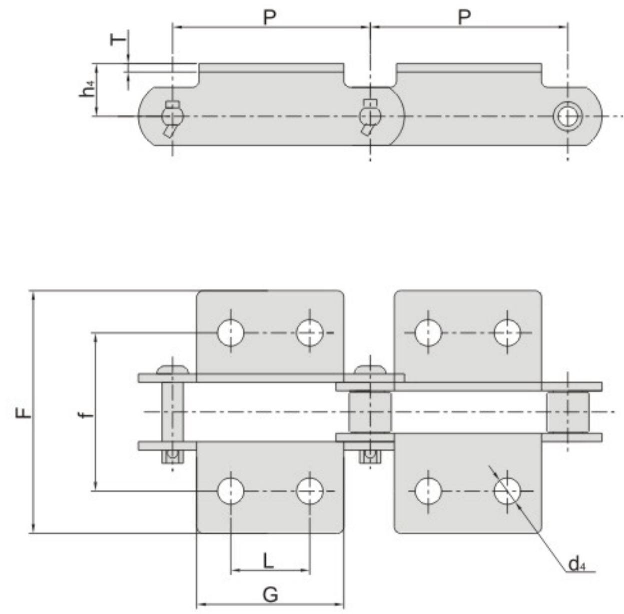
永利百合链号 UNIBear Chain No.	节距 Pitch P	滚子型式 Roller type	附件尺寸 Attachment dimensions h_4	f	F	G	T	d_3	使用螺栓 bolt
	mm		mm	mm	mm	mm	mm	mm	mm
YS03075	75	S.P.F	20	60	92	55	3.2	10	M8
YS03100	100	S.P.F				65			
YS05075	75	S	22	70	94	55	4.5	10	M8
YS05100	100	S.P.F				65			
YS05150	150	S.P.F				85			
YS10100	100	S.P.M	28	100	130	70	6.3	12	M10
YS10150	150	S.P.M.F				90			
YS12200	200	S.P.M.F	38	120	158	120	7.9	15	M12
YS12250	250	S.P.M.F				165			
YS17200	200	S.P.M.F	45	150	196	120	9.5	15	M12
YS17250	250	S.P.M.F				165			

YS型输送链附件
YS TYPE CONVEYOR CHAIN ATTACHMENTS

A2



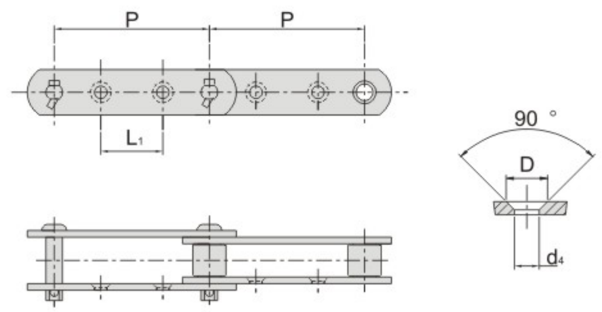
K2



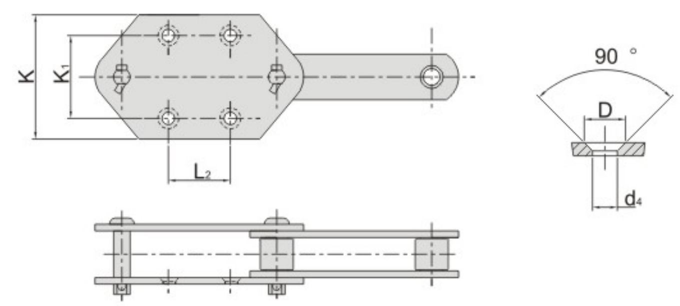
永利百合链号 UNIBear Chain No.	节距 Pitch P	滚子型式 Roller type	附件尺寸 Attachment dimensions							
	P		h_4	f	F	G	L	T	d_4	使用螺栓 bolt
	mm		mm	mm	mm	mm	mm	mm	mm	mm
YS03075	75	S.P.F	20	60	92	55	30	3.2	10	M8
YS03100	100	S.P.F				65	40			
YS05075	75	S	22	70	94	55	30	4.5	10	M8
YS05100	100	S.P.F				65	40			
YS05150	150	S.P.F				85	60			
YS10100	100	S.P.M	28	100	130	70	40	6.3	12	M10
YS10150	150	S.P.M.F				90	60			
YS12200	200	S.P.M.F	38	120	158	120	80	7.9	15	M12
YS12250	250	S.P.M.F				170	125			
YS17200	200	S.P.M.F	45	150	200	120	80	9.5	15	M12
YS17250	250	S.P.M.F				170	125			
YS17300	300	S.P.M.F				220	180			
YS26200	200	S.M	55	180	218	120	80	9.5	15	M12
YS26250	250	S.P.M.F				170	125			
YS26300	300	S.P.M.F				220	180			
YS26450	450	S.P.M.F				320	280			

