VAV

Conveyor components and solutions

CONVEYOR CHAINS

There are two types of conveyor chains:

√ Drop forged chain
√ Double drag link chain DIN 8165-FV and DIN 8167-M

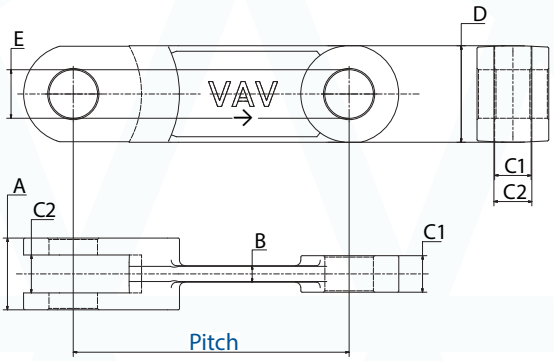
VAV supplies different versions of both types and can deliver the optimum conveyor chain for any purpose.

The chains can be equipped with plastic, welded, or bent scrapers (or a combination).

Supplier of spare parts
for the bulk handling industry

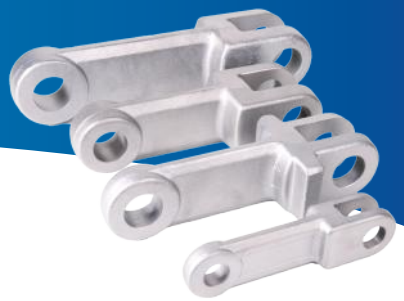
Drop forged chain

The drop forged chains supplied by VAV are made of heat treated high grade alloy steel. The links can be equipped with plastic flights and/or steel scrapers. The following table shows various types of drop forged chains ex stock, together with the respective breaking loads and core/surface hardness.



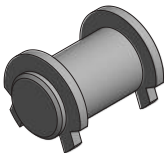
Drop forged chain (parameters in mm)								
Pitch	A	B	C1	C2	D	E	Breaking loads available ex stock	
							58 HRC Case hardened	Q&T 40 HRC
102	32	10	14	15	36	18	150 kN	
102	27	11	12	13	36	16		170 kN
102	30	8	13	13,5	36	14		140 kN
102	24	6	8	9	36	14	100 kN	
125	36	10	15	16	36	16		140 kN
142	42	13	19	20	50	25	250 kN	350 kN
142	54	16	25	26	50	25	300 kN	380 kN
142	62	15	29	30	50	25	350 kN	600 kN
150	36	13	15	16	50	25		200 kN
150	36	13	15	16	50	25		300 kN
150	36	13	15	16	50	25		400 kN
160	42	13	20	21	46	20		300 kN
160	50	14	25	26	50	25	300 kN	380 kN
175	62	15	29	30	50	25		600 kN
200	68	18	30	31	60	30	500 kN	
200	70	24	30	31	60	30		700 kN
250	70	20	30	33	70	32		750 kN
260	70	20	30	33	70	32	600 kN	

Materials: 20MnCr5, 42CrM04, Stainless steel 304/316, 1.4713. The breaking load depends on the choice of material.

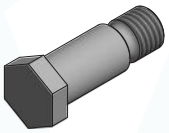


Pins

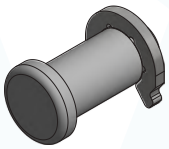
Pins are available in different executions and the following materials:
16MnCr5, 42CrMo4i, 1.4034i, 1.4122i, 1.4462, 1.4713. Other materials are available on request.



