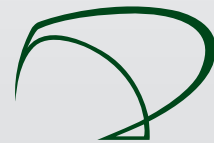


CAN-AM®

**CAN-AM**

# Mill and Drag Chain

**SUPPLY SERVICES LTD**

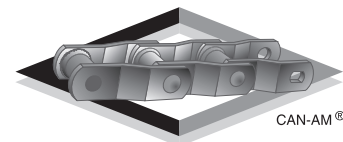
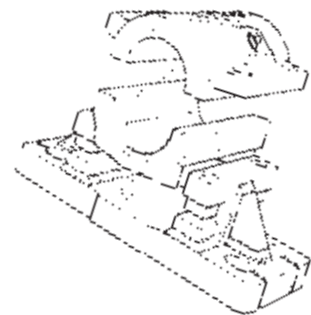
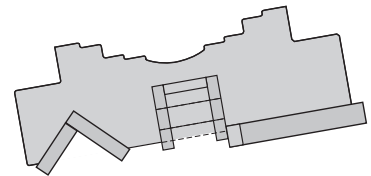
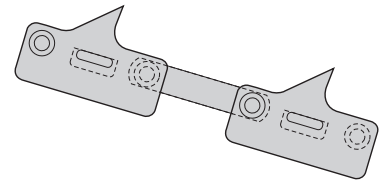


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**CAN-AM** Products

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CAN-AM®

## CHAIN DESIGNATION

Due to increasing demand from our customers and our commitment to serving the industry, we have broadened our selection base and to achieve this effectively, we have adopted the following National Standard Chain Designation:

- WR – Welded steel chain c/w heat treated rivets
- WH – Welded steel chain – fully heat treated
- WHIBR – Fully heat treated plus further Induction Hardened Barrels & Rivets
- WHIBRS – Same as IBR **plus** sidebar wear surfaces
- WD – Welded steel drag chain
- XHD – Extra heavy duty
- CS – Cast steel barrel

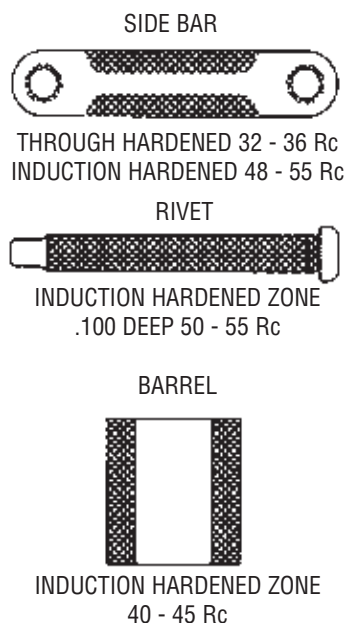
### NOTE:

Unless otherwise specified (quoted) welded steel chains are always supplied in 10 ft. lengths.

## THROUGH HEAT TREATING & INDUCTION HARDENING

(IBR) denotes fully heat treated & induction hardened barrels & rivets.

(IBRS) denotes fully heat treated & induction hardened barrels, rivets & side bars.



Used individually or combined the two types of heat treating CAN-AM chain can dramatically increase chain life.

### Impact & Strength

Through heat treated chain (to the proper hardness) will improve impact and ultimate strength.

### Wear

In a non-abrasive environment **heat treated chain** will give up to 50% greater wear life. Reduction of elongation of side bar holes can be assisted by induction hardening the hole perimeter.

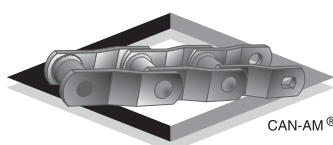
In a non-abrasive environment, **induction hardened chain** will give several times greater wear life.

**Note:** Individual situations may vary wear life.

Induction hardening depth and Rc range will vary to suit thickness of material, diameter of rivets and particular applications.

## HEAT TREATED AND INDUCTION HARDENED CHAIN

CAN-AM welded steel chains are available from stock with fully heat treated parts and/or induction hardened parts. For maximum chain life in severe applications including heavy impact loading, high speed requirements, capacity loads, or abrasive conditions, some or all of your CAN-AM chain will benefit from specific heat treatment.



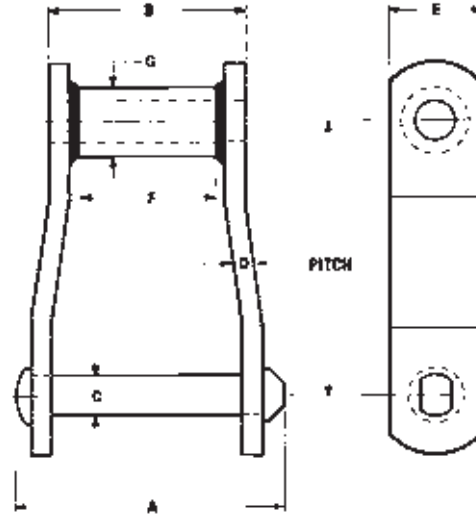
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## OFFSET SIDEBAR WELDED STEEL CHAIN

### CAN-AM WELDED STEEL CHAINS

provide an economical and superior method for conveying most materials. They are most common in the lumber, pulp and paper, plywood, OSB and other board mills, bucket elevator and bulk material handling.

*For higher impact strength and greater wear resistance, use fully heat treated or induction hardened chain.*



Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	Average Weight per Foot in lbs.	Approx. Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Approx. Tooth Face at Pitch Line	Outside Barrel Dia.
						A	B	C	D	E	F	G
WR-78	2.609	27,000	4,500	4.6	4.3	3	2	1/2	1/4	1 1/4	1	.840
WH-78	2.609	33,000	5,500	4.6	4.3	3	2	1/2	1/4	1 1/4	1	.840
WR-78-4	4.000	27,000	4,500	3	3.5	3	2	1/2	1/4	1 1/4	1	.840
WR-82	3.075	30,000	5,000	3.9	4.7	3 3/8	2 1/4	9/16	1/4	1 1/4	1 1/8	1
WH-82	3.075	36,000	6,000	3.9	4.7	3 3/8	2 1/4	9/16	1/4	1 1/4	1 1/8	1
WR-124	4.000	50,400	8,200	3	7.8	4 1/4	2 3/4	3/4	3/8	1 1/2	1 1/2	1 1/4
WH-124	4.000	57,000	9,500	3	7.8	4 1/4	2 3/4	3/4	3/8	1 1/2	1 1/2	1 1/4
WR-111	4.760	50,400	9,500	2.5	8.6	4 13/16	3 3/8	3/4	3/8	1 3/4	1 3/4	1 1/4
WH-111	4.760	60,000	12,000	2.5	8.6	4 13/16	3 3/8	3/4	3/8	1 3/4	1 3/4	1 1/4
WR-106	6.000	50,400	8,200	2	6.2	4 1/4	2 3/4	3/4	3/8	1 1/2	1 1/2	1 1/4
WH-106	6.000	60,000	12,000	2	6.2	4 1/4	2 3/4	3/4	3/8	1 1/2	1 1/2	1 1/4
WR-132	6.050	85,500	14,100	2	14.1	6 3/8	4 13/32	1	1/2	2	2 3/4	1 3/4
WH-132	6.050	122,000	20,300	2	14.1	6 3/8	4 13/32	1	1/2	2	2 3/4	1 3/4
WR-150	6.050	120,000	19,000	2	16.3	6 1/2	4 13/32	1	1/2	2 1/2	2 3/4	1 3/4
WH-150	6.050	122,000	20,300	2	16.3	6 1/2	4 13/32	1	1/2	2 1/2	2 3/4	1 3/4
WR-155	6.050	148,000	22,000	2	19.0	6 13/32	4 7/16	1 1/8	9/16	2 1/2	2 3/4	1 3/4
WH-155	6.050	175,000	29,000	2	19.0	6 13/32	4 7/16	1 1/8	9/16	2 1/2	2 3/4	1 3/4
WR-157	6.050	148,000	22,000	2	20.0	6 3/4	4 5/8	1 1/8	5/8	2 1/2	2 3/4	1 3/4
WH-157	6.050	175,000	29,000	2	20.0	6 3/4	4 5/8	1 1/8	5/8	2 1/2	2 3/4	1 3/4
WR-159	6.125	185,000	28,000	2	26.0	6 3/4	4 5/8	1 1/4	5/8	3	2 3/4	1.9
WH-159	6.125	210,000	32,000	2	26.0	6 3/4	4 5/8	1 1/4	5/8	3	2 3/4	1.9
WR-200	6.125	185,000	28,000	2	22.1	6 3/4	4 5/8	1 1/4	5/8	2 1/2	2 3/4	1.9
WH-200	6.125	190,000	32,000	2	22.1	6 3/4	4 5/8	1 1/4	5/8	2 1/2	2 3/4	1.9

