

HEKO round link chains (DIN)

HEKO qualities

HEKO Case Hardening represents:

- Highly wear resistant hardened surface, min. surface hardness 800HV
- High fatigue strength
- High breaking strength through fine-grained, tough core
- Excellent dimensional tolerance

HEKO tempered represents:

- Very high breaking strengths



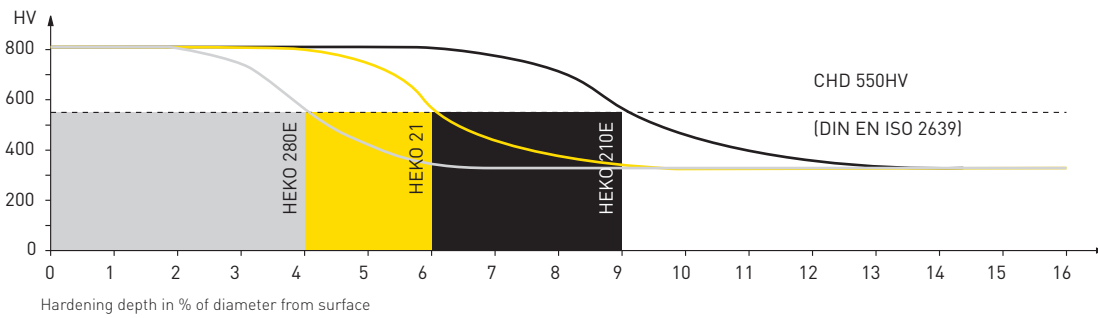
Cross section through case hardened chain link



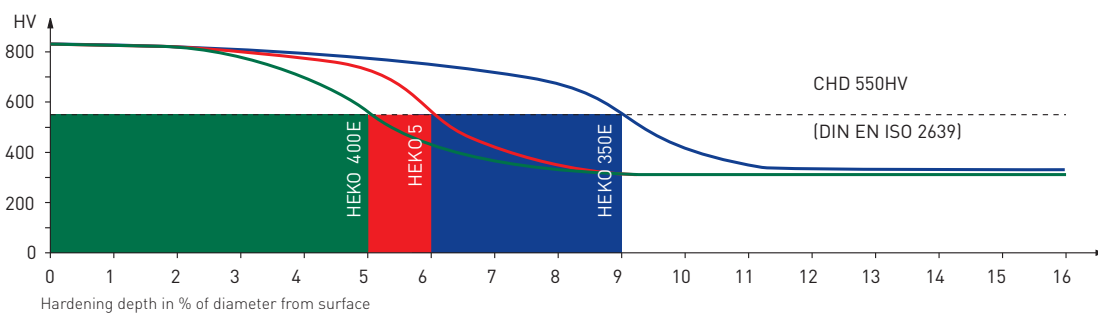
HEKO round link chains (DIN)

HEKO qualities

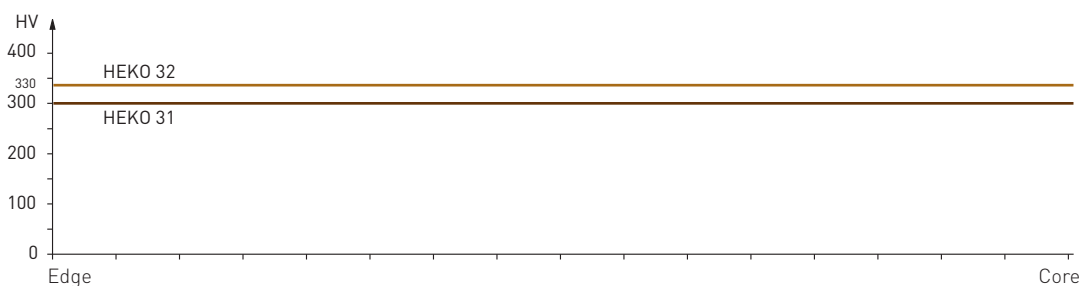
Technical data for case hardened manganese steel chains



Technical data for case hardened Chrome-Nickel or Chrome-Nickel-Molybdenum steel chains



Technical data for tempered manganese-, Chrome-Nickel or Chrome-Nickel-Molybdenum steel chains



HEKO round link chains (DIN)

HEKO has utilised a special case hardening process for decades and has been at the forefront in the further development of hardening technology. Modern technology employed nowadays results in excellent wear resistance of the chains. The quality of case hardening achieved in our vacuum ovens with Helium quenching is currently leading this technology worldwide.

Generally, HEKO recommends case hardened chains for chain conveyors. In special cases, highly tempered round link chains manufactured from manganese steel, or CrNi or CrNiMo alloy steel are used.

