Development & Co-operation

BEIJING LEECHAIN

Corporate Product Brochure

Quality / Expertise / Globalisation

Beijing LeeChain Technology Ltd.

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about

Established in 2004, LeeChain brand has been engaged in the design, manufacture and service of round link chain for more than twenty years. We specialize in chains for coal, electric power, coal chemical industry, lifting and hoisting, etc. We can produce mining chains, slagging chains, lifting chains with diameters ranging from 26 to 56mm.

Product Offering (Two major series)

Chains: including various specifications of carburized super wear-resistant slag discharge chains, circular chains of different strength grades, compact chains, corrosion-resistant chains, wide-band chains and super flat chains

Chain link: V-lock type chain link, carburized and ladder tooth type chain link

Why Choose Us

LeeChain products are high performance, consistently maintained under strict quality control, and marketed to users worldwide. Proven in production environments for many years, they are known for their high stability and excellent price/performance ratio.

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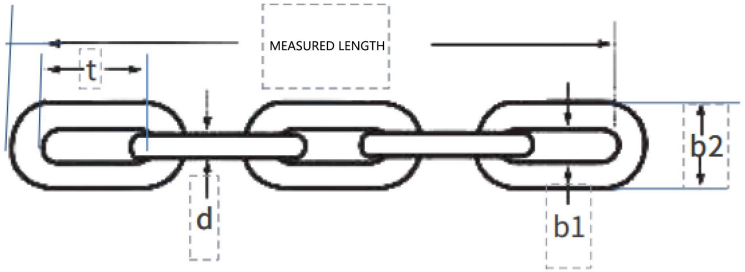
Chain Products

Round Link Chain

Chain meets the German standard DIN22252-2012 for conveying equipment

SPECIFICATION d x t	DIAMETER		PITCH		WIDTH		MEASURED LENGTH	
mm	d	TOLERANCE	t	TOLERANCE	MINIMUM INTERNAL WIDTH	MINIMUM INTERNAL WIDTH	5×t	TOLERANCE
26×92	26	±0.8	92	±0.9	30	85	460	±1.0
30×108	30	±0.9	108	±1.1	34	97	540	±1.1
34×126	34	±1.0	126	±1.3	38	110	630	±1.3
38×137	38	±1.1	137	±1.4	42	122	685	±1.4
42×146	42	±1.1	146	±1.5	48	139	730	±1.5



SPECIFICATION d x t	TEST LOAD TF	BREAKING LOAD BF	WORKING LOAD WF	MINIMUM TEST DEFLECTION	WEIGHT
mm	kN	kN	kN	mm	kg/m
26 × 92	637	850	531	26	13.7
30 × 108	848	1130	707	30	18
34 × 126	1090	1450	907	34	22.7
38 × 137	1360	1820	1130	38	29
42 × 146	1660	2220	1380	42	36.5

Remarks

- Maximum elongation at test load 1.6% Minimum elongation at breakage 14%
- KV impact test, minimum impact value 50J
- Fatigue test cycles at least 70,000 times, the average stress 150N/mm2, amplitude ± 100N/mm2。

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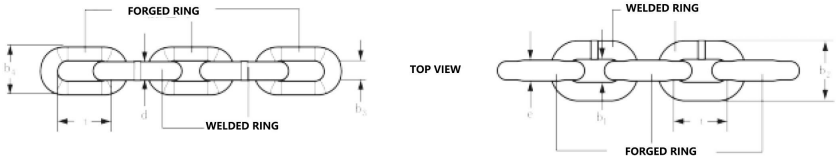
Chain Products

Compact Chain

Adopting forged vertical ring, applied to different specifications of mining compact chain, the performance of the product is obviously superior to that of adopting flat vertical ring structure. Execution standard: DIN22255-2012.