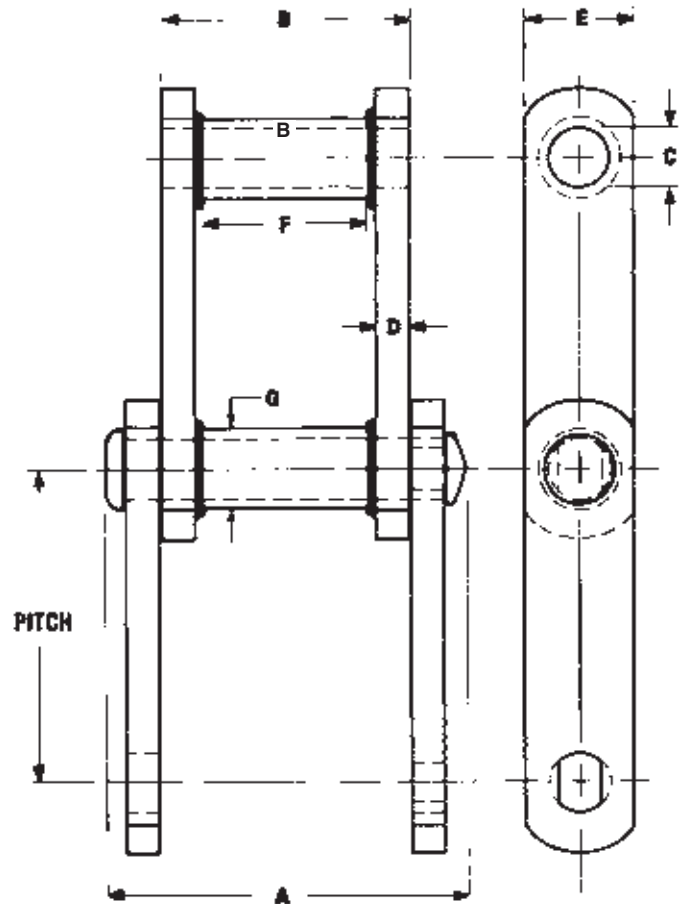
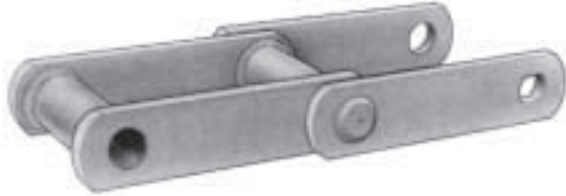
All of the above CAN-AM chains are standard with heat treated rivets. For WH144 and WH166, please refer to OSB Chains, page 25.

**Note:** For extra heavy duty chains see page 4.

## STRAIGHT SIDEBAR WELDED STEEL CHAIN

### CAN-AM WELDED STEEL C CLASS CHAINS

provide easy access for welding attachments to CAN-AM Steel chain, especially for field welding.



A

Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	Average Weight per Foot in lbs.	Approx. Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Approx. Tooth Face at Pitch Line	Outside Barrel Dia.
						A	B	C	D	E	F	G
WRC-78	2.609	27,000	4,500	4.6	4.3	3	2	1/2	1/4	1 1/4	1	.840
WRC-131*	3.075	50,400	8,400	3.9	6.8	3 9/16	2.0	3/4	3/8	1 1/2	1	1 1/4
WRC-124	4.000	50,400	8,400	3	7.8	4 1/4	2 3/4	3/4	3/8	1 1/2	1 1/2	1 1/4
WRC-111	4.760	50,400	8,400	2.5	8.6	4 13/16	3 3/8	3/4	3/8	1 3/4	1 3/4	1 1/4
WRC-110	6.000	50,400	8,400	2	7.2	4 1/4	2 3/4	3/4	3/8	1 1/2	1 1/2	1 1/4
WRC-132	6.050	85,500	14,100	2	14.1	6 1/2	4 13/32	1	1/2	2	2 3/4	1 3/4
WRC-150	6.050	120,000	19,000	2	16.3	6 1/2	4 13/32	1	1/2	2 1/2	2 3/4	1 3/4

\*Fits in 4" channel

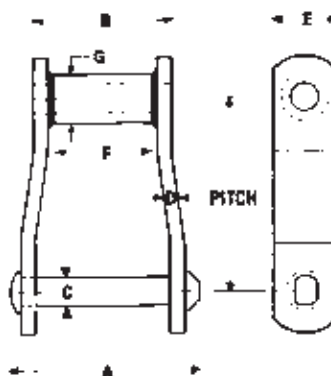
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## EXTRA HEAVY-DUTY WELDED STEEL CHAIN

### CAN-AM EXTRA HEAVY DUTY WELDED STEEL CHAINS

provide higher ultimate strength, superior impact resistance and longer life than standard chains. The CAN-AM Tough Guy features include: greater impact capabilities, higher ultimate strength and larger wearing surface.

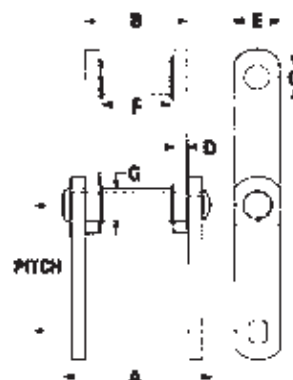
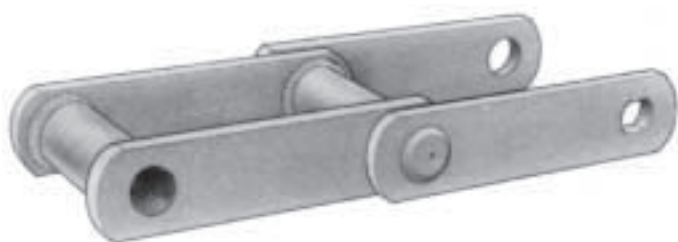
### H TYPE EXTRA HEAVY DUTY CHAIN



Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	Average Weight per Foot in lbs.	Approx. Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Approx. Tooth Face at Pitch Line	Outside Barrel Dia.
						A	B	C	D	E	F	G
WR-78XHD*	2.636	30,000	5,000	4.6	6.3	3 3/8	2	9/16	3/8	1 1/4	1	1
WH-78XHD*	2.636	36,000	6,000	4.6	6.3	3 3/8	2	9/16	3/8	1 1/4	1	1
WR-82XHD	3.075	50,400	8,400	3.9	8.5	3 3/4	2 3/8	3/4	3/8	1 1/2	1 1/8	1 1/4
WH-82XHD	3.075	57,000	9,500	3.9	8.5	3 3/4	2 3/8	3/4	3/8	1 1/2	1 1/8	1 1/4
WR-124XHD	4.063	85,000	14,200	3	14.6	4 7/8	3	1	1/2	2	1 1/2	1 5/8
WH-124XHD	4.063	122,000	20,400	3	14.6	4 7/8	3	1	1/2	2	1 1/2	1 5/8
WR-106XHD	6.050	85,000	14,200	2	11.8	4 7/8	3	1	1/2	2	1 1/2	1 3/4
WH-106XHD	6.050	122,000	20,400	2	11.8	4 7/8	3	1	1/2	2	1 1/2	1 3/4
WR-132XHD	6.050	120,000	20,000	2	15.3	6 3/4	4 21/32	1	5/8	2	2 3/4	1 3/4
WH-132XHD	6.050	122,000	20,400	2	15.3	6 3/4	4 21/32	1	5/8	2	2 3/4	1 3/4

\*Fits in 4" channel

### C TYPE EXTRA HEAVY DUTY CHAIN



Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	Average Weight per Foot in lbs.	Approx. Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Approx. Tooth Face at Pitch Line	Outside Barrel Dia.
						A	B	C	D	E	F	G
WRC-82XHD	3.075	50,400	8,400	3.9	8.3	3 3/4	2 3/8	3/4	3/8	1 1/2	1 1/8	1 1/4
WRC-124XHD	4.063	85,000	14,200	3	14.6	4 7/8	3	1	1/2	2	1 1/2	1 5/8
WRC-110XHD	6.050	85,000	14,200	2	11.8	4 7/8	3	1	1/2	2	1 1/2	1 3/4
WRC-132XHD	6.050	120,000	20,000	2	15.3	6 3/4	4 21/32	1	5/8	2	2 3/4	1 3/4

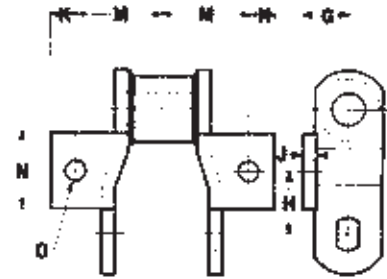
## MILL CHAIN ATTACHMENTS

The following pages detail some of the standard mill chain attachments that we manufacture. CAN-AM CHAINS has also manufactured thousands of special attachments in conjunction with our customers, to solve specific conveying problems. In many cases these design changes have resulted in a substantial increase in the chain's overall service life and in some cases as much as a three (3) times increase.