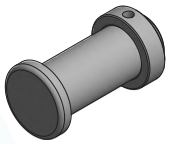
Circlips



hex pin with thread



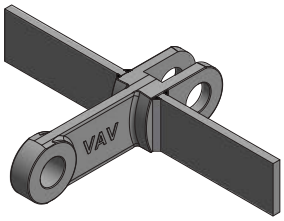
Head pin with circlips



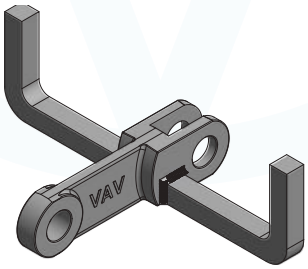
Head pin with
collar and dowel pin

Examples of drop forged chain with scrapers

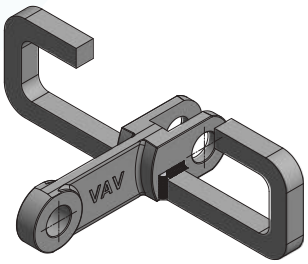
VAV can supply all kinds of scrapers. Whether it is horizontal, inclined or vertical transport, there is a special version for every type of transport and a solution for every capacity. Below you will find a number of examples of steel scrapers and plastic flights.



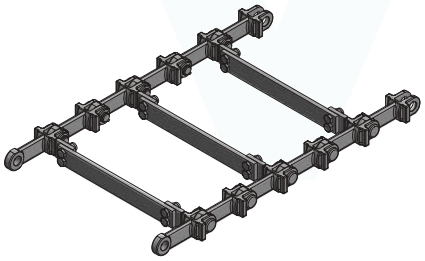
Horizontal transport



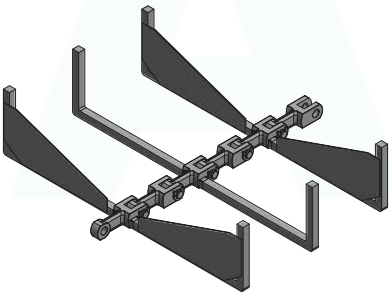
"U" scraper for
inclined transport



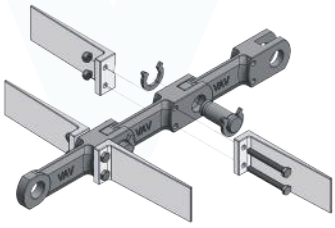
"O" scraper
for vertical transport



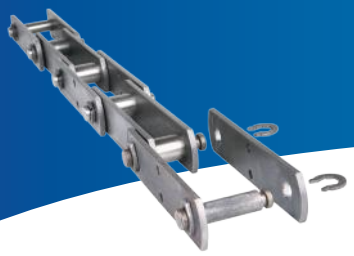
Double drop forged chain scraper



"U" scraper with welded plates



Easy to (dis)assemble
plastic flights



DIN-chains in stock

VAV does not recommend an "own" type of chain. Capacity, type of bulk material, situation on site, and price / quality ratio determine the advice of our technicians. That is why VAV stocks a large number of double drag link chains and sprockets in various sizes.

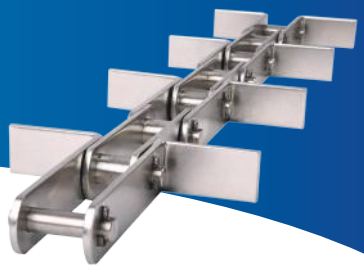
These chains can be custom-made, with a short delivery time, with plastic flights and/or steel welded scrapers. The standard pins are fitted with a circlip (unless otherwise stated). An overview of the chains available from stock can be found in the table below.