SPECIFICATION d x t	DIAMETER		THICKNESS	TOLERANCE		FLAT RINGS		VERTICAL RING	
						INNER WIDTH	OUTER WIDTH	INNER WIDTH	OUTER WIDTH
mm	d	TOLERANCE	e	t	TOLERANCE	b1 LEAST	b2 UTMOST	b3 LEAST	b4 UTMOST
26 × 92	26	± 0.8	30	92	± 0.9	30	87	30	75
30 × 108	30	± 0.9	34	108	± 1.1	34	99	34	87
34 × 126	34	± 1.0	38	126	± 1.3	38	111	38	99
38 × 126	38	± 1.1	42	126	± 1.3	42	123	42	111
38 × 137	38	± 1.1	42	137	± 1.4	42	123	42	111
38 × 146	38	± 1.1	42	146	± 1.5	42	123	42	111
42 × 146	42	± 1.1	48.5	146	± 1.5	49	139	46	115
48 × 152	48	± 1.5	56	152	± 1.5	62	163	53	127



SPECIFICATION dxt	TEST LOAD TF	BREAKING LOAD BF	WORKING LOAD WF	MINIMUM TEST DEFLECTION	WEIGHT
mm	kN	kN LEAST	kN UTMOST	mm	kg/m
26x92	637	850	531	26	13. 9
30x108	848	1130	707	30	18. 1
34x126	1090	1450	907	34	22. 9
38x126	1360	1820	1130	38	30
38x137	1360	1820	1130	38	29
38x146	1360	1820	1130	38	27. 6
42x146	1660	2220	1380	42	37
48x152	2170	2900	1810	48	48. 8

Remarks

- Maximum elongation at test load 1.6%, minimum elongation at breakage 11%.
- KV impact test, minimum impact value 50J
- Fatigue test at least 70,000 cycles, average stress 150N/mm2, amplitude ± 100N/mm2

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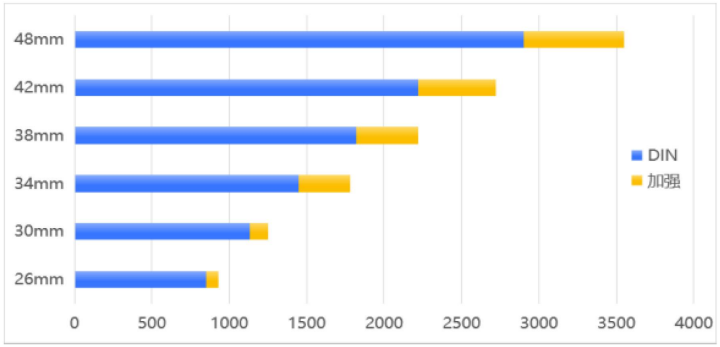
Chain Products

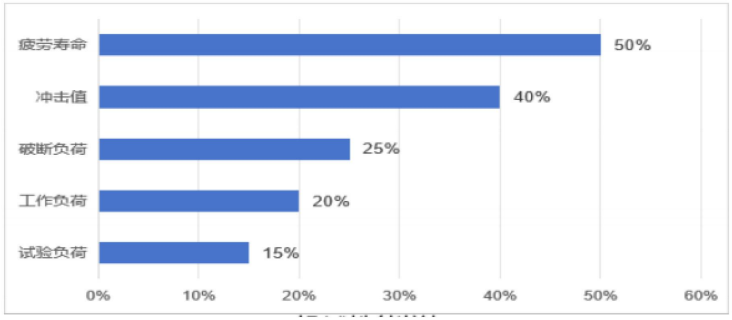
Reinforced Circular and Compact Chains

Reinforced chains are further processed using proprietary heat treatment technology and have the same dimensional data as regular chains. Reinforced chains are characte rised by high strength and long life.

Reinforced Compact Chain has better tensile strength, fatigue life and toughness due to the use of forged vertical rings and special heat treatment. The optimum hardness distribution of each ring reduces inter-ring wear and significantly increases service life.