***We are problem solvers.***

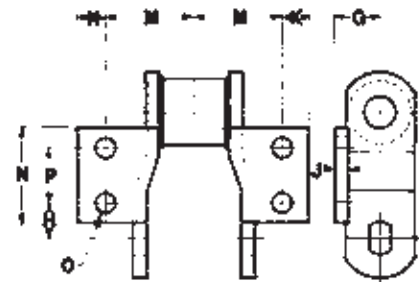
***Challenge us to perform for you!***

### K1 ATTACHMENTS AND A1 ATTACHMENTS (IF ONE SIDE)



Chain Number	G	H	J	K	M	N	Bolt Size O
WR-78	7/8	1 1/4	1/4	1/2	2	1 1/4	3/8
WR-78HD(X)	7/8	1 1/4	1/4	1/2	2	1 1/4	3/8
WR-82	7/8	1 1/2	1/4	5/8	2 3/8	1 3/4	3/8
WR-82XHD	1 1/8	1 1/2	3/8	5/8	2 3/8	1 3/4	3/8
WR-124	1 1/8	2	3/8	5/8	2 5/8	1 3/4	3/8
WR-124XHD	1 1/2	2	1/2	3/4	2 5/8	1 3/4	1/2
WR-111	1 1/4	2 1/8	3/8	5/8	3 1/8	1 3/4	3/8
WR-132	1 1/2	3	1/2	7/8	3 3/4	2	1/2
WR-132HD(X)	1 1/2	3	1/2	7/8	3 3/4	2	1/2

### K2 ATTACHMENTS AND A2 ATTACHMENTS (IF ONE SIDE)



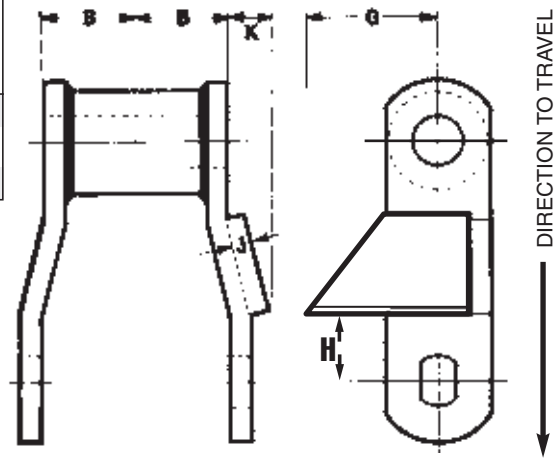
Chain Number	G	H	J	K	M	N	P	Bolt Size O
WR-78	7/8	13/16	1/4	1/2	2	2 1/8	1 1/8	3/8
WR-78HD(X)	7/8	13/16	1/4	1/2	2	2 1/8	1 1/8	3/8
WR-82	7/8	1/2	1/4	5/8	2 1/8	2 1/4	1 1/4	3/8
WR-82XHD	1 1/8	1/2	3/8	5/8	2 3/8	2 1/4	1 1/4	3/8
WR-124	1 1/8	7/8	3/8	5/8	2 5/8	3	1 15/16	3/8
WR-124XHD	1 1/2	7/8	1/2	3/4	2 5/8	4	1 15/16	1/2
WR-111	1 1/4	1	3/8	3/4	3 1/8	4	2 5/16	3/8
WR-132	1 1/2	1 5/8	1/2	3/4	3 3/4	4 1/4	2 3/4	1/2
WR-132HD(X)	1 1/2	1 5/8	1/2	7/8	3 3/4	4 1/4	2 3/4	1/2
WR-150	1 3/4	1 5/8	1/2	7/8	3 3/4	4 1/4	2 3/4	1/2

# MILL CHAIN ATTACHMENTS

## R2 ATTACHMENTS

Chain Number	B	G	H	J	K	Weight per foot in lbs.
WR-78	1	1 9/16	1	1/4	1/2	4.4
WR-78HD(X)	1 1/8	1 9/16	1	3/8	5/8	7.5
WR-82	1 1/8	1 3/4	13/16	1/4	1/2	6.0

**NOTE:** R-1 attachments are similar except travel is narrow end forward. (Point direction is reversed)

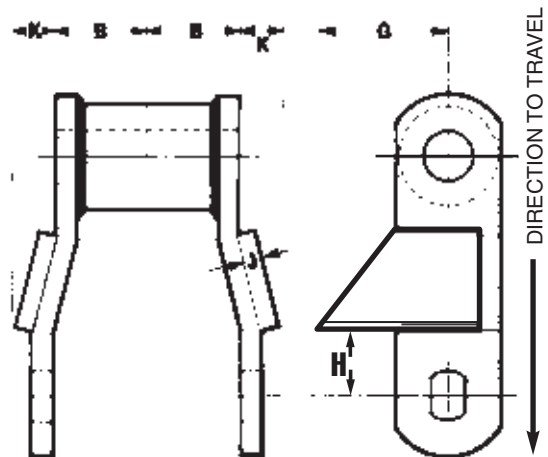


## RR-2 ATTACHMENTS

RR Attachments available on all chains

Chain Number	B	G	H	J	K	Weight per foot in lbs.
WR-78	1	1 9/16	1	1/4	1/2	4.8
WR-78HD(X)	1 1/8	1 9/16	1	3/8	5/8	8.0
WR-82	1 1/8	1 3/4	13/16	1/4	1/2	6.5
WR-82XHD	1 3/16	2 1/16	13/16	3/8	3/4	8.5
WR-124	1 3/8	1 7/8	1 1/2	3/8	3/4	9.3
WR-132	2 13/64	2 1/2	1 1/2	1/2	7/8	16.0

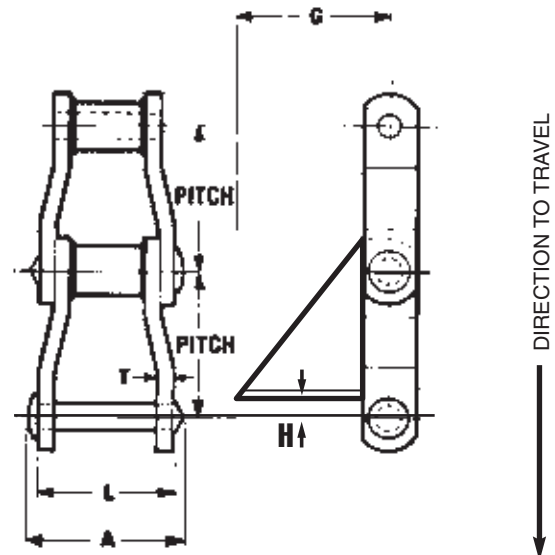
RR-1 Attachments are similar except travel is narrow end forward. (Point direction is reversed.)



## S1 ATTACHMENTS

- Weld on type supplied unless integral is specified (Quoted)
- WRC specifications as stated

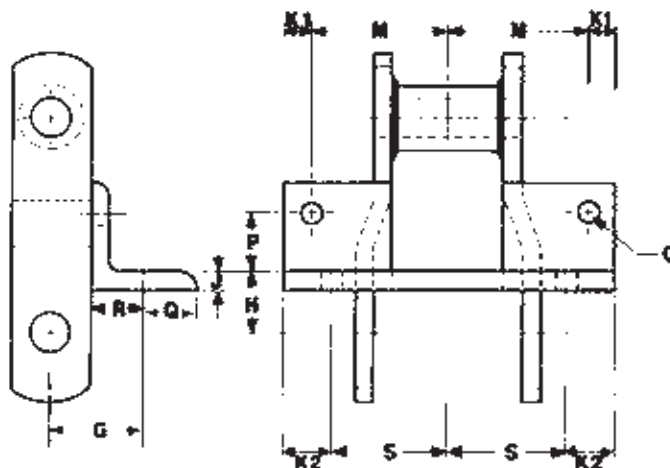
Chain Number	A	G	H	L	T	Weight per foot in lbs.
WR-124	4 1/4	3 3/4	1	3 5/8	3/8	17.4
WR-111	4 13/16	4	1	4 3/16	3/8	18.3
WR-106	4 1/4	3 3/4	1	3 5/8	3/8	16.1
WR-124XHD	4 7/8	3 3/4	1 9/32	4 1/8	1/2	26.0
WR-132	6 1/4	5	1 9/32	5 9/32	1/2	18.0
WR-150	6 1/4	5 1/2	1 9/32	5 9/32	1/2	20.0





# MILL CHAIN ATTACHMENTS

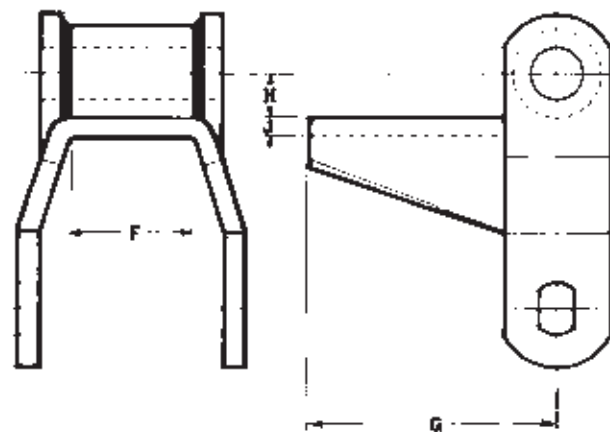
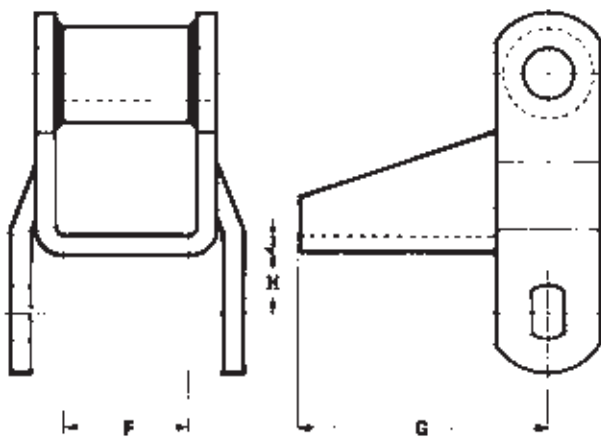
## F4 ATTACHMENTS