YS型输送链附件
YS TYPE CONVEYOR CHAIN ATTACHMENTS

G2

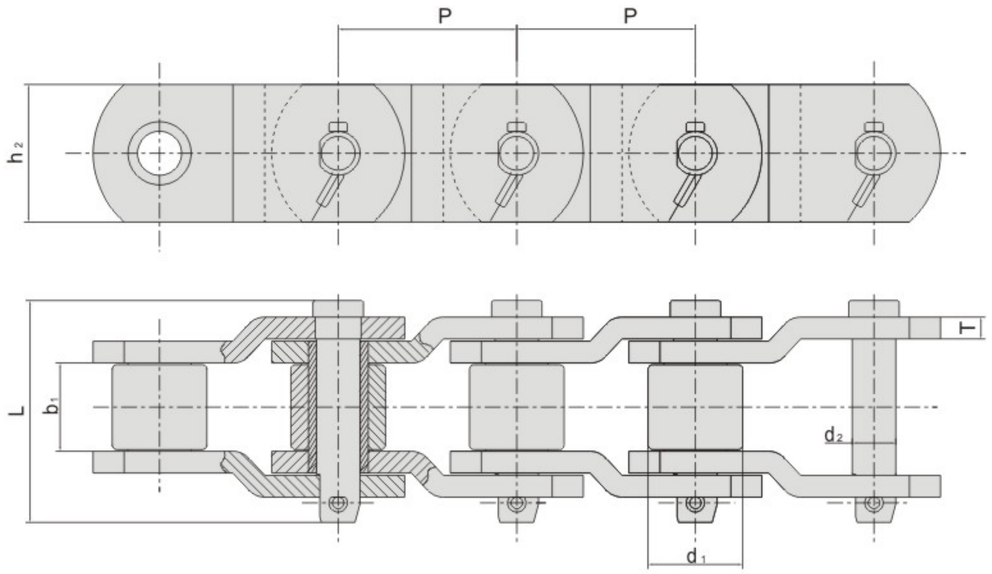


G4



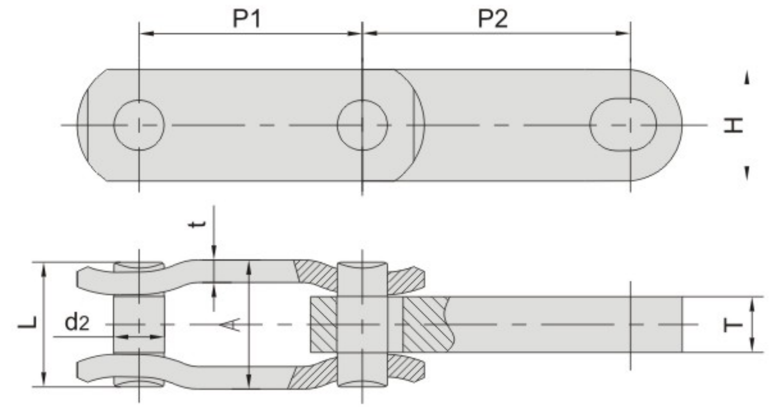
永利百合链号 UNIBear Chain No.	节距 Pitch P	滚子型式 Roller type	附件尺寸 Attachment dimensions						
	P		L1	L2	K	K1	D	d_4	使用螺栓 bolt
	mm		mm	mm	mm	mm	mm	mm	mm
YS05100	100	S.P.F	40	50	80	50	15	10	M8
YS05150	150	S.P.F	60	70					
YS10100	100	S.P.M	30				20	12	M10
YS10150	150	S.P.M.F	60	75	110	70			
YS12200	200	S.P.M.F	80	100	110	70	26	15	M12
YS12250	250	S.P.M.F	125						
YS17200	200	S.P.M.F	70	100	120	80	26	15	M12
YS17250	250	S.P.M.F	110	140	150	100			
YS17300	300	S.P.M.F	150						
YS26200	200	S.M		100	120	80	26	15	M12
YS26250	250	S.M		140	150	100			
YS26300	300	S.P.M.F	140	180	150	100			
YS26450	450	S.P.M.F	220						

