
**Double-pitch precision roller chains,
attachments and associated chain
sprockets for transmission and
conveyors**

*Chaînes de précision à rouleaux à pas double, plaques-attaches et
pignons dentés correspondants pour transmission et manutention*



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 1275 was prepared by Technical Committee ISO/TC 100, *Chains and chain sprockets for power transmission and conveyors*.

This fourth edition cancels and replaces the third edition (ISO 1275:1995), which has been technically revised.

Introduction

This International Standard has been established to cover a range of chains used in the majority of countries in the world by unifying dimensions, strengths and other data from current national standards.

The principal feature of these chains is their derivation from the ISO 606 series by using the standard round parts in links that are double the standard pitch.

Chains have been adopted from the ANSI, BS and DIN double-pitch series to form a range from 25,4 mm to 101,6 mm pitch. Versions of chains are included with normal and with thicker plate materials, with the alternatives of smaller or larger rollers, as well as a range of attachments and sprockets.

The dimensions of the chains provide for complete interchangeability of individual links, and the sprocket dimensions allow complete interchangeability of chains of the same pitch and the same chain designation (either A or B series).

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Double-pitch precision roller chains, attachments and associated chain sprockets for transmission and conveyors

1 Scope

This International Standard specifies requirements for double-pitch precision roller chains suitable for the mechanical transmission of power and for conveyors, together with those for their associated sprockets. It covers dimensions, tolerances, length measurement, preloading and minimum tensile strengths.

These double-pitch chains have been derived from some of the short-pitch transmission precision roller chains covered by ISO 606 having certain common dimensions but of double the pitch.

The chains are intended for use under less onerous conditions with respect to speed and power transmitted than are the base chains from which they are derived.

This International Standard primarily applies to sprockets with 5 to 75 teeth inclusive (with intermediate numbers of teeth $5\frac{1}{2}$ to $74\frac{1}{2}$ inclusive).

The preferred numbers of teeth are 7, 9, 11, 13, 19, 27, 38 and 57.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 286-2, *ISO system of limits and fits — Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts*

ISO 606, *Short-pitch transmission precision roller and bush chains, attachments and associated chain sprockets*

3 Transmission chains

3.1 Assembly and component nomenclature

The nomenclature of the chain assemblies and their component parts is illustrated in Figures 1 and 2.

NOTE The figures do not define the actual form of the chain plates.

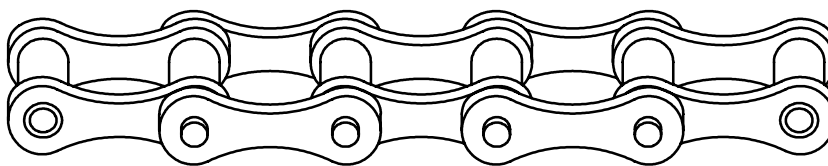


Figure 1 — Chain assembly