Chain Number	G	H	J	K1	K2	M	P	Q	R	S	Weight per foot in lbs.	Bolt Size O
WR-78	1 3/4	1	1/4	1/2	7/8	2 1/4	15/16	5/8	1 1/8	1 7/8	8.3	3/8
WR-78XHD	1 3/4	1	1/4	1/2	7/8	2 1/4	15/16	5/8	1 1/8	1 7/8	9.9	3/8
WR-82	1 13/16	1 1/4	1/4	7/16	7/8	2 1/2	1 1/8	13/16	1 3/16	2 1/16	8.9	3/8
WR-82XHD	2 1/16	1 1/4	3/8	1/2	1 1/16	2 1/2	1 1/8	1 1/16	1 3/16	2 1/16	12.5	3/8
WR-124	2 1/16	1 5/32	3/8	1/2	1 1/16	2 5/8	1 1/16	1 1/16	1 5/16	2 1/16	11.6	3/8

## H1 ATTACHMENTS

## H2 ATTACHMENTS



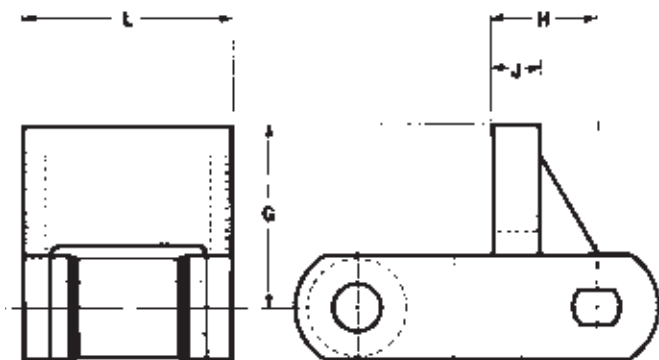
Chain Number	F	G	H	J	Weight per foot in lbs.
WR-78	1 1/2	3 5/8	1/2	3/16	6.6
WR-78XHD	1 1/2	3 5/8	1/2	3/16	9.5
WR-82	1 3/4	3 5/8	5/8	3/16	8.9
WR-82XHD	1 3/4	3 7/8	5/8	3/16	12.1

Chain Number	F	G	H	J	Weight per foot in lbs.
WR-78	1 1/2	3 5/8	1/2	3/16	6.6
WR-78XHD	1 1/2	3 5/8	1/2	3/16	9.5
WR-82	1 3/4	3 5/8	5/8	3/16	8.9
WR-82XHD	1 3/4	3 7/8	5/8	3/16	12.1

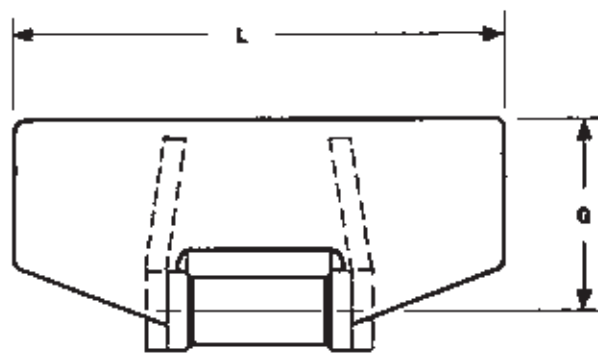
**Note:** H1 Also fits 8IX

## MILL CHAIN ATTACHMENTS

### RF2



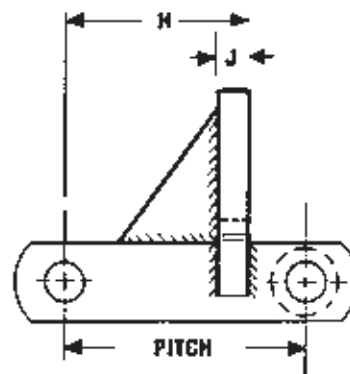
### RF 12



Chain Number	G	H	J	K	Weight per foot in lbs.
WR-78	2 11/16	1 1/2	1/4	3	7.7
WR-78HD(X)	2 11/16	1 1/2	3/8	3	10.7
WR-82XHD	2 3/4	2 9/64	3/8	3 1/4	12.3
WR-124	3 1/4	2	1/2	4 1/4	15.8
WR-111	3 1/4	2 1/8	1/2	7 3/4	14.5
WR-132	3 1/2	3	3/4	9	28.5

Specifications for C Style Chain same as above  
Specify L and G Dimension when ordering.

Also available for wide end forward operation.



In many cases design changes have resulted in a substantial increase in the chains overall service life and in some cases as much as a three (3) fold increase.

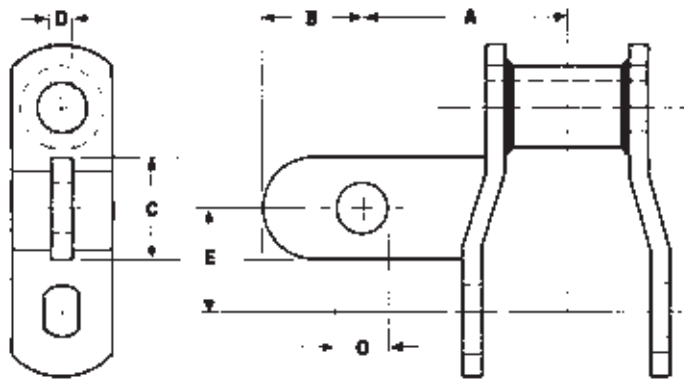
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# MILL CHAIN ATTACHMENTS

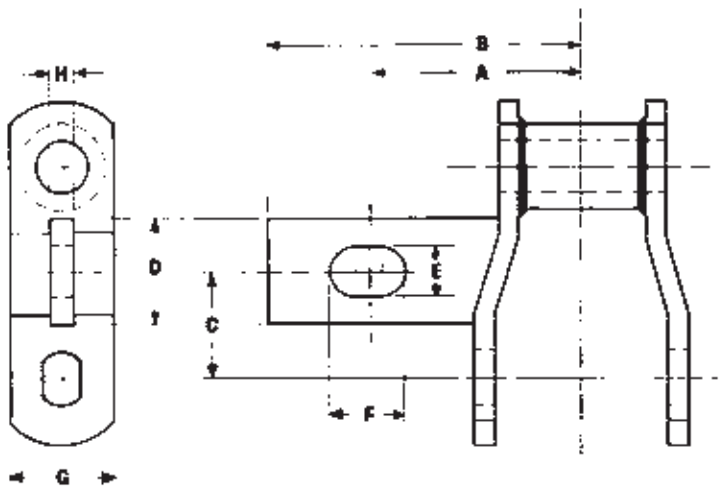
## A22



Chain Number	A	B	C	D	E	O
WR-78	2	5/8	1 1/4	1/4	1 1/4	7/16
WR-124	3	7/8	1 3/4	3/8	2	9/16
WR-111	3 1/2	7/8	1 3/4	3/8	2 3/8	9/16
WR-106	2 3/4	7/8	1 3/4	3/8	3	9/16
WR-132	4 1/4	1	1 3/4	1/2	3	13/16
WR-132XHD	4 1/4	1	2	5/8	3	13/16

Specify left or right hand when ordering.

## SPECIAL SLOTTED A22 FOR WAFERIZER CHAINS



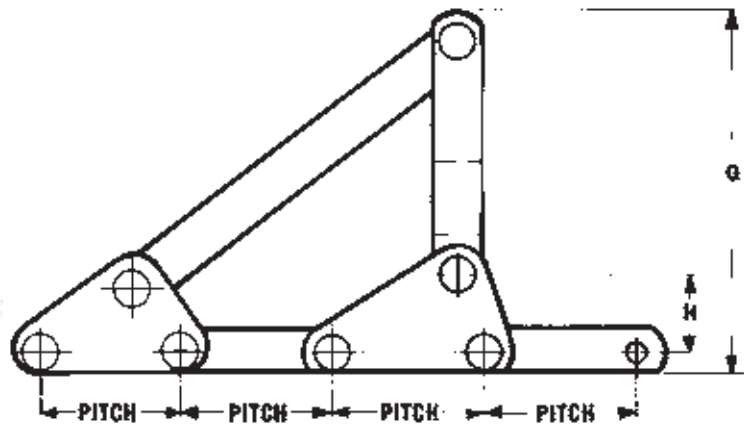
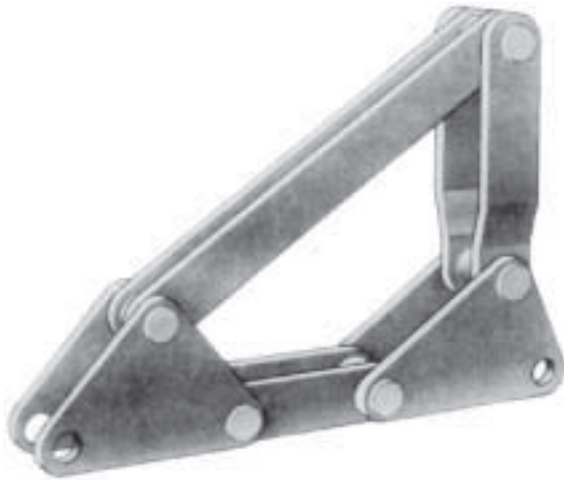
Chain Number	A	B	C	D	E	F	G	H
WR-124	4	5 15/16	1 3/4	2	13/16	1 1/2	1 1/2	1/2
WR-124XHD	4 1/8	6 1/16	1 3/4	2	13/16	1 1/2	2	1/2
WR-106	4	5 15/16	3	2	13/16	1 1/2	1 1/2	1/2
WR-106XHD	4 1/8	6 1/16	3	2	13/16	1 1/2	2	1/2
WR-132	4 1/2	6 1/4	3	2	13/16	1 1/2	2	1/2
WR-132XHD	4 5/8	6 3/8	3	2 1/2	13/16	1 1/4	2	1/2
WR-144	4	5 15/16	3	2	13/16	1 1/2	1 3/4	1/2
WR-166	4	5 15/16	3	2	13/16	1 1/2	1 3/4	1/2

All items to the left are also available in "H" Series, fully heat treated, and/or plus "IBR" induction hardened options.