重载弯板输送链
HEAVY DUTY CRANKED LINK CHAINS

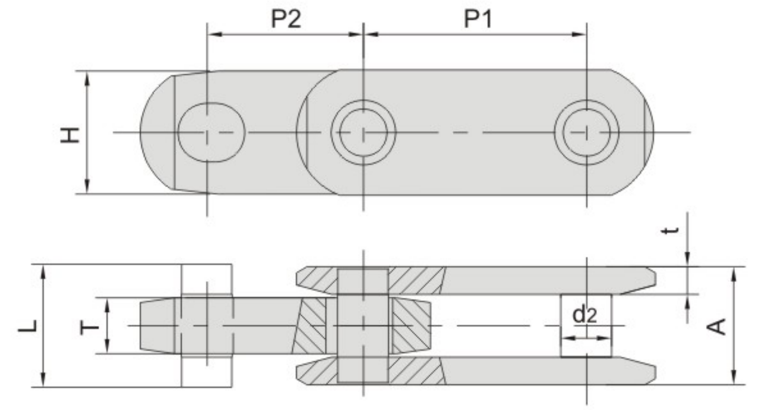


永利百合链号 UNIBear Chain No.	节距 Pitch	滚子直径 Roller diameter	窄端内宽 Width between narrow side	销轴直径 Pin diameter	销轴长度 Pin length	链板高度 Plate depth	链板厚度 Plate thickness	极限拉伸载荷 Ultimate tensile strength	平均拉伸载荷 Average tensile strength	每米长重 Weight per meter
	P	d_1 max	b_1	d_2 max	L max	h_2 max	T	Q min	Q_0	q
	mm	mm	mm	mm	mm	mm	mm	KN	KN	kg/m
2010	63.50	31.75	38.10	15.90	90.7	47.8	7.9	250.0	270.0	14.00
2510	78.10	31.75	36.90	16.00	94.8	40.0	8.0	271.0	292.0	10.72
2512(MXS3011)	77.90	41.28	39.60	19.05	100.0	57.0	9.7	340.0	367.2	18.40
2515F2	77.90	41.28	38.50	19.05	103.0	60.0	10.0	400.0	420.0	20.28
2814	88.90	44.45	36.60	22.23	117.6	58.0	12.7	471.0	507.6	25.70
3214	103.20	44.45	48.00	22.00	123.5	55.0	13.0	476.0	514.0	23.60
3315	103.45	45.24	49.30	23.85	130.0	63.5	14.2	550.0	594.0	27.71
3618	114.30	57.15	52.30	27.97	138.0	79.2	14.2	760.0	820.8	41.20
4020	127.00	63.50	69.90	31.78	165.7	88.9	15.7	987.0	1069.2	48.60
2184	152.40	76.20	35.00	22.20	96.0	51.0	9.5	330.0	378.0	18.17
MXS882	66.27	22.23	28.58	11.10	68.5	28.5	6.4	115.6	124.8	5.30
MXS3075	78.10	31.75	38.10	16.46	93.5	44.5	9.7	334.0	360.7	13.45
MXS1242	103.20	44.45	49.20	22.23	124.5	57.0	12.8	623.0	672.8	24.63
SS588	66.27	22.23	28.60	11.11	63.7	28.6	6.3	130.0	144.0	5.46
SS568H	77.90	41.30	39.70	19.05	97.6	57.0	9.5	340.0	367.3	19.80
SS40H(P)	78.11	31.75	38.10	15.88	97.0	41.5	9.5	250.0	280.0	12.60
SS124	103.20	44.45	49.20	22.23	127.2	57.0	12.7	560.0	590.0	22.57

双向侧弯链
DOUBLE FLEX CHAINS



永利百合链号 UNIBear Chain No.	节距 Pitch		外节外宽 Width over outer plates	销轴直径 Pin diameter	销轴长度 Pin length	链板高度 Plate depth	侧弯半径 Side bow radius	链板厚度 Plate thinkness		极限拉伸载荷 Ulitmate tensile strength	每米长重 Weight per meter
	P1	P2	A	d_2 max	L max	H	R	T	t	Q min	q
	mm	mm	mm	mm	mm	mm	mm	mm	mm	KN	kg/m
DF3500	63.5	76.2	38.1	14.48	35.5	31.8	508	15.9	6.4	160	5.08
DF3910	76.2	76.2	38.1	14.48	35.5	31.8	560	15.9	6.4	160	4.92



永利百合链号 UNIBear Chain No.	节距 Pitch		外节外宽 Width over outer plates	销轴直径 Pin diameter	销轴长度 Pin length	链板高度 Plate depth	侧弯半径 Side bow radius	链板厚度 Plate thinkness		极限拉伸载荷 Ulitmate tensile strength	每米长重 Weight per meter
	P1	P2	A	d_2 max	L max	H	R	T	t	Q min	q
	mm	mm	mm	mm	mm	mm	mm	mm	mm	KN	kg/m
DF3498	63.5	44.45	36.8	16	35.8	35.6	460	15.9	7.87	180	6.91

链条功率选用 SELECTION OF CHAIN DRIVE POWER

《滚子链传动选择指导》（GB/T 18150-2006/ISO 10823：2004）标准已经公布。标准规定考虑链条实际传递功率时。应对主动链轮所传递的功率（即输入功率）进行修正。

实际传递功率（修正功率）=输入功率x工况系数x齿数系数

工况系数见下表所列，齿数系数=（19/Zs）1.08（Zs-小链轮齿数）

The standard of "Guidelines for the Selection of Roller Chain Drives"(GB/T 18150-2006/ISO 10823:2004)had been issued. If you try to calculate the actual transmission power of chain, you must consider revising the transmission power of driving sprocket (input power).
Actual power(Corrected power)=input power x service factor x teeth factor
Service factor is listed in the following table.
Teeth factor = (19/Zs)1.08 (Zs-tooth number of the small sprocket)

