MEASURING LEAF CHAIN LENGTH

TECHNICAL SHEET

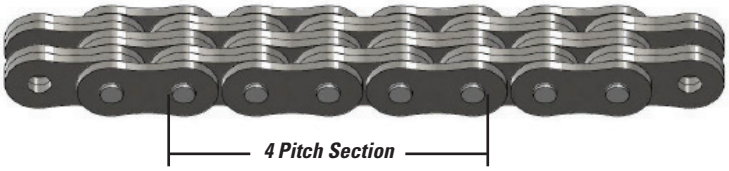


Figure 1: Measure 4 Pitch Section with a Caliper or Tape Measure

Figure 2: Leaf Chain EZ Chain Wear Gauge®

INSTRUCTIONS

1. The measurement should contain equal number of inner links and outer links.
2. Measuring longer sections will give more realistic estimations.
3. Chain on equipment should be measured on the tension side.
4. Measurement is outside of pin to outside of pin.
5. Chain not on equipment requires the specified minimum measuring load.

Note: In applications, the tape measure is the most common tool used to measure chain length. However, a caliper will be more accurate and should be used when possible.

TABLE 1.
MEASUREMENT SPECS NEEDED PER CHAIN SIZE

Chain Size	P = Pitch	PD = Pin Diameter	Minimum Measuring Load
	in.	in.	lb.
BL12	1.500	0.500	400
BL14	1.750	0.562	530
BL16	2.000	0.687	800

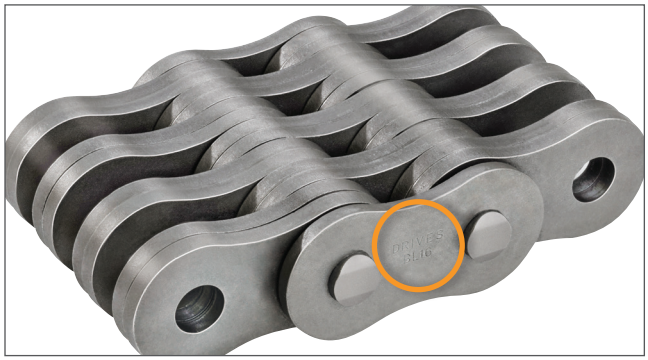
LEAF CHAIN % ELONGATION FORMULA

$$\% \text{ Elongation} = \frac{(AML - NL)}{NL} * 100$$

P	Pitch [inches]	Table 1
NP	Number of Pitches	# of Measured Pitches
NL	Nominal Length [inches]	NL = P * NP
PD	Pin Diameter [inches]	Table 1
ML	Measured Length [inches]	From Tape Measure or Caliper
AML	Adjusted Measured Length [inches]	AML = ML - PD

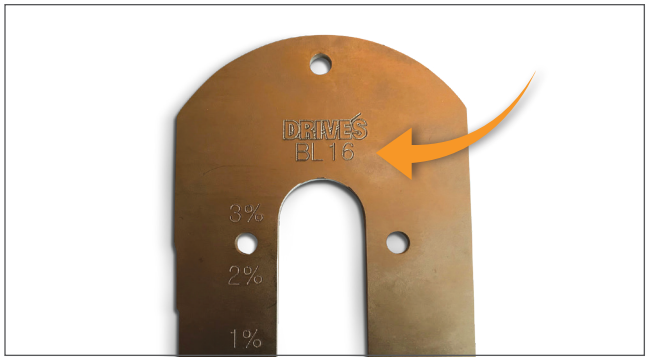
EZ CHAIN WEAR GAUGE®

Check the life of your leaf chain



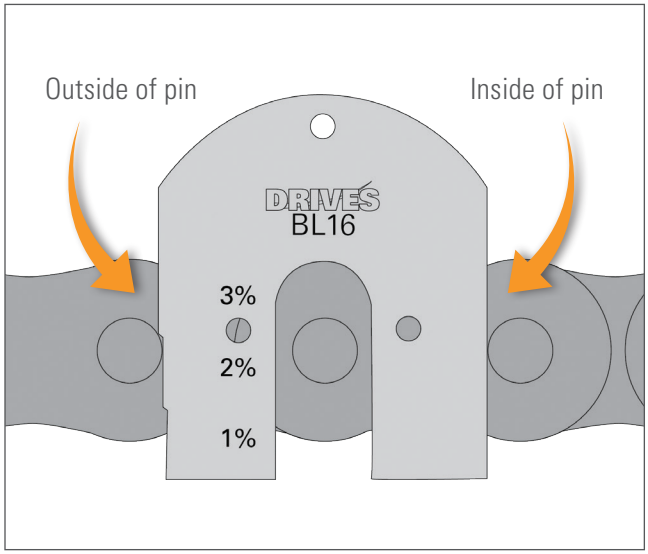
STEP 1

Determine the leaf chain pitch size.



STEP 2

Ensure the gauge is the corresponding size.



STEP 3

Measure the leaf chain from inside of the pin to outside of the pin, with the gauge flush on the link plate.

- If installed on the machinery, measure on the tension side.
- Chain not on the machine requires a specific minimum measuring load.

STEP 4

Do not force the gauge. Measurements should be taken at multiple points near the sheaves of the machine. If the gauge step fits through the checkpoint at 3% elongation, the chain is worn and should be replaced.

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