

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ADDENDUM 1
TO
ISO
RECOMMENDATION
R 1835

SHORT LINK CHAIN FOR LIFTING PURPOSES

GRADE 40 NON-CALIBRATED CHAIN
FOR CHAIN SLINGS, ETC.

1st EDITION

September 1972

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Printed in Switzerland

Also issued in French and Russian. Copies to be obtained through the national standards organizations.

FOREWORD

Addendum 1 to ISO Recommendation R 1835-1971 was drawn up by Technical Committee ISO/TC 111, *Round steel link chains, chain wheels, lifting hooks and accessories*.

It was approved in January 1972 by the Member Bodies of the following countries :

Australia	Israel	South Africa, Rep. of
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INTRODUCTION

This Addendum is intended as an Appendix to ISO Recommendation R 1835 and lists 16 additional sizes of lifting chains, Grade 40* non-calibrated for use as load chains in pulley blocks and similar appliances.

These 16 sizes are being appended to ISO Recommendation R 1835 to indicate how its general requirements could be applied to other sizes of chains in current use. The sizes have been added as a temporary measure as an aid to chain selection until the recommended sizes are in general international use.

APPENDIX

TABLE Z.1 – Temporary additional dimensions of Grade 40 non-calibrated chain
(For symbols see Fig. 1 and 2)

Dimensions in millimetres

(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
Nominal size d_n	Diameter tolerance $(d - d_n)$	Maximum additional weld dimensions (See Fig. 1)		Outside link length limits		Outside link width w max.		Minimum inside link width $(1.25 d_n)$
		$(d_w - d)$ max.	$(G - d)$ max.	max. ($5 d_n$)	min. ($4.75 d_n$)	away from weld ($3.5 d_n$)	max. extra at weld ($0.05 w$)	
6	$+ 0.12$ $- 0.36$	1.2	2.1	30	28	21	1.1	7.5
7	$+ 0.14$ $- 0.42$	1.4	2.5	35	33	25	1.3	8.7
8.7	$+ 0.17$ $- 0.52$	1.7	3.0	44	41	30	1.5	10.8
9.5	$+ 0.19$ $- 0.57$	1.9	3.4	48	45	33	1.7	11.8
10.3	$+ 0.21$ $- 0.62$	2.1	3.6	52	49	36	1.8	12.8
11	$+ 0.22$ $- 0.66$	2.2	3.9	55	52	39	2.0	13.7
12	$+ 0.24$ $- 0.72$	2.4	4.2	60	57	42	2.1	15.0
13	$+ 0.26$ $- 0.78$	2.6	4.6	65	61	46	2.3	16.2
13.5	$+ 0.27$ $- 0.81$	2.7	4.8	68	64	47	2.4	16.8
16.7	$+ 0.33$ $- 1.00$	3.3	5.9	84	79	58	2.9	20.9
19	± 0.95	3.8	6.7	95	90	67	3.4	23.7
20.6	± 1.0	4.1	7.2	103	98	72	3.6	25.7
25.4	± 1.3	5.1	8.9	127	121	89	4.5	31.7
30	± 1.5	6.0	10.5	150	142	105	5.3	37.5
41.3	± 2.1	8.3	14.5	207	196	145	7.3	51.6
46.0	± 2.3	9.2	16.1	230	219	161	8.1	57.5

NOTE. – The measurements given in column 9 are made away from the weld, but smooth welded chains customarily meet the requirement at the weld also.

* To be known in future as Grade M.