工况系数表 Service factor table

从动机械特性 Driven Mechanism Characteristic	主动机械特性 Driving Mechanism Characteristic		
	平稳运转	轻微震动 Slight Vibration	中等振动 Medium Vibration
平稳运转 Smooth Running	1.0	1.1	1.3
中等振动 Medium Vibration	1.4	1.5	1.7
严重振动 Severe Vibration	1.8	1.9	2.1

世界各国历史悠久的链条工厂都制定有自己的链传动功率曲线和功率图。GB/T 18150-2006/ISO 10823：2004 标准也建立了特定条件下的功率曲线图，选择链条传动功率或由传动功率选择链条，前提是已知小链轮齿数和转速，链条实际传递的功率在功率曲线图的额定功率范围内，所选择的链条才是合适的。

现以工农十二型手扶拖拉机传动部分和旋耕部分的传递功率，验算链条选择是否合理。

The chain factories with long history in the world have their own chain transmission power rating graph and power diagram. We can refer to the GB/T 18150-2006/ISO 10823:2004 standard selecting the drive power or selecting chain according to the drive power, the condition is that we should know the tooth number of the small sprocket and its speed. Only if the actual power is within the range of rating power of the power rating graph, the selection is correct.

Now we use the transmission part in walking tractor and the transmission power in rotary tillage to prove whether the chain selection is correct.

1.传动部分
小链轮转速 ns=1351转/分 小链轮齿数Zs=14 经修正后的实际传递功率=10.944马力=8.16千瓦
由B系列滚子链功率曲线得知，选择08B-2滚子链是合适的。

Chain drive part
Small sprocket speed ns=1351 Tooth number of small sprocket Zs=14
Actual power (Corrected power)=10.944hp=8.16kW
From B series horsepower rating graph, you will find selected 08B-2 chain is suitable.

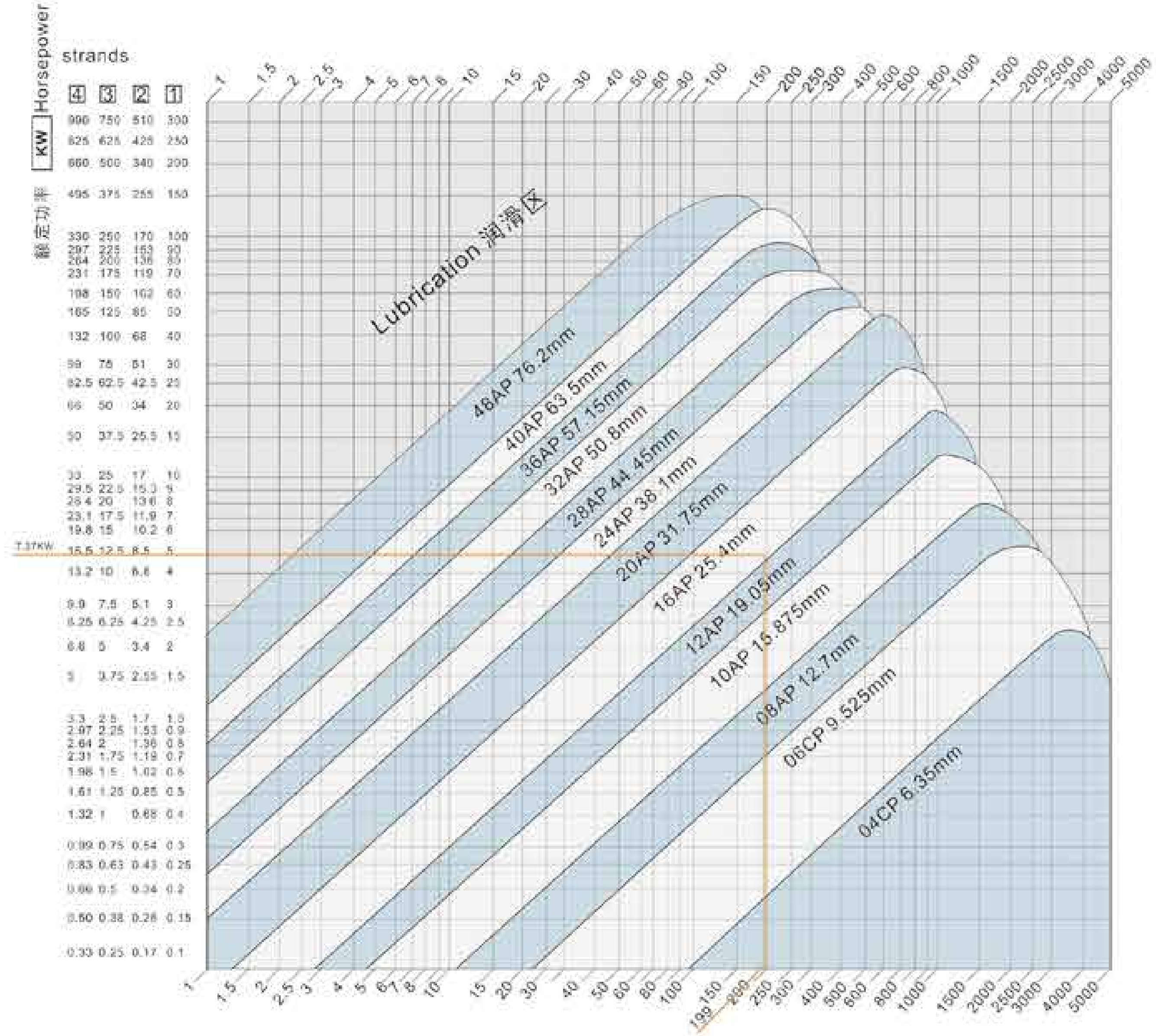
2.旋耕部分
小链轮转速 ns=199转/分 小链轮齿数Zs=13 经修正后的实际传递功率=9.888马力=7.37千瓦
由A系列滚子链功率曲线得知，选择12A-2滚子链是不合适的，选型偏小，正确选用应采用16A-1滚子链或60H-2重载型滚子链。