## MILL CHAIN ATTACHMENTS

### CAN-AM SIDE-LIFT LOG CHAIRS

NOTE: Chairs ordered separately will have end link supplied loose



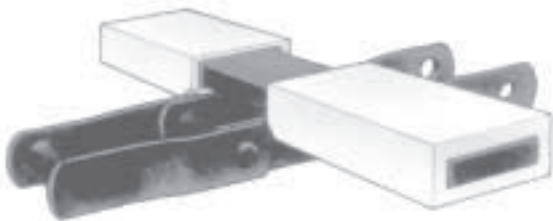
Chain Number	Average Pitch in Inches	Rivet Dia.	Overall Width	Height in Inches	H	Pitches per Assembly
			A	G		
WR-78	2.609	1/2	3	8-14	1 7/8	4-5
WR-82	3.075	9/16	3 1/4	10-14	1 7/8	5-6
WR-124	4.000	3/4	4 1/4	10-18	2 7/8	4-6
WR-124XHD	4.063	1	4 7/8	12-18	3	4-6
WR-106	6.000	3/4	4 1/4	12-20	3 3/4	4-6
WR-132	6.050	1	6 1/4	12-24	3 3/4	4-5
WR-132HD(X)	6.050	1	6 3/4	12-24	3 3/4	4-5
WR-150	6.050	1	6 1/4	12-24	4	4-5
WR-155	6.050	1 1/8	6 13/32	12-30	4	4-5
WR-157	6.050	1 1/8	6 3/4	12-30	4	4-5



## CAN-AM UHMW FLIGHTS

Sleeves constructed of UHMW and press fitted over steel tube or flat bar. CAN-AM UHMW flights act as the wear strip in the bottom of the conveyor.

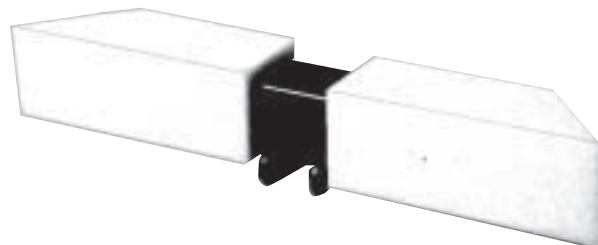
Easily replaced sleeves save flat bar and chain wear and greatly reduce maintenance costs. Other features include reduced power consumption and noise reduction.



### Flat Bar Style

FB = 3 1/2" x 1"

UHMW = 4 1/2" x 2" outside



### HSS Square Tube Style

Tube = 3" x 3"

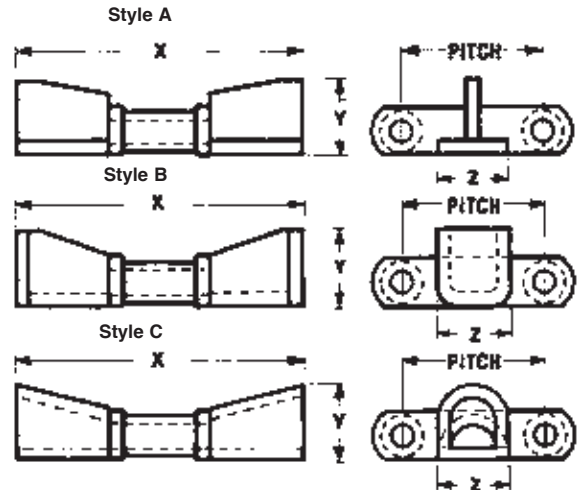
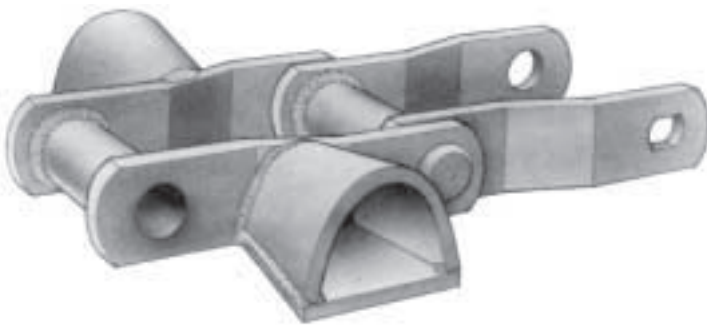
UHMW = 4" x 4" outside

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# MILL CHAIN ATTACHMENTS

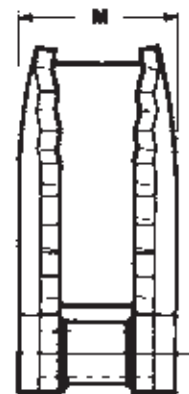
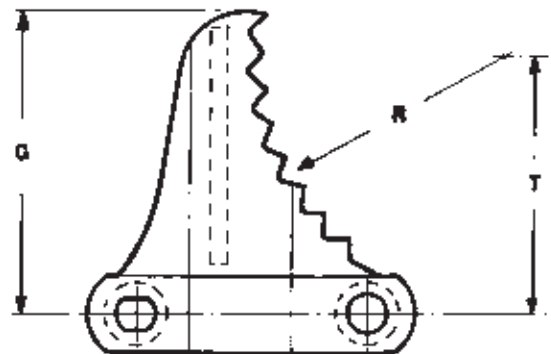
## LOG CRADLE FOR SINGLE STRAND CHAIN



Chain Number	Pitch	Style A			Style B			Style C			Special Style C		
		X	Y	Z	X	Y	Z	X	Y	Z	X	Y	Z
WR-124	4.000	8	2 1/2	2 1/2	8	2 1/2	2 1/4	8	2 1/4	3 1/2	11	2 15/16	3
WR-111	4.760	8 1/2	2 1/4	1 3/4	8 1/2	3	2 1/4	8 1/2	2 1/4	3 1/2	11	2 15/16	3
WR-124XHD	4.050	8 1/2	3	2 1/2	8 1/2	3	2 1/2	8 1/2	3	3	11	3 3/4	3
WR-106	6.000	8	2 1/4	3	8	2 1/4	2 1/4	8	2 1/4	3 1/2	11 5/8	2 15/16	3 1/2
WR-132	6.050	11	3	3	11	3	3 1/4	11	3	3 1/2	13	3 1/2	3 1/2
WR-132XHD	6.050	11 1/4	3	3	11 1/4	3	3	11 5/8	3	3 1/2	13 5/8	3 1/4	3 1/2

Note: Style "A" cradles could pose conveying problems – discuss with factory.

## SPECIAL SLASHER ATTACHMENTS\*

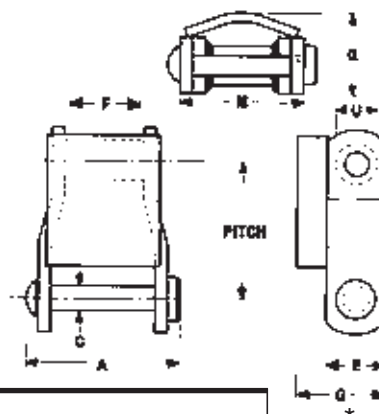


Chain Number	G	R	T	M
WR-124	7 5/16	12	7	4
WR-124XHD	7 5/16	12	7	4 1/4
WR-106	8 1/4	6	6 3/4	3 7/8
WRC-110	8 1/4	6	6 3/4	3 7/8
WR-106XHD	9	6 3/8	7	4 5/64
WR-132	7 5/16	6	7	5 1/2
WRC-132	7 5/16	6	7	5 1/2

\* Available integral to sidebar or welded on.

# MILL CHAIN ATTACHMENTS

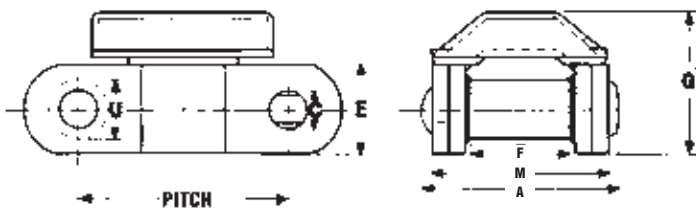
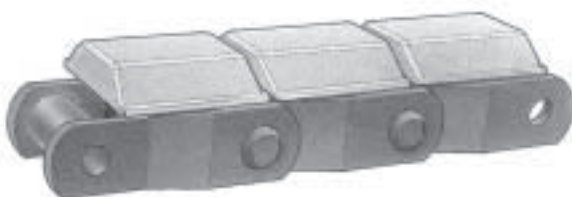
## CAN-AM WELDED STEEL UNIVERSAL TOP



Chain Number	Chain Pitch	Links per Foot	Weight per Foot in lbs	Dimensions in Inches						
				A	C	E	F	G*	M	U
WR-78 U	2.609	4.6	6.0	3	1/2	1 1/4	1	1 13/16	2 5/8	7/8
WR-78 XHDU	2.636	4.6	10.4	3.45	9/16	1 1/4	1	1.90	2 13/16	1
WR-82 U	3.075	3.9	8	3 1/2	9/16	1 1/4	1 1/8	2	3	1
WR-82 XHDU	3.075	3.9	13 1/2	4	3/4	1 1/2	1 1/8	2 3/8	3 5/16	1 1/4
WR-130/8U	4.000	3	4.8	3	1/2	1 1/4	1	1 13/16	2 5/8	7/8
WR-124 U	4.000	3	13.0	4 1/4	3/4	1 1/2	1 1/2	2 1/2	3 5/8	1 1/4
WR-124 XHDU	4.063	3	19.8	4 5/8	1	2	1 1/2	3 1/4	4 1/16	1 5/8

