

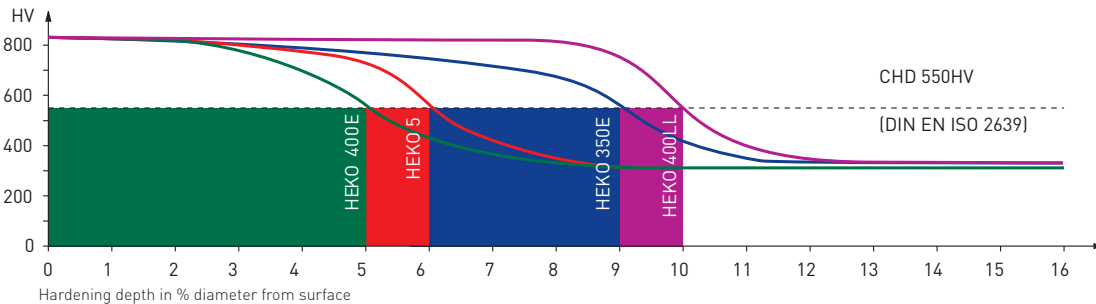
# HEKO round link chains (ENDLESS)

## HEKO qualities and case hardening

### HEKO Case Hardening represents:

- Highly wear resistant case hardened surface, min. surface hardness 825HV
- 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	HEKO 400LL
Proof stress N/mm <sup>2</sup>	240	150	210	240
Breaking stress N/mm <sup>2</sup>	450 <sub>1,2)</sub>	370 <sub>7)</sub>	350 <sub>1)</sub>	400 <sub>1)</sub>
Contact surface hardness min. joint HV 1	825	825	825	825
Case hardening depth d+/-0.01 d after etching	0,09	0,10	0,14 <sub>3)</sub>	0,16
Case hardening depth d min. CHD <sub>d)</sub> 550	0,05	0,06 <sub>4)</sub>	0,09 <sub>5)</sub>	0,10

- 1) tolerance 10%  
 2) up to  
 3) 30 mm  $\varnothing = 0,12$  d,  
 34 mm  $\varnothing = 0,115$  d,  
 36-42 mm  $\varnothing = 0,11$  d

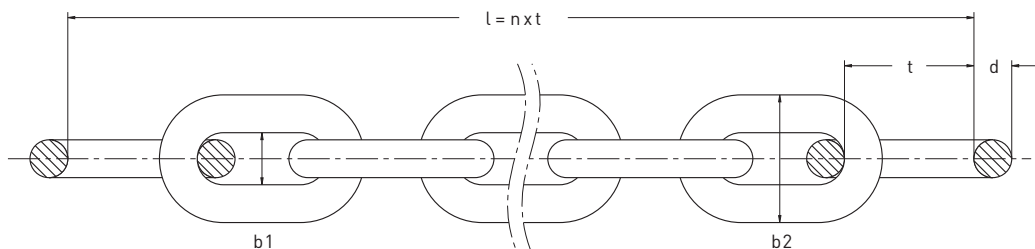
- 4)  $\geq 30$  mm  $\varnothing = 0,05$  d  
 5) 30 mm  $\varnothing = 0,08$  d,  
 34 mm  $\varnothing = 0,075$  d,  
 36-42 mm  $\varnothing = 0,07$  d

- 6) CHD = Case hardening depth  
 7)  $\geq 30$  mm  $\varnothing =$  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 825 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)	HEKO 400LL MBK (kN)
d x t			b1	b2				
14 x 50	WN	4.1	16.3	47	140	114	108	-
16 x 64	WN	5.1	20.0	55	180	148	140	-
19 x 75	WN	7.6	22.0	63	260	210	198	230
22 x 86	WN	9.8	26.0	74	350	281	266	315
25 x 95	WN	12.4	34.0	89	400	363	344	-
26 x 92	WN	13.7	30.0	85	425	392	371	-
26 x 100	WN	13.5	31.0	87	475	392	371	432
30 x 108	WN	18.0	34.0	102	565	523	494	-
30 x 120	WN	17.8	36.0	102	640	523	494	580
34 x 126	WN	26.0	38.0	109	726	672	635	-
34 x 136	WN	23.8	39.0	113	726	672	635	670
38 x 144	WN	30.0	44.0	127	920	839	794	850

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