VAV double drag link chain (parameters in mm) available from stock

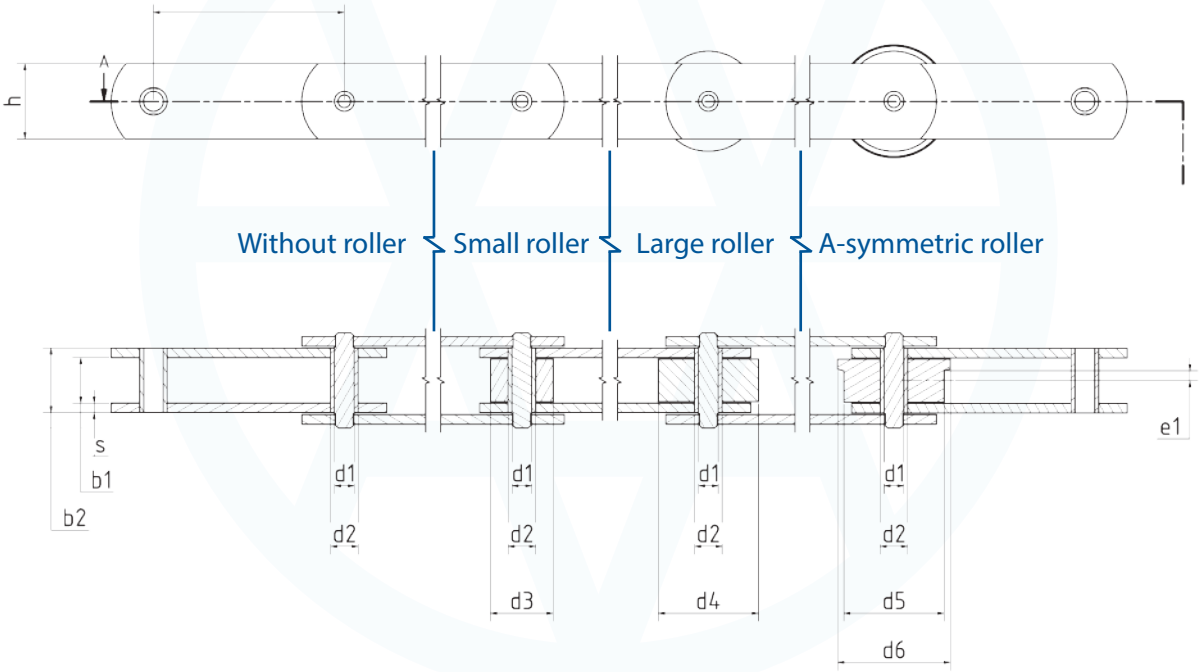
Pitch	Inner	Bush/pin	Plates	Breaking load
(p)	width (b1)	Ø (d1/d2)	(h x s)	in kN
80	22	**18 / 12	30 x 4	63
80	25	20 / 14	35 x 5	90
80	25	*20 / 14	35 x 6	110
80	25	*20 / 14	35 x 8	110
80	30	22 / 16	40 x 6	112
80	35	30 / 20	50 x 8	180
100	22	18 / 12	30 x 4	63
100	25	20 / 14	35 x 5	90
125	25	20 / 14	35 x 5	90
125	30	22 / 16	40 x 6	112
125	32	**21 / 15	40 x 6	112
125	30	26 / 18	45 x 6	140
125	35	26 / 18	45 x 6	140
125	30	30 / 20	50 x 8	180
125	45	30 / 20	50 x 8	180
150	30	22 / 16	50 x 6	112
150	52	25 / 18	50 x 8	140
150	45	30 / 20	50 x 8	180
150	55	36 / 26	50 x 8	250
160	30	30 / 20	50 x 8	180
160	37	**25 / 18	50 x 7	160
160	45	30 / 20	50 x 8	180
160	55	36 / 26	60 x 10	250

* Splitpin execution
** Revited execution

DIN 8165 - FV

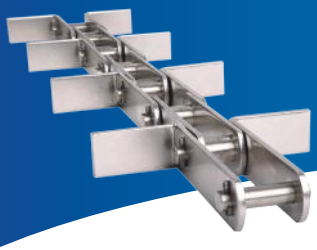


Double drag link chains according to DIN 8165 (FV) and DIN 8167 (M) are available with connecting pins in a circlip, split pin and riveted version. The steel scrapers can be L-shape bent, welded and / or bolted with plastic profiles. It is also possible to attache special VAV plastic scrapers on every outside link. The chains can also be fitted with rollers. Delivery in different materials, (inductive) hardened is possible on request.