Rotary tillage chain part
Small sprocket speed ns=199 Tooth number of small sprocket Zs=13
Actual power (Corrected power)=9.888hp=7.37kW
From A series horsepower rating graph, you will find selected 12A-2 chain is unsuitable. You should choose 16A-1 or 60H-2 Heavy duty roller chain instead of 12A-2.

POWER RATING GRAPH 功率曲线图

本功率曲线图的特定条件主要是：
小链轮齿数为19；
链条长度为120个节距；
传动比从1：3到3：1；
链传动的预期使用寿命为15000小时。

The main characteristics of this power graph are as follows
Tooth number of small sprocket =19
Chain length:120 pitches
Transmission ratio:1:3 to 3:1
Service life of chain:15000 hours



小链轮转速(r/min)
Small Sprocket Speed(r/min)

注：多排链的额定功率可由排链的额定功率乘以排数系数得到。

Note: The rating power of multiple strand chain can be obtained by multiplying the strand factor by the rating power of single strand chain.

排数系数表 Strand factor table

排数 Number of strand	1	2	3	4	5	6
系数 Factor	1.0	1.7	2.5	3.3	4.1	4.9

链条传动的润滑取决于使用场合、温度、链条线速度等。

1. 使用场合影响

开式传动如各类联合收割机、割晒机等链条应采用油脂润滑。
闭式传动如手扶拖拉机链条传动箱，应采用机油润滑。

2. 温度影响

一般推荐在-5℃~+60℃范围内使用润滑。
冬季采用粘度小的机油，夏季采用粘度大的机油。

3. 线速度影响

润滑方式直接与链条线速度有关，可参照下图选择润滑方式。

Lubrication of chain depends on the working environment, temperature, chain speed and so on.

1.Influence of working environment

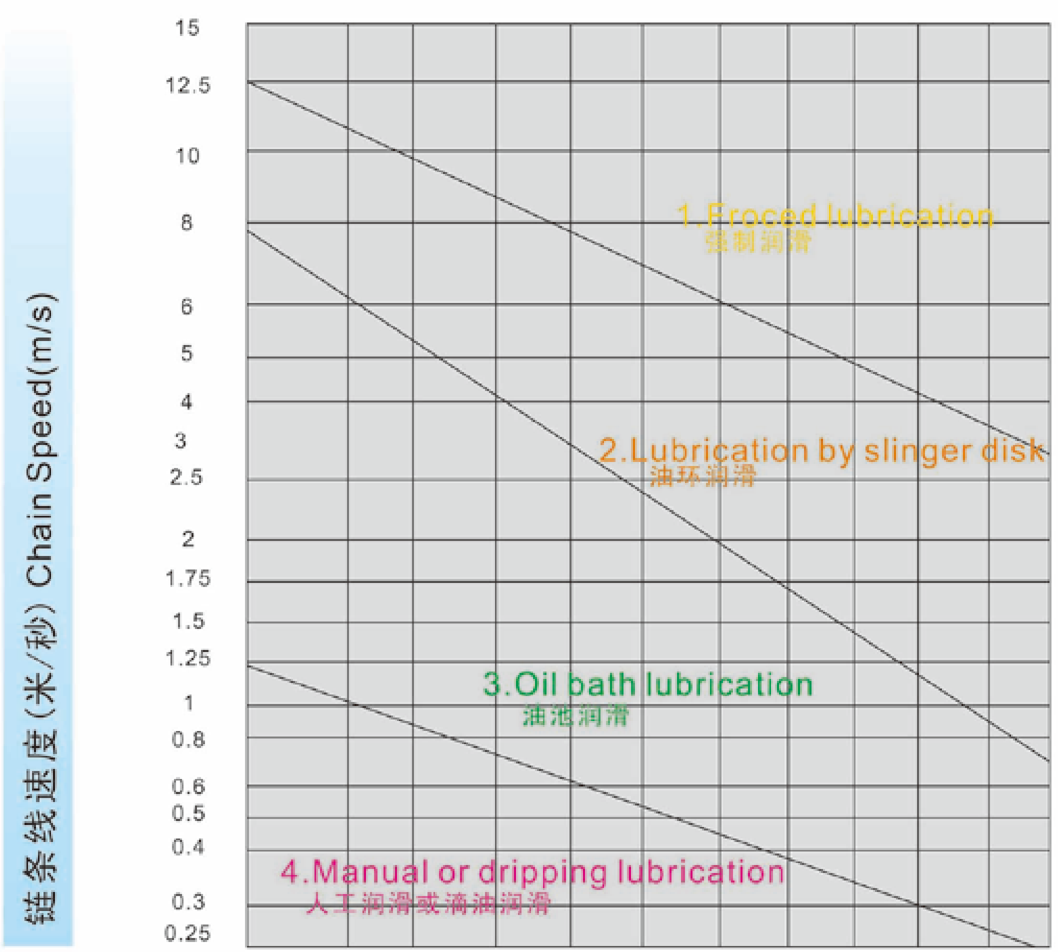
For open drive such as combine chain, swather chain etc., grease lubrication is recommended.
For closed drive such as walking tractor chain transmission case etc., oil lubrication is recommended.