Technical data for HEKO chain qualities

	case hardened qualities Mn-steel			case hardened qualities CrNi-steel/CrNiMo-steel		
	HEKO 280E	HEKO 21	HEKO 210E	HEKO 400E	HEKO 5	HEKO 350E
Proof stress N/mm ²	140	125	105	240	150	210
Breaking stress N/mm ²	280 ₁₎	250	210 ₁₎	450 _{1) 2)}	370 ₇₎	350 ₁₎
Contact surface hardness min. joint HV 1	800	800	800	825	825	825
Case hardening depth d+/-0.01 d after etching	0.07	0.10	0.14 ₃₎	0.09	0.10	0.14 ₃₎
Case hardening depth d min. CHD _{d)} 550	0.04	0.06 ₄₎	0.09 ₅₎	0.05	0.06 ₄₎	0.09 ₅₎

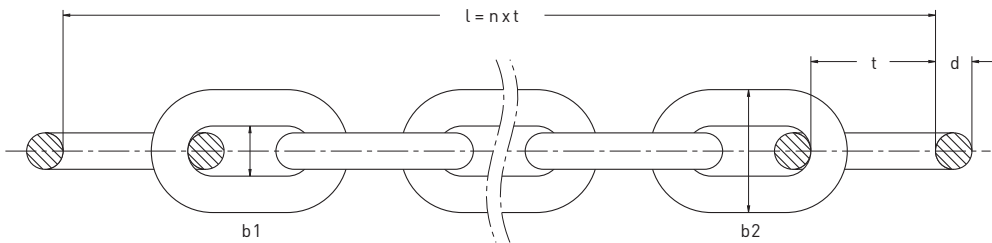
1) tolerance 10%
2) up to
3) 30 mm Ø = 0,12 d, 36-42 mm Ø = 0,11 d
4) > 30 mm Ø = 0,05 d

5) 30 mm Ø = 0,08 d, 36-42 mm Ø = 0,07 d
6) CHD = Case hardening depth
7) > 30 mm Ø = tolerance 20%

	tempered qualities	
	Mn-steel	CrNi-/CrMo-steel
	HEKO 31	HEKO 32
Proof stress N/mm ²	250	300
Breaking stress N/mm ²	500	600
Contact surface hardness min. joint HV 1	300	330

HEKO round link chains (DIN)

Dimensions and technical characteristics of HEKO round link chains



nominal diameter x pitch (mm)	DIN chain	weight (kg/m)	inside width min. (mm)	outside width max. (mm)	HEKO qualities							
					case hardened					tempered		
d x t			b1	b2	280E MBK kN	21 MBK kN	210E MBK kN	400E MBK kN	5 MBK kN	350E MBK kN	31 MBK kN	32 MBK kN
10 x 28	766	2.3	12.0	36.0	44	39	33	63	58	55	78	94
10 x 35	764	2.0	14.0	36.0	44	39	33	63	58	55	78	94
13 x 36	766	3.9	15.6	47.0	74	66	56	106	98	93	132	159
13 x 45	764	3.5	18.0	47.0	74	66	56	106	98	93	132	159
16 x 45	766	5.8	19.2	58.0	112	100	84	160	148	140	201	241
16 x 56	764	5.2	22.0	58.0	112	100	84	160	148	140	201	241
18 x 50	766	7.4	21.6	65.0	142	127	107	204	188	178	254	305
18 x 63	764	6.5	24.0	65.0	142	127	107	204	188	178	254	305
20 x 56	766	9.0	24.0	72.0	175	157	132	251	232	220	314	376
20 x 70	764	8.2	27.0	72.0	175	157	132	251	232	220	314	376
22 x 77	764	10.7	31.0	82.0	212	190	160	304	281	266	380	456
23 x 64	766	12.0	27.6	83.0	232	207	174	332	307	290	415	498
23 x 80	764	11.0	31.0	83.0	232	207	174	332	307	290	415	498
26 x 73	766	15.0	31.2	94.0	298	265	223	425	392	371	530	637
26 x 91	764	14.0	35.0	94.0	298	265	223	425	392	371	530	637
28 x 78	766	18.0	33.6	101.0	344	308	258	492	455	431	615	739
28 x 98	764	16.5	36.0	101.0	344	308	258	492	455	431	615	739
30 x 84	766	20.0	36.0	108.0	395	353	296	565	523	494	706	848
30 x 105	764	19.0	39.0	108.0	395	353	296	565	523	494	706	848
33 x 92	766	25.0	43.0	119.0	478	427	359	684	633	598	855	1026
33 x 115	764	22.5	43.0	119.0	478	427	359	684	633	598	855	1026
36 x 101	766	29.0	43.2	130.0	570	508	428	814	753	712	1017	1221
36 x 126	764	26.5	47.0	130.0	570	508	428	814	753	712	1017	1221
39 x 109	766	34.0	51.0	140.0	669	597	502	956	884	836	1194	1433
39 x 136	764	31.0	51.0	140.0	669	597	502	956	884	836	1194	1433
42 x 118	766	40.0	50.0	151.0	776	692	582	1108	1025	970	1385	1662
42 x 147	764	36.0	55.0	151.0	776	692	582	1108	1025	970	1385	1662

MBK = min. breaking load, d = diameter, t = pitch, WN = works standard. Additional dimensions and qualities on request, including stainless steel. Trouble-free operation is only achieved by matching chains and attachments with the chain wheels.

Tolerance of chains bundled in pairs ≤ 1 mm