BREAKING STRENGTH



INCREASED MECHANICAL PROPERTIES

◆Strengthened mechanical properties of round chain

SPECIFICATION d x t mm	TEST LOAD TF kN	BREAKING LOAD BF kN	WORKING LOAD WF kN最大	MINIMUM TEST DEFLECTION mm	NUMBER OF FATIGUE TESTS (MINIMUM)
22 × 86	525	745	456	22	105,000
26 × 92	733	1040	637	26	
30 × 108	976	1390	848	30	
34 × 126	1250	1780	1090	34	
38 × 137	1560	2220	1360	38	

◆strengthened mechanical properties of compact chain

SPECIFICATION d x t mm	TEST LOAD TF kN	BREAKING LOAD BF kN	WORKING LOAD WF k N	MINIMUM TEST DEFLECTION mm	NUMBER OF FATIGUE TESTS (MINIMUM)
26 × 92	650	930	580	26	105,000
30 × 108	845	1250	782	30	
34 × 126	1250	1780	1090	34	
38 × 126	1560	2220	1360	38	
38 × 137	1560	2220	1360	38	
38 × 146	1560	2220	1360	38	
42 × 146	1910	2720	1660	42	

Remarks

◆Maximum elongation under experimental load 1.6%, minimum elongation at breakage 14%, minimum impact value of 50J in KV impact test

◆Refer to DIN22252:2012 Verification Method and Procedure

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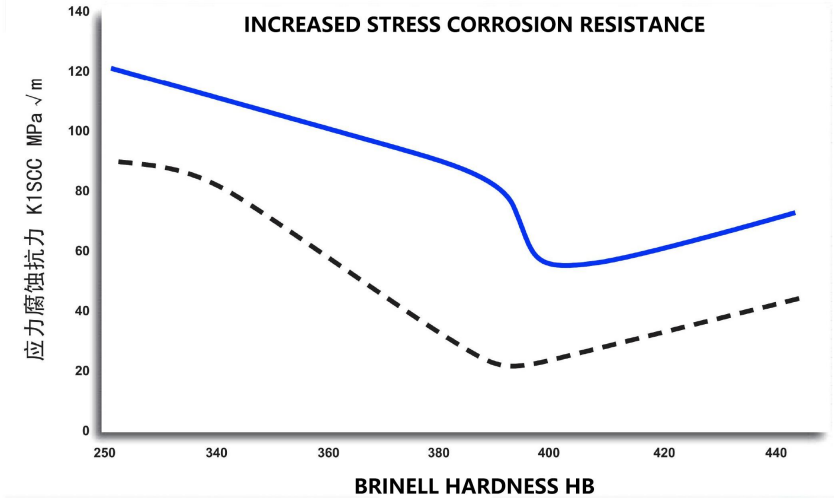
Chain Products

Anti-corrosion circular and compact chains

Unlike zinc-dipped chains, the corrosion protection does not deteriorate with surface wear. It is particularly suitable for continuous operation in corrosive environments and has better mechanical properties than normal chains.



◆Mechanical properties of anti-corrosion round link chain

SPECIFICATION d x t	TEST LOAD TF	BREAKING LOAD BF	WORKING LOAD WF	MINIMUM TEST DEFLECTION	FATIGUE TEST	CHAIN TYPE	
mm	kN	kN	kN UTMOST	mm	LEAST	CIRCULAR CHAIN	COMPACT CHAIN
26 × 92	637	930	580	26	105,000	√	√
30 × 108	848	1230	770	30		√	√
34 × 126	1090	1600	1000	34		√	√
38 × 126	1360	2000	1250	38		√	√
38 × 137	1360	2000	1250	38		√	√
38 × 146	1360	2000	1250	38		√	√
42 × 146	1660	2440	1520	42		×	√
48 × 152	2170	3180	1990	48		×	√

Remarks

◆Maximum elongation of 1.6% under experimental load, minimum elongation of 14% at breakage.