2.Influence of temperature

Application in the temperature range of -5℃ to +60℃ is recommended.
In winter, lower viscosity oil is recommended; But in summer, higher viscosity oil is recommended.

3.Influence of chain speed

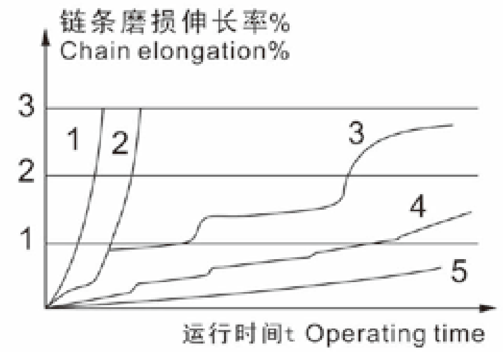
The lubrication method is related to chain speed.
Refer to the following chart for details, please.



链传动的润滑
Lubrication

运行在链轮上的链条由于销轴处铰链的相对回转而产生磨损。因此有效的润滑就显得至关重要，其不仅可以有效降低磨损且能降低功率损耗和噪音。

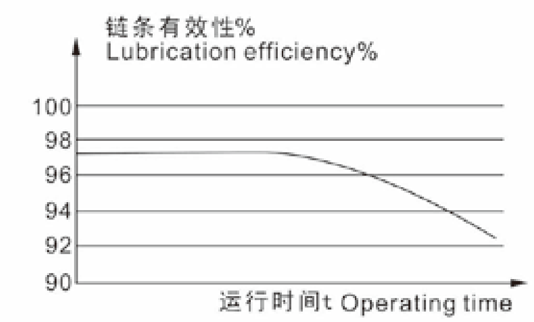
Wear is mainly caused by bearing pressure, angle-sliding movements of the pins and rotation of the rollers etc.. Effective lubrication of the chain hinges is utmost important for reducing wear, power loss and noise etc. effectively.



曲线1：干摩擦：链条由于干摩擦引起严重磨损而致使其短时间内迅速磨损失效；
曲线2：仅有初始润滑：链条因仅有初始润滑，故其磨损在润滑剂用完迅速增加；
曲线3：人工润滑：链条因人工润滑而频繁产生间歇性干磨察，特别是在人工润滑不能符合润滑周期要求时；
曲线4：不恰当的润滑：链条被使用了不恰当的润滑，比如劣等、脏的、不合适的粘度或不足的润滑剂，而引起的链条不均匀磨察；
曲线5：正确的润滑：可以看出其对链条使用寿命的至关重要性。

Curve 1: Without lubrication. Chain would be worn out and destroyed within a very short time.
Curve 2: Optimum initial lubrication only. High wear would occur within a short time after the lubricant has been used up.
Curve 3: Manual lubrication. Intermittent dry rub frequently occurs, especially when regular periodical relubrication is not well implemented.
Curve 4: Incorrect lubrication. Uneven chain wear results from incorrect lubrication.
Curve 5: Correct lubrication. The right lubrication is the utmost important to obtain a optimum service life.

润滑和有效性
Lubrication and efficiency



左图显示了润滑有效性随运行时间的变化
The left graph shows the efficiency of lubrication decrease with operating time.

当摩擦副表面变色时表明润滑已失效，在此之前应进行再次润滑。
具体的润滑失效间隔时间应依据特定的工况和运行条件进行试验测定。

Relubrication shall be done before discoloration of the rub surface which indicates the lubrication failure of the former lubrication, The specific lubrication intervals shall be determined by tests based on specific conditions and running conditions.

