

PRODUCT SALES BULLETIN

SUBJECT: CHAIN WEAR – UNIBILT – X348, X458 AND X678 CHAIN

In the past there have been numerous questions regarding the maximum allowable chain "stretch" or wear. The following are some general guidelines on this subject:

CONVEYOR CHAIN LENGTHS				
Chain Size	Nominal Length	# of Pitches	New Length	Recommended Max. Worn Length
Unibilt	240î	30	243î	248î (2%)
X-348	120î	40	121î ± 1/2î	125î
X-458	120î	30	121î ± 1/2î	125î
X-678	120î	20	121î ± 1/2î	125î

1. Chain "stretch" is not the same as chain wear. Under load, all conveyor chain stretches similar to a large rubber band. This stretch varies depending on the size of chain and the load. Chain wear is the physical wearing of the bearing surfaces and is an indication of the remaining service life available in the chain.
2. A lightly loaded slow speed conveyor will tolerate worn chain better than a highly loaded high speed conveyor.
3. The drive caterpillar chain should be inspected for wear and replaced if necessary when the conveyor chain is replaced. If the RC-160 cat chain is in good condition, it should be removed and reinstalled so that the opposite cat dog face engages the conveyor chain. Worn cat chain does not work well with new conveyor chain.
4. If new chain is added to a multiple drive conveyor (as part of a system extension for example), the chain should be added in small sections spaced throughout the length of the existing chain. New chain runs slightly slower through a cat drive as compared to worn chain. This slight speed differential can cause substantial chain tension increases if one drive is pulling a long length of worn chain and the other is pulling a long length of new chain.
5. Lubrication of the chain bearing surfaces is the only way to ensure that a conveyor chain will last through a reasonable service life. Even a lightly loaded chain can wear out in a short time if it is not lubricated properly.

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