◆KV impact test, minimum impact value 50J.

◆Fatigue test at least 70,000 cycles, average stress 150N/mm2, amplitude ±100N/mm2.

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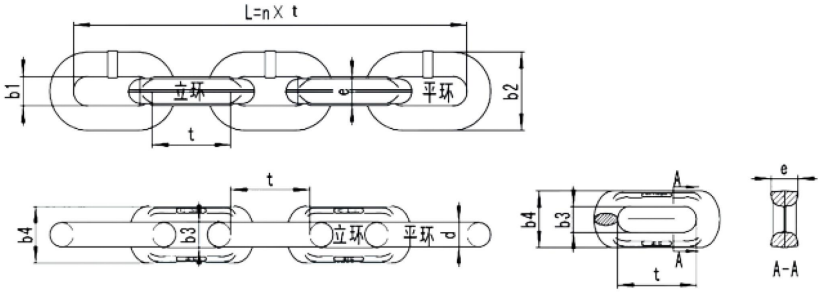
Chain Products

Super Flat Chain

Ultra-flat chain is a kind of chain with lower height than compact chain, for example, the height of 42×146 ultra-flat chain is the same as that of 38×137 compact chain and 34×126 round chain, which makes it possible to replace them freely.

The optimised vertical ring structure of super flat chain can avoid and reduce the knots caused by stacked chains, and the increased contact surface area at the overlap of flat and vertical rings can significantly reduce the contact pressure and wear between the chain rings, and improve the wear resistance and service life of the chain.。



$d/b_4 \times t$ OR $d/b_4 \times t_1/t_2$ mm	DIAMETER d		VERTICAL RING THICKNESS e	PITCH t OR t_1/t_2		FLAT RINGS INNER WIDTH b_1	FLAT RINGS OUTER WIDTH b2	VERTICAL RING INNER WIDTH b_3	VERTICAL RING OUTER WIDTH b4	ARC ENRICHMENT r		MASS PER UNIT LENGTH kg/m
	mm		mm	mm		mm	mm	mm	mm	mm		
	NOMINAL SIZE	LIMIT DEVIATION	UTMOST	NOMINAL SIZE	LIMIT DEVIATION	LEAST	UTMOST	LEAST	UTMOST	NOMINAL SIZE	LIMIT DEVIATION	
26/60 × 92	26	± 0.8	30	92	± 0.9	30	87	28	60	40	2 0	12.9
26/64 × 92	26	± 0.8	30	92	± 0.9	30	87	30	64	40	2 0	13.3
30/75 × 108	30	± 0.9	34	108	± 1.1	34	99	33	75	46	2 0	17.6
34/85 × 126	34	± 1.0	37	126	± 1.3	38	111	37	85	52	2 0	22.4
34/94 × 126	34	± 1.0	36	126	± 1.3	38	111	37	94	52	2 0	22.5
38/97 × 126	38	± 1.1	42	126	± 1.3	44	126	42	97	59	2 0	29.6
38/99 × 137	38	± 1.1	42	137	± 1.4	44	126	42	99	59	2 0	28.9
42/110 × 137	42	± 1.1	46	137	± 1.4	46	135	46	110	64	2 0	35.4
42/110 × 146	42	± 1.1	46	146	± 1.5	46	135	46	110	64	2 0	34.1
48/115 × 152	48	± 1.4	58	152	± 1.6	62	163	53	115	78	2 0	46.3
48/115 × 144/160	48	± 1.4	58	144/160	± 1.5/± 1.6	62	163	53	115	78	2 0	45.5
52/127 × 170	52	± 1.7	63	170	± 1.9	65	177	56	127	83	2 0	53.8
56/133 × 187	56	± 1.9	65	187	± 2.1	69	187	60	133	92	2 0	59.9
60/136 × 181/197	60	± 2.0	70	181/197	± 2.3	73	198	63	136	96	2 0	66

