



HEKO
GROUP
CONVEYOR SOLUTIONS

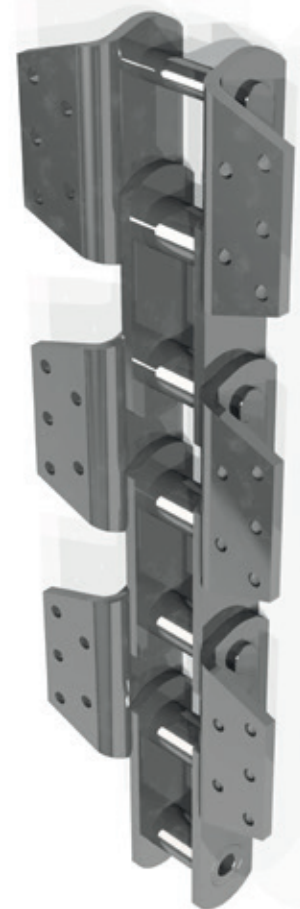


CENTRAL CHAINS FOR BUCKET ELEVATORS

HEKO central chains with integral bucket holders



HEKO central chains with separate bucket holders



HEKO's central bucket elevator chains and wheels are manufactured to HEKO's own standard and their flexible manufacturing facilities also enables the production to other dimensions and parameters. The high chain speed utilised in central chain bucket elevators generates high dynamic loads. HEKO therefore design and manufacture the chain and accessories to the highest fatigue strength, breaking load and wear resistance, thus resulting in optimal service life. HEKO chains with integral bucket holders are manufactured from fine grained sheet steel. Bucket holders are bent to form an angle so that the buckets can be bolted to the chain. A precision bending press is used to ensure maintaining close dimensional tolerances.

Technical specifications

name	pitch [mm]	clearance width [mm]	bush-Ø [mm]	breaking force [kN]
HBE 1	140	50	38	450
HBE 2	152.4	65	45	540
HR 856	152.4	76	44.5	450
HR 857	152.4	76	44.5	600
HR 956	152.4	76	44.5	600
HR 958	152.4	76	50.8	750
HR 859	152.4	95	60.5	900
HR 864	177.8	95	60.5	900
HR 984	177.8	95	63.5	1150

HEKO's central bucket elevator chain with separate bucket holders are fitted with forged holders which are bushed onto the extended pins. Both the pins and bores are induction hardened. Depending on chain size, a gap of up to 1.5 mm is left between the chain link and bucket holder. This considerably reduces the transmission of vibration to the chain, the latter resulting from the polygon effect when the chains enter the chain wheel. Decoupling the bucket from the chain prevents cracks arising in the back of the buckets and weld seams. HEKO manufacture a standard range of chain links from fabricated fine-grained sheet steel as well as forged steel.

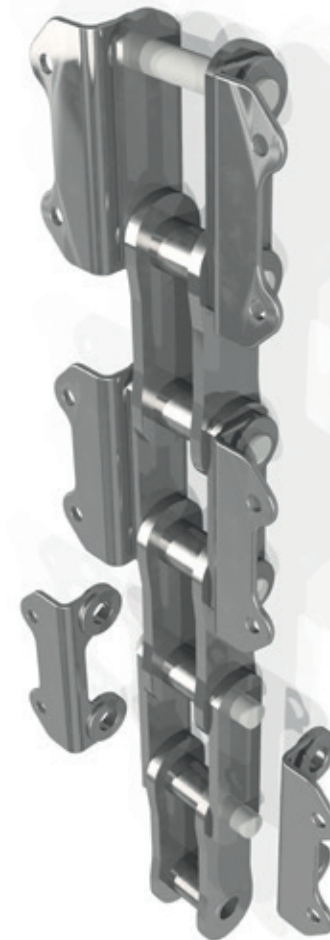
Technical specifications

Sheet Steel chains with separate bucket holders

name	pitch [mm]	clearance width [mm]	bush-Ø [mm]	breaking force [kN]
HBE 3	177.8	70	52	950
KBE 4	180	70	56	1150
HK800	180	85	53.7	1000
HK1200	180	100	60	1200
HK1600	180	110	75	1600
HK2000	200	115	80	2000

Forged link chain with separate bucket holders

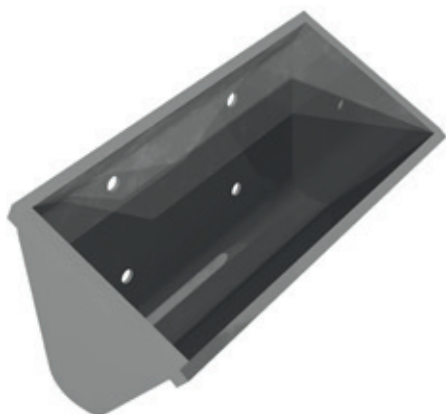
name	pitch [mm]	clearance width [mm]	bush-Ø [mm]	breaking force [kN]
HBE 4	177.8	70	58	1250
HBE 5	177.8	85	63	1600
HBE 6	177.8	95	71	1950
KBE 5	180	80	62	1450



HEKO Chain wheels and buckets



HEKO Produces both toothed and toothless drive and idling wheels. Generally, the friction between the chain and wheel rims is usually sufficient so that toothless rims are employed as HEKO standard. Chain speeds of up to 2 m/s are possible. However, if the friction grip is found to be insufficient then toothed rims are fitted. The contact surfaces of both toothed and toothless wheels are induction hardened with the hardness and hardening depth selected to suit the operating conditions to achieve an optimum service life of both chains and wheel rims.



HEKO also produce elevator buckets, both to HEKO's own standard, which achieve optimum performance, or to suit customers' requirements.