INTERNATIONAL STANDARD

**ISO 487**

Third edition
1998-07-15

# Steel roller chains, types S and C, attachments and sprockets

*Chaînes à rouleaux en acier, types S et C, plaques-attaches et roues dentées*

Reference number
ISO 487:1998(E)

## 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.

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.

International Standard ISO 487 was prepared by Technical Committee ISO/TC 100, *Chains and chain wheels for power transmission and conveyors*.

This third edition cancels and replaces the second edition (ISO 487:1984), which has been revised to include the latest features and products that are needed by industries using these chains and attachments. This edition introduces a new range of higher strength chains ("H" series) and the "F4" attachments for the S45 and S55 chains whilst deleting the "corn picker" attachments as these are not deemed relevant to current practice in industry.

Annex A forms an integral part of this International Standard. Annex B is for information only.





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## 1 Scope

This International Standard specifies the characteristics of a range of steel roller chains, dimensionally derived from the malleable iron type and suitable for the conditions of operation and maintenance prevailing in such fields as agriculture, building, quarrying and related industry, mechanical handling, etc., and of associated chain sprockets.

## 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 185:1988, *Grey cast iron — Classification*.

ISO 606:1994, *Short-pitch transmission precision roller chains and chain wheels*.

## 3 Chains

### 3.1 Nomenclature

The nomenclature of chains and their component parts is given in figures 1 and 2.

### 3.2 Designation

Steel roller chains shall be designated by the standard ISO chain numbers given in table 1.

### 3.3 Dimensions

The chains shall conform to the dimensions given in table 1. Maximum and minimum dimensions are specified to ensure the interchangeability of links produced by different chain makers. They represent limits for interchangeability, but are not the actual tolerances that should be used in manufacture.

### 3.4 Minimum tensile strength

**3.4.1** The minimum tensile strength is the value that shall be exceeded when a tensile force is applied to a sample which is tested to destruction as described in 3.4.2. This strength is not a working force. It is intended primarily as a comparative figure between chains of various materials and constructions. For application information, the manufacturers or their published data should be consulted.

**3.4.2** A tensile force, not less than that specified in table 1, shall be applied slowly to the ends of a chain length containing at least five free pitches, by means of shackles permitting free movement on both sides of the chain centre line, in the normal plane of articulation.