\* Nominal Dimension

## CAN-AM WELDED STEEL CHAIN WITH U.H.M.W. CAP

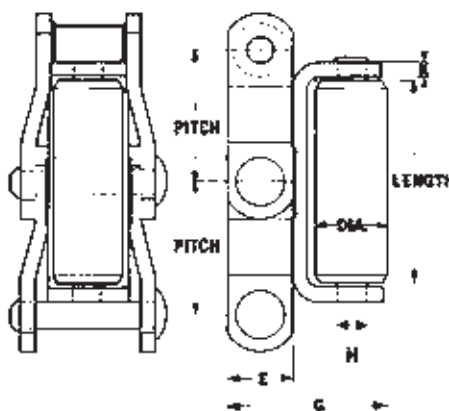
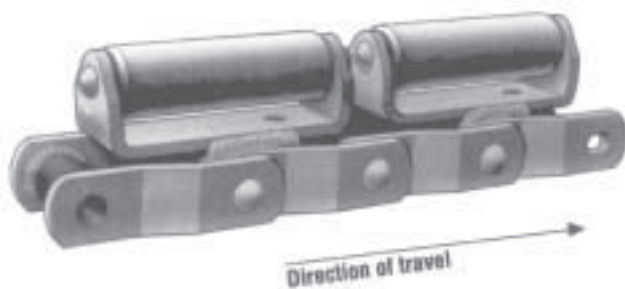


Chain Number	Chain Pitch	Links per Foot	Weight per Foot in lbs	Dimensions in Inches						
				A	C	E	F	G*	M	U
WR-78 UP	2.609	4.6	5.4	3	1/2	1 1/4	1	1 15/16	2 5/8	7/8
81X UP	2.609	4.6	3.4	2 1/2	7/16	1 1/8	7/8	1 7/8	1 5/8	7/8

\* Nominal Dimension

# MILL CHAIN ATTACHMENTS

## STEEL ROLL TOP CHAIN WITH NYLON ROLLERS



Chain Number	Chain Pitch	Links per Foot	Weight per Foot in lbs.	Roller Length	Roller Dia.	Side Bar Width	Overall Height	Cradle Material	Roller Rivet Dia.
						E	G	K	H
WR-78RTN	2.609	4.6	7.85	4	1 1/4	1 1/4	3 1/8	1/4	1/2

Standard rolltop chain supplied with solid nylon roller. WRC 78 (combination chain) styles also available.

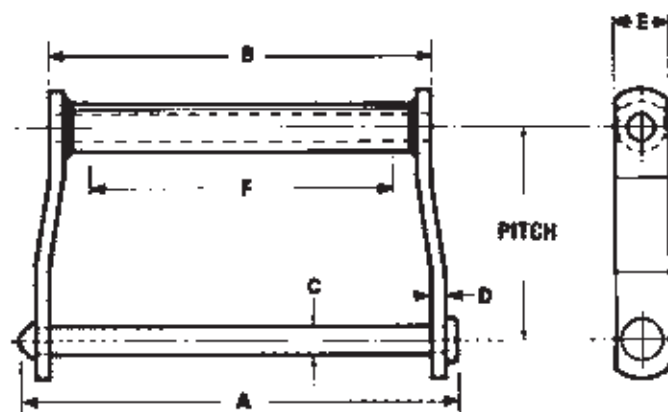
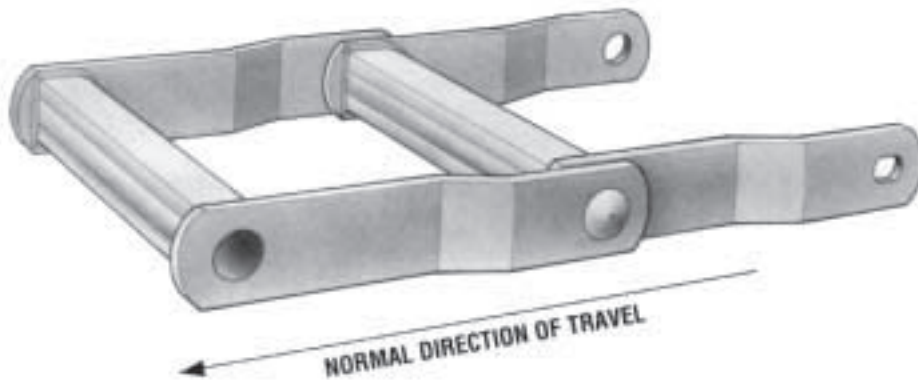
## DRAG CHAIN

### CAN-AM WELDED STEEL DRAG CHAINS

provide efficient and economical service when used in chip and sawdust conveyors, and like applications. Features include original formed barrel design for complete rivet to barrel contact for maximum rivet wear, higher impact

strength, weldability of attachments and option of heat treating and/or induction hardening specific parts.

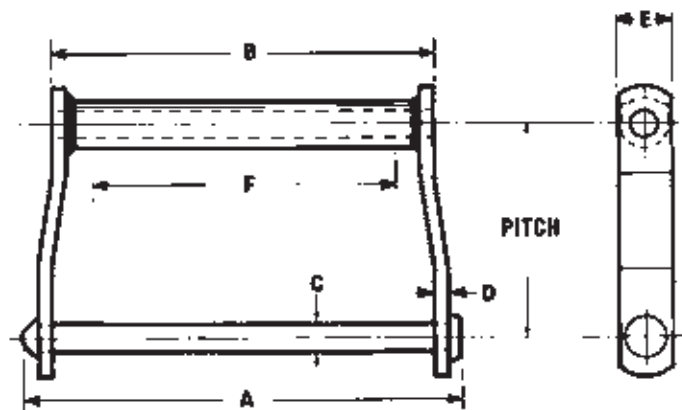
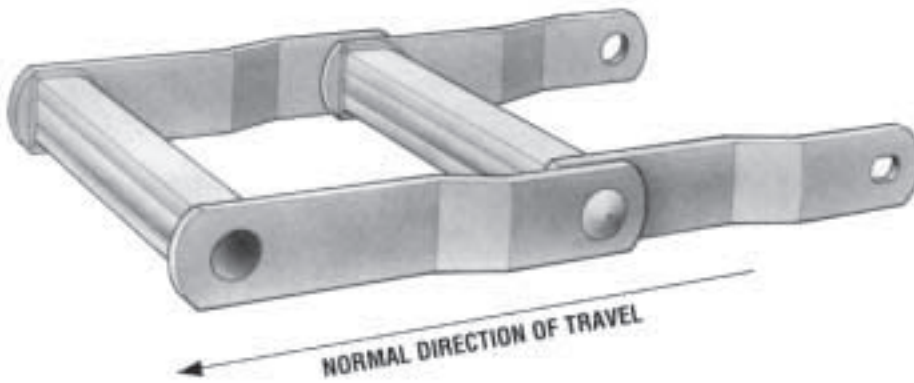
**Reverse barrel chain is available. Contact Factory.**



Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	Weight per Foot in lbs.	Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Maximum Sprocket Face
						A	B	C	D	E	F
WD-102	5.000	51,000	10,200	2.4	12.0	9 1/4	7 3/4	3/4	3/8	1 1/2	6 3/8
WD-104	6.000	51,000	10,200	2	8.1	6 3/4	5 3/8	3/4	3/8	1 1/2	4 1/8
WD-110	6.000	51,000	10,200	2	12.0	11 3/4	10 1/4	3/4	3/8	1 1/2	9
WD-112	8.000	51,000	10,200	1.5	9.5	11 3/4	10 1/4	3/4	3/8	1 1/2	9
WD-116	8.000	51,000	10,200	1.5	13.8	15 1/2	14 1/8	3/4	3/8	1 3/4	13
WD-118	8.000	70,000	14,000	1.5	18.7	16 5/8	14 7/8	7/8*	1/2	2	13 1/4
WD-120	6.000	70,000	14,000	2	18.4	12	10 1/4	7/8*	1/2	2	8 3/4
WD-122	8.000	70,000	14,000	1.5	15.3	12	10 1/4	7/8*	1/2	2	8 3/4
WD-480	8.000	70,000	14,000	1.5	17.1	14 1/2	12 3/4	7/8*	1/2	2	11

\*Also available in 1" Ø pin

## CAN-AM (XHD) HEAVY DUTY DRAG CHAINS



Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	Weight per Foot lbs.	Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Maximum Sprocket Face
						A	B	C	D	E	F
WD-120XHD	6.000	122,000	24,400	2	22.5	12 3/4	10.5	1	5/8	2	8 3/4
WD-118XHD	8.000	122,000	24,400	1.5	22.5	17 3/8	15 1/8	1	5/8	2	11
WD-122XHD	8.000	122,000	24,400	1.5	19.5	12 3/4	10.5	1	5/8	2	8 3/4
WD-480XHD	8.000	122,000	24,400	1.5	21	15 1/4	13	1	5/8	2	11