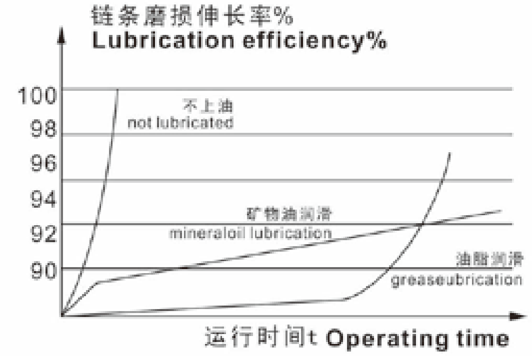
润滑剂
Lubricant

润滑剂的选择首先取决于润滑方式

First of all, the selection of an appropriate lubricant depends on the type of lubrication.

如右图所示，低粘度的矿物油特别适合链传动

Just as the right diagram shows, low viscosity mineral oils are particularly suitable for chain drives.



推荐的不同工作温度下的润滑剂应具备的粘度
Recommended viscosity

环境温度 Ambient temperature℃	润滑剂粘度 Viscosity of lubricant
-5℃~+25℃	N100(ISO VG 100)
-25℃~+45℃	N150(ISO VG 150)
-45℃~+60℃	N220(ISO VG 220)

若使用温度更高(如炉箱链)或使用环境很恶劣、泥浆四溅等开式或重载低速链传动时，二硫化物(MoS2，WS2)或硒化物(MoSe2，WSe2)无论是用作添加剂还是直接喷润都能提高润滑性能。

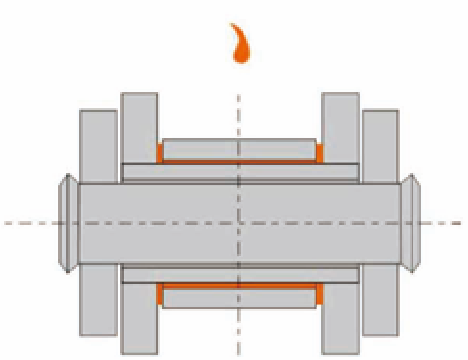
低粘度或滴点在70℃左右的润滑脂同样适用于人工润滑。在某些特殊的场合使用液化的润滑脂进行喷润。不稳定的物质挥发完后即可开始工作。

无论采用何种润滑剂和润滑方式，最重要的问题是使润滑剂能及时充分均匀的分布到构成摩擦副的链节铰链处的间隙中(销轴-套筒之间，套筒-滚子之间)。

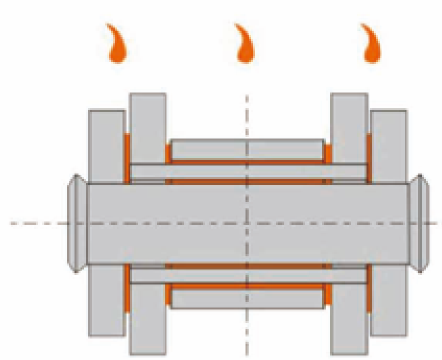
For higher temperatures(e.g. furnace chains) or severe operating conditions,mud spattering open-type etc. or heavy-duty low speed chains, graphite or molybdenum disulfide (MoS_2)applied either as additive or spray will improve lubrication performance.

Low-viscosity or the grease products with a drop point of 70℃ are also suitable for manual lubrication. Liquidized grease may be sprayed on the chains in special conditions and chains can start running immediately after the evaporation of thevolatile carrier substance.

No matter which kind of lubricants and lubrication methods choosed, the most important issue is to ensure the lubricant flow into evenly (between pin and bush, between bush and roller).



a)错误的给油方式
Incorrect method

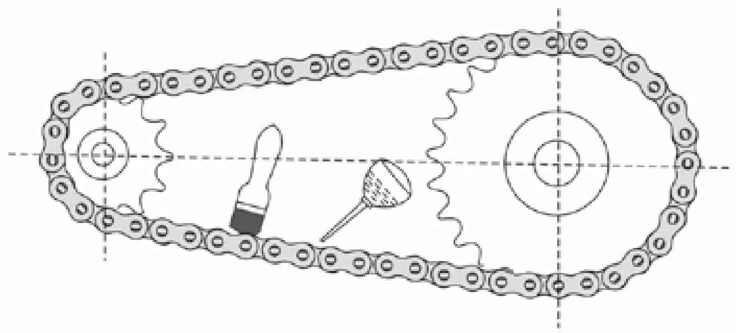


b)正确的给油方式
Correct method

SELECTION OF LUBRICATION 润滑选择
UNIBEAR

润滑方式选择 Selection of lubrication method

常见的润滑方式有以下5种：
Normally, there are five lubrication methods as below:



1. 人工润滑
用刷子或油壶定期在链条松边内外链板间隙处加油。这种方式可靠性不高，因此仅适用于非经常工作的链条或低速二级传动中。至少应每天充分润滑一次（若条件允许，应每隔8小时注油一次），应尽可能避免产生润滑剂的变色现象。