DIN 8165 - FV - Double drag link chain (parameters in mm)										
Breaking load in kN	63	90	112	140	180	250	315	400	500	630
Inner width (b1)	22	25	30	35	45	55	65	70	80	90
Bush Ø (d2)	18	20	22	26	30	36	42	44	50	56
Pin Ø (d1)	12	14	16	18	20	26	30	32	36	42
Plate height (h)	30	35	40	45	50	60	70	70	80	100
Plate thickness (s)	4	5	6	6	8	8	10	12	12	12
Small roller (d3)	26	30	32	36	42	50	60	60	70	80
Large roller (d4)	40	48	55	60	70	80	90	100	110	120
A-symmetric (d5/d6)	50/60	63/73	72/87	80/95	100/120	125/145	140/170	150/185	160/195	170/210
Angle acc. DIN	30x4	40x5	40x6	50x7	50x7	65x7	70x9	70x11	80x12	100x12

Available in pitch (p): 40 - 50 - 63 - 80 - 100 - 125 - 135 -150 - 160 - 200 - 250 mm.
Other sizes and materials are available on request.



DIN 8167 - M

DIN 8167 - M - Double drag link chain (parameters in mm)									
Breaking load in kN	56	80	112	160	224	315	450	630	900
Inner width (b1)	24	28	32	37	43	48	56	66	78
Bush Ø (d2)	15	18	21	25	30	36	42	50	60
Pin Ø (d1)	10	12	15	18	21	25	30	36	44
Plate height (h)	30	35	40	50	60	70	80	100	120
Plate thickness (s)	4	5	6	7	8	10	12	14	16
Small roller (d3)	21	25	30	36	42	50	60	70	85
Large roller (d4)	42	50	60	70	85	100	120	140	170
A-symmetric (d5/d6)	42/50	50/60	60/70	70/85	85/100	100/120	120/140	140/170	170/210
Angle acc. DIN	40x4	40x4	50x6	50x6	60x8	70x9	70x9	100x12	120x15

Available in pitch (p): 40 - 50 - 63 - 80 - 100 - 125 - 135 -150 - 160 - 200 - 250 mm.
Other sizes and materials are available on request.

Pins

Pins are available various executions and in materials:
16MnCr5, 42CrMo4i, 1.4034i, 1.4122i, 1.4462, 1.4713. Other materials on request.

Circlips

Split pins

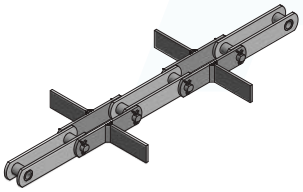
Circlip - revited

Split pin - head pin

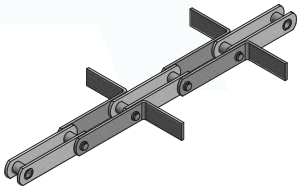
Examples of double drag link chain with scrapers

Double drag link chain can be produced in various executions. Outer links can be bent in L-shape scrapers or provided with plastic flights. Internal and external links can be provided with welded scrapers. Of course, a combination is possible.

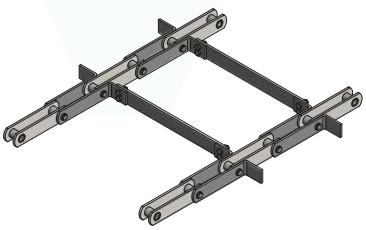
With plastic scrapers



T-shape welded



L-shape bended



Double strand with cross bar

Sprockets

Sprockets for double drag link chain

Sprockets are with or without teeth (return sprockets) and wear-resistant due to the hardening on the teeth. These sprockets have a symetrical hub and are divisible, making them easy to (dis) assemble. The following versions are available ex stock. Different dimensions are possible on request.

Sprockets for double drag link chain available ex stock (parameters in mm)					
Pitch	Inner width	Bush Ø	Pitch Ø (p x n)		
			6 teeth	8 teeth	7 teeth
63	22	18	126,00	164,63	x
80	22	18	160,00	209,05	x
100	22	18	200,00	261,31	x
125	25 / 30 / 35 / 45	20 / 22 / 26 / 30	250,00	326,64	x
150	30 / 45	22 / 30	x	x	345,71
160	30 / 45	30	320,00	418,10	x

Pitch diameter calculation									
z = number of teeth, n = conversion factor									
Pitch Ø (in mm) = Pitch of the chain x n									
z	n	z	n	z	n	z	n	z	n
6	2,0000	9	2,9238	12	3,8637	15	4,8097	18	5,7588
7	2,3048	10	3,2361	13	4,1786	16	5,1258	19	6,0755
8	2,6131	11	3,5495	14	4,4940	17	5,4422	20	6,3925