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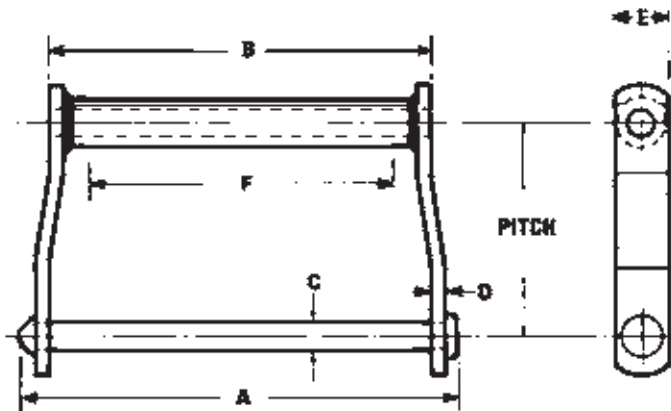
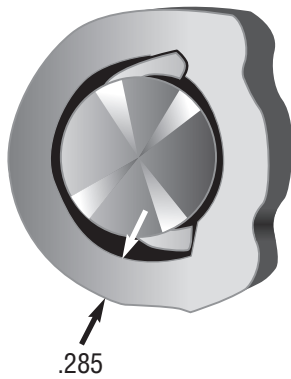


# SUPER HOG CHAINS

## CAN-AM "SUPER HOG" DRAG CHAIN

features a formed, heavy wall seamless tube barrel. This rugged barrel supports a through and induction hardened 1" steel rivet. The "Super Hog" design eliminates crushed/peeled barrels and reduces wear due to racking. When the going gets tough...use CAN-AM "Super Hog" in log hauls, chip conveyors & heavy duty hog fuel handling application.

**STANDARD  
"SUPER HOG" CHAINS  
FEATURE FULLY THROUGH  
HARDENED THEN INDUCTION HARDENED  
RIVETS AVAILABLE WITH HEAT-TREATED  
SIDEBARS (WDRS) OR HEAT-TREATED  
SIDEBAR AND  
BARRELS (WDH).**



**HEAVY BARRELS RESIST CRUSHING • CAN BE RUN FASTER • LONGER LIFE • LESS DOWNTIME  
• SNUG FITTING RIVETS MINIMIZE RACKING • WILL MOVE HEAVIER LOADS**

"SUPER HOG" (SH)

PRODUCT SPECIFICATIONS

Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	S.H.* Links per Foot	Weight per Foot	Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Maximum
					A	B	C	D	E	F	
WDRS118-SH	8.000	85,500	17,100	1.5	22	16 5/8	14 7/8	1	1/2	2	13 1/4
WDRS118-XHDSH	8.000	122,000	24,400	1.5	24.5	17 3/8	14 7/8	1	5/8	2	13 1/4
WDRS120-SH	6.000	85,500	17,100	2	22	12	10 1/4	1	1/2	2	8 3/4
WDRS120-XHDSH	6.000	122,000	24,400	2	24	12 3/4	10 1/4	1	5/8	2	8 3/4
WDRS122-SH	8.000	85,500	17,100	1.5	17.5	12	10 1/4	1	1/2	2	8 3/4
WDRS122-XHDSH	8.000	122,000	24,400	1.5	20	12 3/4	10 1/4	1	5/8	2	8 3/4
WDRS480-SH	8.000	85,500	17,100	1.5	21.5	14 1/2	12 3/4	1	1/2	2	11
WDRS480-XHDSH	8.000	122,000	24,400	1.5	23	15 1/4	13	1	5/8	2	11

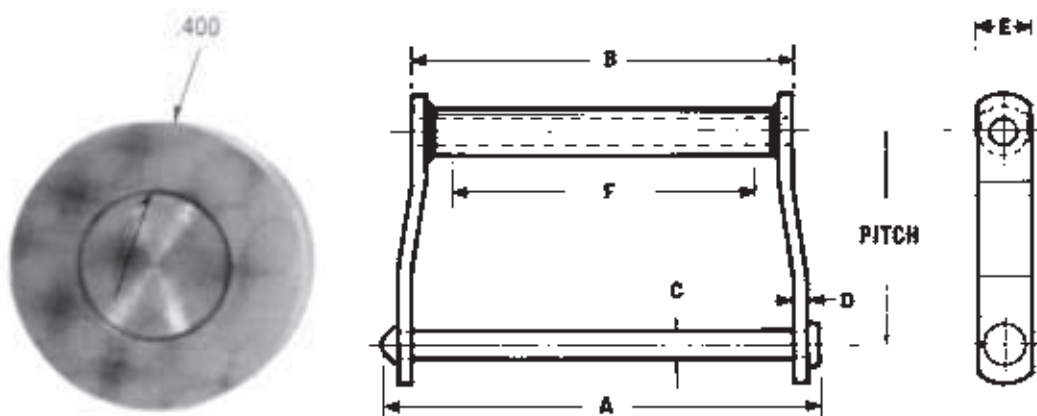
\*SH = Super Hog

# WORK HOG CHAINS

## CAN-AM "WHOLE HOG" DRAG CHAIN

has the same rugged characteristics as the "Super Hog". The main difference...the barrel is extra heavy, round, but packed with the same oversize, greased rivet. This chain is for "Big" logs and two way operations. Use "Whole Hog" for applications so brutal that only a real "tough" chain will do the job. CAN-AM chain...built to take it!

**STANDARD  
"WHOLE HOG" CHAINS FEATURE  
FULLY THROUGH HARDENED THEN INDUCTION  
HARDENED RIVETS AND THROUGH  
HARDENED SIDE BARS.**



**SUPPLY SERVICES LTD**   
Phone 0800 102 112 - [www.supplyservices.co.nz](http://www.supplyservices.co.nz)

**HEAVY BARRELS RESIST CRUSHING • CAN BE RUN FASTER • LONGER LIFE • LESS DOWNTIME**  
**• SNUG FITTING RIVETS MINIMIZE RACKING • WILL MOVE HEAVIER LOADS**

**"WHOLE HOG" (WH)**

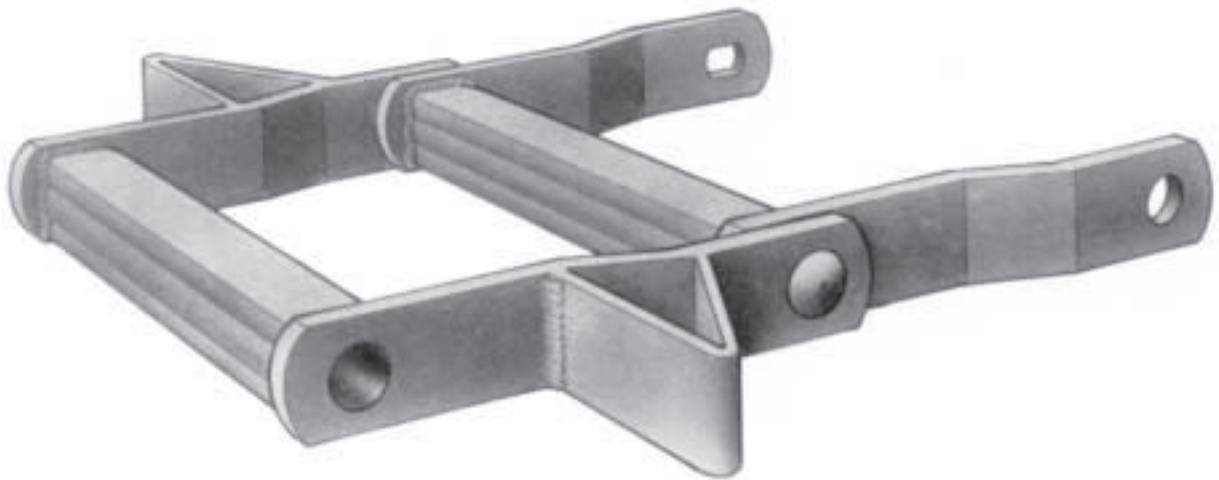
**PRODUCT SPECIFICATIONS**

Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Allowable Working Load lbs.	Links per Foot	W.H.* Weight per Foot	Overall Width	Length of Bearing	Rivet Dia.	Side Bar Thickness	Side Bar Height	Maximum
						A	B	C	D	E	F
WDRS118-WH	8.000	85,500	17,100	1.5	25.5	16 5/8	14 7/8	1	1/2	2	13 1/4
WDRS118-XHDWH	8.000	122,000	24,400	1.5	28	17 3/8	14 7/8	1	5/8	2	13 1/4
WDRS120-WH	6.000	85,500	17,100	2	24	12	10 1/4	1	1/2	2	8 3/4
WDRS120-XHDWH	6.000	122,000	24,400	2	27	12 3/4	10 1/4	1	5/8	2	8 3/4
WDRS122-WH	8.000	85,500	17,100	1.5	20	12	10 1/4	1	1/2	2	8 3/4
WDRS122-XHDWH	8.000	122,000	24,400	1.5	22	12 3/4	10 1/4	1	5/8	2	8 3/4
WDRS480-WH	8.000	85,500	17,100	1.5	22.5	14 1/2	12 3/4	1	1/2	2	11
WDRS480-XHDWH	8.000	122,000	24,400	1.5	25	15 1/4	13	1	5/8	2	11

"WH" = Whole Hog

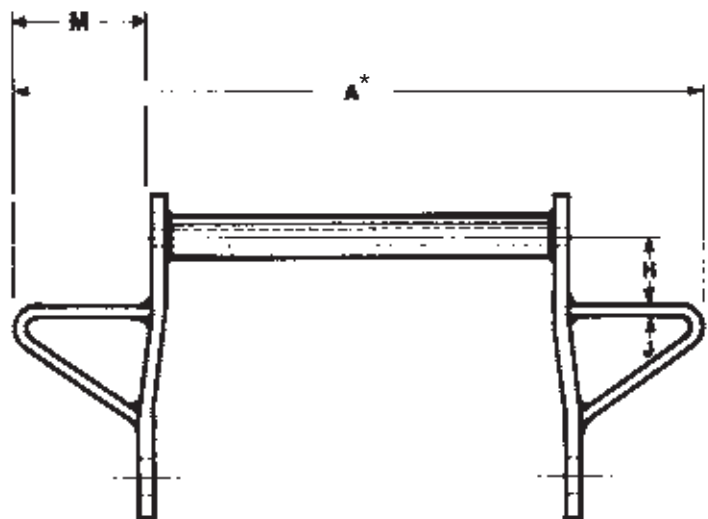
Tabular dimensions and weights are approximate and non-binding. Design improvements may result in variations to published figures. Verification is recommended. © 1994 CAN-AM Chains, all rights reserved.

