

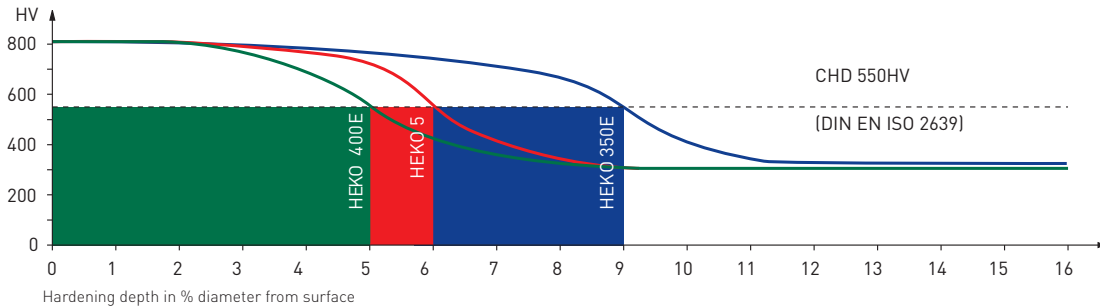
HEKO round link chains (ENDLESS)

HEKO qualities and case hardening

HEKO Case Hardening represents:

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

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



HEKO has utilised a special case hardening process for decades and has been at the forefront in the further development of hardening technology.

Nowadays, excellent wear resistance chains can only be manufactured with the latest technology. In HEKO own vacuum ovens with Helium quenching, a leading quality of case hardening will be achieved, which is currently a leading technology worldwide.

Technical data for HEKO chain qualities

	case hardened qualities CrNi-steel/CrNiMo-steel		
	HEKO 400E	HEKO 5	HEKO 350E
Proof stress N/mm ²	240	150	210
Breaking stress N/mm ²	400 ₁₎	370 ₆₎	350 ₁₎
Contact surface hardness min. joint HV 1	800	800	800
Case hardening depth d+/-0.01 d after etching	0.09	0.10	0.14 ₂₎
Case hardening depth d min. CHD ₅₎ 550	0.05	0.06 ₃₎	0.09 ₄₎

1) tolerance 10%

2) 30 mm Ø = 0,12 d,
34 mm Ø = 0,115 d,
36-42 mm Ø = 0,11 d

3) ≥ 30 mm Ø = 0,05 d

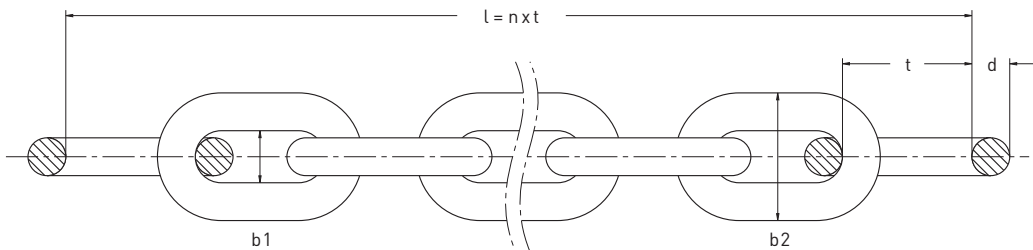
4) 30 mm Ø = 0,08 d,
34 mm Ø = 0,075 d,
36-42 mm Ø = 0,07 d

5) CHD = Case hardening depth
6) ≥ 30 mm Ø = tolerance 20%

HEKO round link chains (ENDLESS)

HEKO round link chains as per works standard

- Technical character of the chain can be optimised for the intended application
- Min. surface hardness 800 HV
- Each strand length up to 750 kgs
- Various number of chain links possible
- High fatigue strength
- Can be supplied as matched pairs



Dimensions and qualities of HEKO chains suitable for attachment type SMO

Nominal diam. x pitch (mm)	works standard	weight (kg/m)	inside width min. (mm)	outside width max. (mm)	case hardened HEKO qualities		
					HEKO 400E MBK (kN)	HEKO 5 MBK (kN)	HEKO 350E MBK (kN)
d x t			b1	b2			
14 x 50	WN	4.1	16.3	47	123	114	108
16 x 64	WN	5.1	20.0	55	160	148	140
19 x 75	WN	7.6	22.0	63	227	210	198
22 x 86	WN	9.8	26.0	74	304	281	266
25 x 95	WN	12.4	34.0	89	393	363	344
26 x 92	WN	13.7	30.0	85	425	392	371
26 x 100	WN	13.5	31.0	87	425	392	371
30 x 108	WN	18.0	34.0	102	565	523	494
30 x 120	WN	17.8	36.0	102	565	523	494
34 x 126	WN	26.0	38.0	109	726	672	635
34 x 136	WN	23.8	39.0	113	726	672	635
38 x 144	WN	30.0	44.0	127	907	839	794

MBK = breaking load, d = diameter, t = pitch, WN = works standard, Further dimensions and qualities on request, also in stainless steel available.