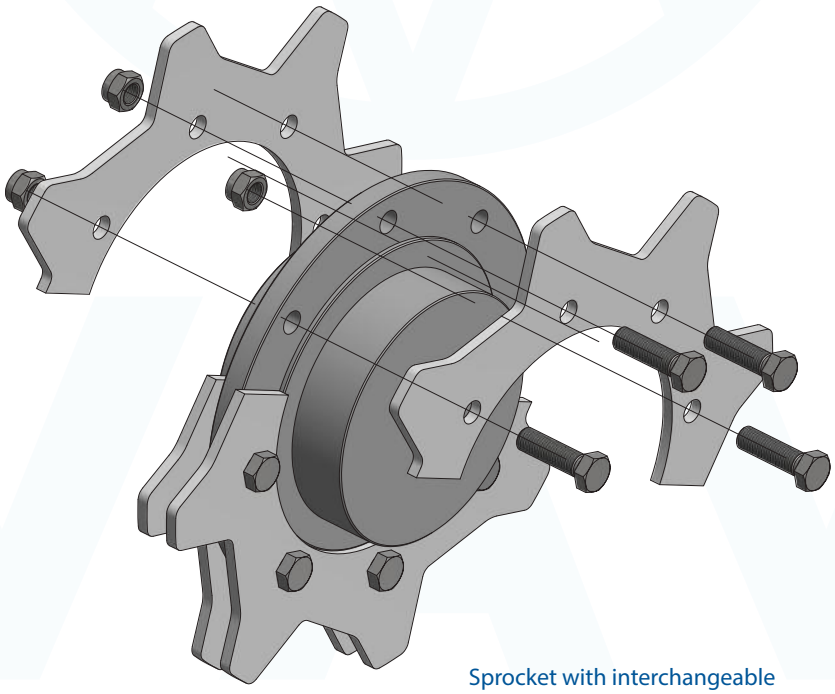
Sprockets from VAV are divisible, for quick (dis) assembly.

Sprockets

Sprockets for drop forged chain

Sprockets for drop forged chain consist of a body with symmetrical hub and interchangeable teeth segments. This has the advantage that, when the sprockets wear out, only the wear-resistant teeth segments need to be replaced. Sprockets can be made to your specifications on request. The following versions are available ex stock.

Sprockets for drop forged chain available ex stock (parameters in mm)					
Pitch	Pitch Ø / number of segments per complete set				
	6 teeth	7 teeth	8 teeth	9 teeth	10 teeth
102	Ø 204,00 / 4	Ø 235,09 / 4	Ø 265,49 / 4	Ø 298,23 / 4	Ø 330,08 / 4
125	Ø 250,00 / 4	Ø 288,10 / 4	Ø 326,64 / 4	Ø 365,48 / 4	Ø 404,51 / 4
142	Ø 284,00 / 4	Ø 327,28 / 4	Ø 371,06 / 8	Ø 415,18 / 6	Ø 459,52 / 4
150	Ø 300,00 / 6	Ø 345,71 / 4	Ø 391,97 / 8	Ø 438,57 / 4	Ø 485,42 / 10
160	Ø 320,00 / 4	Ø 368,76 / 4	Ø 418,10 / 8	Ø 467,81 / 4	Ø 517,77 / 4
200	Ø 400,00 / 4	Ø 460,95 / 4	Ø 522,62 / 8	Ø 584,76 / 4	Ø 647,21 / 4



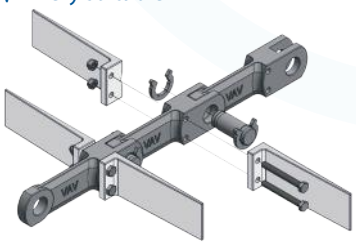
Sprocket with interchangeable teeth segments (8 teeth)

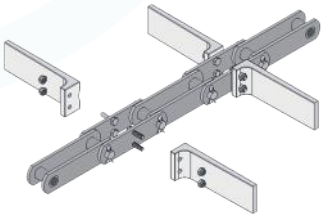
VAV plastic flights

VAV plastic flights are made of flexible and durable Nylon. Because the chain runs on the plastic flights, there is no steel on steel contact. This is energy-saving, noise-reducing and cost-saving. In addition, they are easy to (dis)assemble and wear/guiding rails become unnecessary. There are several types available: the standard Nylon, heat resistant Zytel, Fiberglass reinforced, FDA quality and a detectable version.