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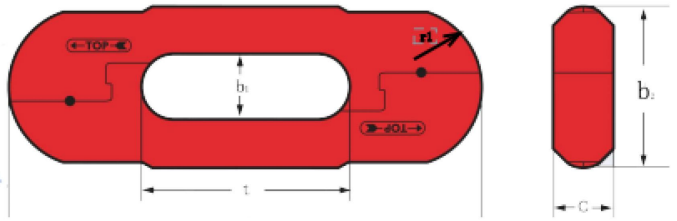
SPECIFICATION d/b4 ×t OR d/b4 ×t1 /t2	TEST LOAD	BREAKING LOAD	WORKING LOAD	AKv IMPACT	MINIMUM TEST DEFLECTION
mm	kN	kN	kN	J	TIMES
26/60×92	570	750	470		
26/64×92	637	850	531		
30/75×108	848	1130	707		
34/85×126	970	1280	800		
34/94×126	1090	1450	907		
38/97×126	1360	1820	1130		
38/99×137	1360	1820	1130		
42/110×137	1660	2300	1380	≥60	≥10万
42/110×146					
48/115×152	1900	2900	1800		
48/115×144/160					
52/127×170	2380	3400	2120		
56/133×187	2600	3930	2460		
60/136×181/197	3000	4500	2820		

V-Lock Chainring



SPECIFICATION d×t	PITCH t	PITCH TOLERANCE	WIDTH INNER WIDTH b1 min.	WIDTH OUTER WIDTH b2 max.	ADAPTER RING THICKNESS c max.	FOREIGN MINISTER l max.	RADIUS r1 max.
34×126	126	±1,3	37	99	36	297	103
38×137	137	±1,4	41	111	40	322	112
38×146	146	±1,5	41	111	40	348	120
42×146	146	±1,5	45	115	46	341	119
48×152	152	±1,5	52	127	56	347	122

V-Lock couplings are specially designed for connecting round and compact chains and have very high tensile properties and fatigue life due to the choice of high alloy steel raw materials with high Cr, Ni and Mo content and multiple heat treatment processes during manufacturing.

The V-Lock couplings are available only in vertical position, have a profile according to DIN 22258 Part 3 and have been carefully designed to ensure an excellent fit to the sprocket.

V-Lock chainrings are lighter in weight than other types of chainrings.。

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Chain Products

Trapezoidal chain ring

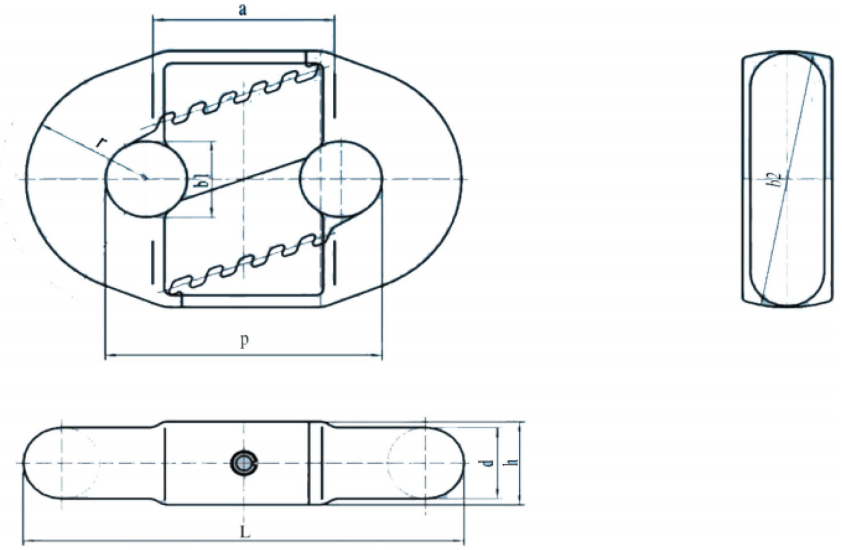
For use in scraper conveyor drive systems in both horizontal and vertical planes, with preference given to horizontal connections. The dimensions of trapezoidal chain rings are in accordance with DIN22258 Part1 2012 and MT/T99-1997 standards. During the manufacturing process, high alloy steel raw materials rich i n Cr, Ni and Mo alloying elements and multiple heat treatment processes are selected to ensure an excellent fit and safe operation with the matching sprockets. The surface of trapezoidal chain link is treated with special anti-corrosion treatment to prolong its service life.