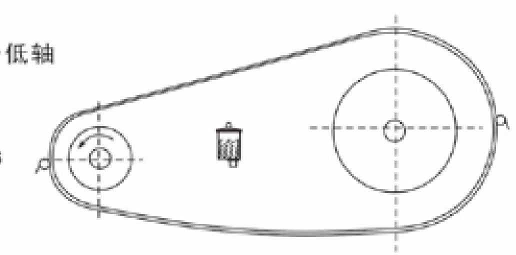
1.Manual lubricationx

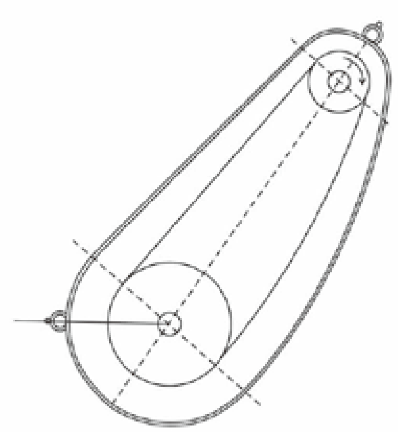
This type of lubrication by means of oil can and brush, which adding lubricant into the gap between outer and inner linkplate of chain loose side periodically is not very safe and therefore this type lubrication is only suitable for those chains with occasional operation or for those secondary drives and low chain speeds. Sufficient lubrication should take place at least once a day (if possible once every eight running hours). Lubricant colouration should be avoided as far as possible.

2. 滴油润滑
用油芯加油器，针阀式注油杯或滴油油杯加油，这种方式仅适用于低轴压比的传动，应尽可能避免产生润滑剂的变色现象。

2. Drip lubrication

Drip lubrication by means of wick oilers, needle oilers or drip oilers is only suitable for low bearing pressure drives. Lubricant colouration should be avoided as far as possible.





3. 油池润滑（亦称油浴润滑）
在一个大小合适的链箱中（使用过的已磨损伸长的链条不应能撞击到箱边）拥有足够的润滑油以使链板边至滚子或套筒处能进入，但浸入不宜过浅或过深。浸入过浅则润滑不可靠；浸入过深则油易发热氧化变质且搅油损失大。

3.Oil bath lubrication (submerged lubrication)

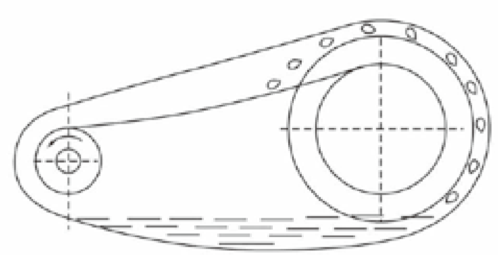
There is just enough oil in a proper chain box for preventing the worn and elongated chain knocking against the casing wall to allow the chain plates to submerge into the bath up to the rollers or the bushings respectively. But immersion should not be too deep or too shallow. Too shallow immersion lubrication is not reliable. Too deep immersion may cause the oil to heat up and lead to untimely oxidation of the oil.

4. 油环润滑（亦称飞溅润滑）

链条运行在油面上方。一个能浸入到油中约12.7mm~25.4mm的甩油盘利用离心力将油飞溅起来并利用箱体上的集油装置持续不断的导流到链条上。甩油盘的圆周速度应大于3m/s，一般不超过12.5m/s，最大不应超过40m/s。当链条宽度超过127mm时，应在链轮两侧都装甩油盘。

4.Oil-ring lubrication (splash lubrication)

With this type of lubrication, the chain operates above oil level. A disk submerging into the lower oil level, the depth is about 12.7mm-25.4mm, Peripheral velocity between min.3m/s and max. 40m/s,normally not bigger than 12.5m/s,centrifuges oil against the casing walls from where it continuously runs down onto the chain via drip rails. The disk should be mounted on both sides of sprocket when the chain width above 127mm.

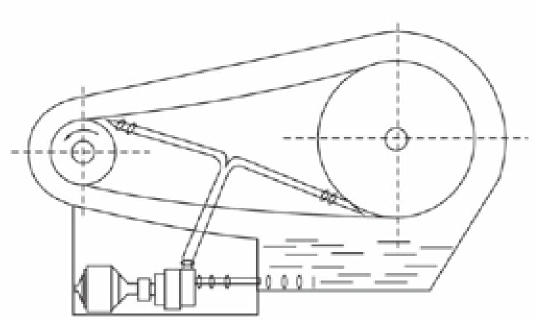


5. 强制润滑（亦称压力润滑）

此润滑方式适用于高速载重型传动。通过油泵和注油管强制供油润滑并起到循环冷却链条的效果。喷油嘴应布置在链条与链轮的啮入处且数目应比链条排数多一个以使其对准每列链板的间隙处。

5.Force feed lubrication (pressure lubrication)

This type of lubrication is suitable for high-speed and heavy-duty type drives. Force feed lubrication is carried out to realize the circulating cooling of chains by means of oil pump and oil feeding pipe. The spray nozzles should be situated near the gearing places of chain and sprocket, and the nozzle number should be one more than the chain strands number to make them aim at the gap of each row link plate.



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