Characteristics of VAV plastic flights					
Type	**Standard**	**Fiberglass**	**FDA-quality**	**Zytel**	**Detectable**
Colour	white	white	white	red	blue
Noise reducing	√ √	√	√ √	√ √	√ √
Flexible (will bend back)	√ √		√ √	√	√ √
Detectable					√ √
FDA quality			√ √		√ √
Temperature resistance	-20 - +70 °C	-20 - +70 °C	-20 - +70 °C	80 - +110 °C	-20 - +70 °C

√ = suitable, √ √ = very suitable





Plastic flights (parameters in mm)			
Length x height	Cc. distance	Drop forged chain	Double drag link chain
	of the holes	pitch*	pitch/plates*
117 x 45	20	102 125, 160	80, 100, 125/35x5
137 x 45	20	102, 125, 160	80, 100, 125/35x5
180 x 45	20	102, 125, 160	80, 100, 125/35x5
162 x 55	25	-	125/40x6, 125/45x6
112 x 58	30	142, 150	125, 150, 160/50x8, 150/50x6
162 x 58	30	142, 150	125, 150, 160/50x8, 150/50x6
212 x 58	30	142, 150	125, 150, 160/50x8, 150/50x6
262 x 58	30	142, 150	125, 150, 160/50x8, 150/50x6
300 x 58	30	142, 150	125, 150, 160/50x8, 150/50x6

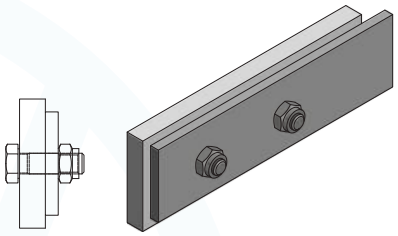
* VAV chain in stock

Plastic profiles

Plastic profiles can be produced in various types of materials, such as: PE (polyethylene), Nylon or PU (polyurethane). These can be used as a scraper or as a flight. The profiles can be custom-made. Below a number of examples.

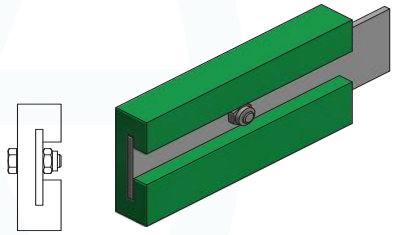
Profile A

Profile A - Plastic flight assembled on the steel scraper.



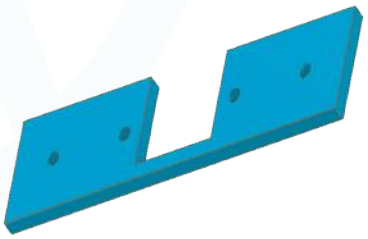
Profile C

Profiel C - Plastic scraper which can be pushed over the steel scrapers



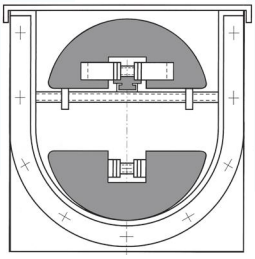
Bridge-profile

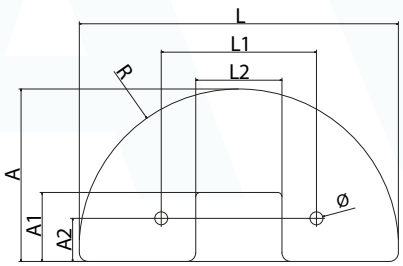
The “bridge” profile is assembled on the steel scrapers. The plastic runs under the chain and ensures less residue.