◆Mechanical Properties of Shaved Tooth Type Chain Link

SPECIFICATION	MINIMAL BREAKAGE LOAD (KN)	PULSATING LOAD RANGE LOWER LIMIT	PULSATING LOAD RANGE UPPER LIMIT	FATIGUE (NUMBER OF CYCLES)	WEIGHT (kg)
22×86	610	38	190	40000	1.9
26×92	850	53	266	40000	2.1
30×108	1130	71	353	40000	3.1
34×126	1450	91	454	40000	4.5

Fatigue test min. 40,000 cycles; average stress 150N/mm2; amplitude ±100N/mm2; KV impact test min. 55J (typical 70J); refer to DIN22258-2012 Part1 standard test methods and procedures.

◆Dimensional parameters of trapezoidal chain rings



SPECIFICATION	SIZE							
	d	p	L_{max}	$b1_{min}$	$b2_{max}$	h_{max}	r	a_{max}
22×86	22±0.7	86±0.9	132	24	85	27	33°	58
26×92	26±0.8	92±0.9	146	28	97	33	41°	63
30×108	30±0.9	108±1.1	170	32	109	36	47°	72
34×126	34±1.0	126±1.3	196	36	121	41	52°	82

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Chain Products

Chain Pairing

Accurate chain pairing is critical to the successful operation of the conveyor. LeeChain chains are paired one-to-one to ensure that the scrapers stay in a straight line and that the scrapers remain stable in the centre channel. The ends of the paired chains are colour-coded and attached to a metal tag with a unique identification number for each chain. There are also other plastic labels attached to each chain with different details of the paired chains and further instructions for pairing.

For 42mm and under chains the pairs are placed in a single box and for 48mm and over chains one per box. Each label, as well as the top and side of the box, has code information attached to it to ensure that the chains in each box are matched together at exactly the same length. The ends of the matched chains must be aligned and clearly identifiable. Pairs of chains must not be used separately.

◆The following list shows the recommended pair lengths and weights.

GENERAL SIZE d×t	PAIRING				WEIGHT kg	
	LENGTH	TOLERANCE mm		NUMBER OF RINGS		
mm	m	mm	TYPICAL		RINGS	COMPACT RINGS
22×86	25. 03	8	4	291	476	
	50. 14	16	8	583	957	
	100. 36	32	16	1167	1916	
26×92	25. 16	8	4	273	686	
	50. 14	16	8	545	1370	
	100. 00	32	16	1087	2733	
30×108	25. 16	8	4	233	911	
	50. 00	16	8	463	1810	
	100. 12	32	16	927	3625	
34×126	25. 07	8	4	199		1159
	50. 02	16	8	397	2272	2312
38×126	50. 27	16	8	399	2952	2958
38×137	50. 00	16	8	365	2810	2848
38×146	50. 08	16	8	343	2785	2811
42×146	50. 08	16	8	343		3376
48×152	50. 01	16	8	329		4714
50×146/174	49. 99	16	8	313		4757
52×170	50. 15	20	10	295		5396
56×187	50. 30	20	10	269		6026
60×181/197	50. 08	20	10	265		6611
65×203	50. 14	20	10	247		8814

Pairing tolerance is the maximum permissible amount of difference in the length of any pair of chains.

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