“Half moon” profile

The so-called “half-moon” profile is assembled on the steel scrapers.



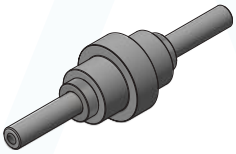


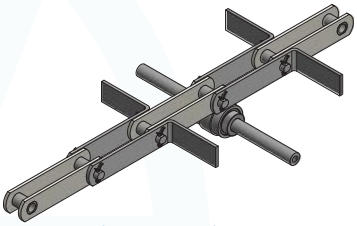
Accessories

VAV CirclipMaster

Circlips are an ideal way to secure the pin of a chain. The disadvantage is that they are difficult to disassemble. That is why VAV has developed the CirclipMaster. A hydraulic, hand-operated tool, applicable to circlips of various types of conveyor chain. The VAV CirclipMaster makes it possible to release circlips quickly, simple and safe from the pin.

Idler

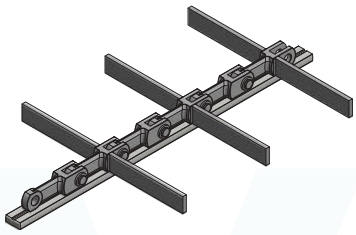




VAV supplies idlers according to your specifications. The idlers can be made of plastic (for example PE1000 or Nylon) or steel (optional hardened). The idlers can be equipped with ball bearings. The axe can be fitted with internal or external thread.

Idler in plastic or steel (parameters in mm)			
Inner width chain	Roller Ø	Shaft Ø	Internal thread
25	50/60	20	M10x25
30	50/60	20	M10x25
35	50/60	20	M10x25
45	60/70	20	M10x25

Wear-guiding rails



Wear-guiding rails for drop forged chain are available in Manganese steel (X120Mn12). The rails are provided with a guiding groove, for the ideal guidance of the drop forged chain.

Wear-guiding rails from material X120Mn12 (1.3401)			
Size (mm)	Length (meter)	Delivery	Weight (kg/m)
35 x 10	2,95 - 3,10	Stock	2,60
50 x 10	2,95 - 3,20	Stock	3,75
50 x 20	2,95 - 3,20		7,67
60 x 10	2,95 - 3,20	Stock	4,54
70 x 10	2,95 - 3,20		5,32
70 x 20	2,95 - 3,20	Stock	10,81

Chain calculations

Conveyor chain calculations

Chain speed in m/sec (v)

$$v = \frac{z \times p \times n}{60.000}$$

v	=	chain speed in m per sec
z	=	number of teeth
p	=	chain pitch
n	=	rotations per minute

Conveyor chain calculations

Capacity in m^3 per hour (Q)

$$Q = A \times v \times 3.600 \text{ sec.}$$

Q	=	capacity in m^3 per hour
A	=	trough width x layer height in m^2
v	=	chain speed in m per sec

Conveyor chain calculations

Material weight on the chain in kg (mass1)

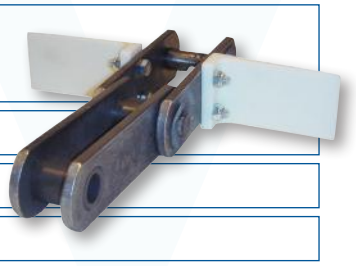
$$Mass_1 = \frac{\text{tons per hour x distance in meters}}{v \times 3,6}$$

$Mass_1$	=	material weight on the chain in kg
v	=	chain speed in m per sec

Conveyor chain calculations

Power in Kw (P)

$$P = \frac{(v \times mass_1 \times \mu_1 + mass_2 \times \mu_2) \times 9,81}{1.000}$$



P	=	power in Kw
v	=	chain speed in m per sec
$mass_1$	=	material weight on the chain in kg
μ_1	=	friction between steel and the product (for a smooth-running product ca. 1,15)
$mass_2$	=	total chain weight in kg
μ_2	=	friction between the steel bottom and the chain (for steel scrapers approx. 0,25 and for plastic flights approx. 0,15)