## DRAG CHAIN ATTACHMENTS WING ATTACHMENTS



### STANDARD WINGS OPTIONS AVAILABLE

Chain Number	A*	H	J	M
WD 102	14 1/2	1 1/2	3/8	3 1/4
WD 104	12	2 1/4	3/8	3 3/8
WD 110	17	2 1/4	3/8	3 3/8
WD 112	17	2 1/4	3/8	3 3/8
WD 113	17	2 1/4	3/8	3 3/8
WD 116	22	2 1/2	3/8	3 15/16
WD 118	22	2 1/2	1/2	3 9/16
WD 120	17	2 1/2	1/2	3 3/8
WD 122	17	2 1/2	1/2	3 3/8
WD 480	22	2 1/2	1/2	4 5/8
WD 120XHD	17 1/4	2 1/2	1/2	3 1/4
WD 118XHD	22 1/4	2 1/2	1/2	3 7/16
WD 480XHD	22 1/4	2 1/2	1/2	4 1/2

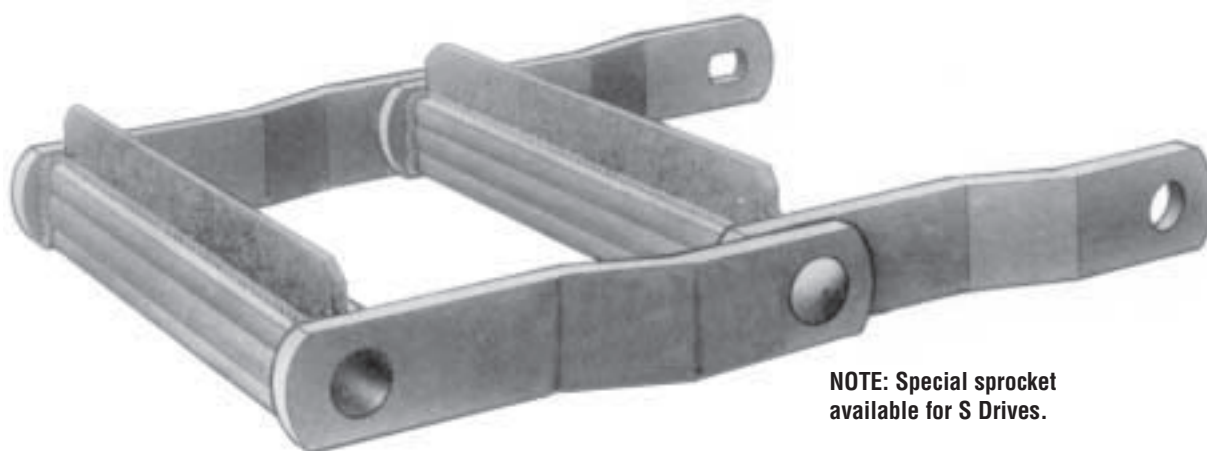


\* Please specify measurement

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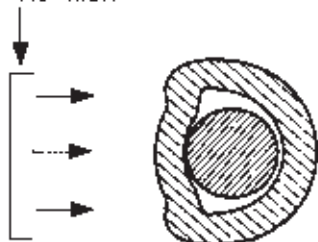
# DRAG CHAIN ATTACHMENTS

## ATTACHMENTS C-1/2", C-1, C-3, C-4

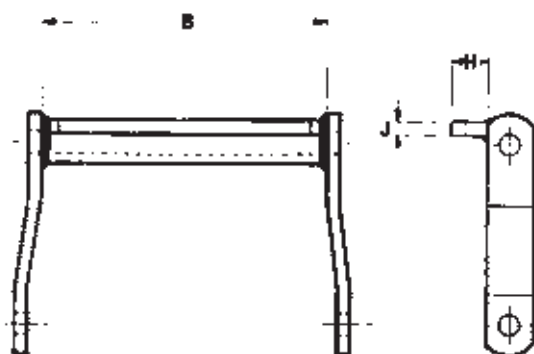


**NOTE:** Special sprocket available for S Drives.

C-1/2 ATTACHMENT



End view of drag chain barrel.  
C-1/2 is welded to barrel face.



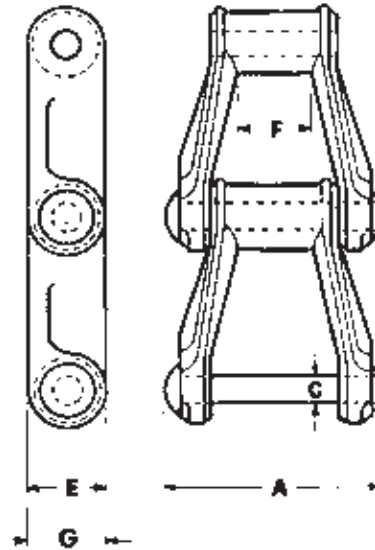
\* See note below

Chain Number	C-1/2*			C-1			C-3			C-4		
	B	J	H	B	J	H	B	J	H	B	J	H
WD 102	6 3/4	3/8	1 1/2	6 3/4	3/8	1 1/2	6 3/4	3/8	1 3/4	6 3/4	3/8	3
WD 104	4 1/2	3/8	1 1/2	4 1/2	3/8	1 1/2	4 1/2	3/8	1 3/4	4 1/2	3/8	3
WD 110	9 1/4	3/8	1 1/2	9 1/4	3/8	1 1/2	9 1/4	3/8	1 3/4	9 1/4	3/8	3
WD 112	9 1/4	3/8	1 1/2	9 1/4	3/8	1 1/2	9 1/4	3/8	1 3/4	9 1/4	3/8	3
WD 113	9	1/2	1 1/2	9	1/2	1 3/4	9	1/2	1 3/4	9	1/2	4
WD 116	13	3/8	1 3/4	13	3/8	1 3/4	13	3/8	1 3/4	13	3/8	4
WD 118	13 1/2	1/2	2	13 1/2	1/2	1 3/4	13 1/2	1/2	2	13 1/2	1/2	4
WD 120	9	1/2	2	9	1/2	1 3/4	9	1/2	2	9	1/2	4
WD 122	9	1/2	2	9	1/2	1 3/4	9	1/2	2	9	1/2	4
WD 480	11 1/2	1/2	2	11 1/2	1/2	1 3/4	11 1/2	1/2	2	11 1/2	1/2	4

\*Note: C-1/2 attachments are welded on front of barrel, whereas C-1, C-3, C-4 attachments are welded on top of barrel.  
C-1/2 attachments do not extend above sidebar height.

## MALLEABLE CHAIN

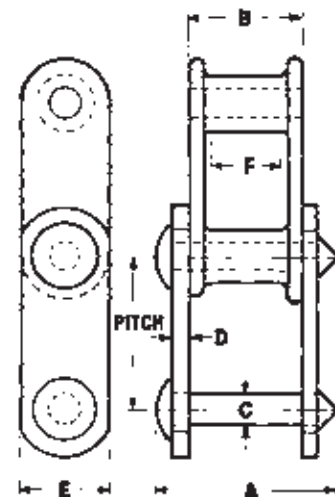
Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Links per Foot	Weight per Foot lbs.	Overall Width	Rivet Dia.	Side Bar Height	Maximum Sprocket Face
					A	C	E	F
H-78	2.609	20,200	4.6	4.2	3 3/8	1/2	1 1/8	1
H-82	3.075	22,000	3.9	5.5	4 1/16	9/16	1 1/4	1 1/8



## STEEL AND MALLEABLE COMBINATION CHAIN

Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Links per Foot	Weight per Foot lbs.	Overall Width	Length of Bearing	Rivet Dia.	Side bar Thickness	Side Bar Height	Maximum Sprocket Face	Barrel Dia.
					A	B	C	D	E	F	G
C 55*	1.630	9,000	7.4	2.0	1.813	1 7/32	3/8	7/32	23/32	3/4	.72
C 77*	2.308	11,000	5.2	2.3	2 3/32	1 1/4	7/16	3/16	7/8	11/16	.72
C 188	2.609	14,000	4.6	3.5	2 5/8	1 9/16	1/2	1/4	1 1/8	7/8	7/8
C 131	3.075	24,000	3.9	6.7	3 5/8	2	5/8	3/8	1 1/2	1 1/8	1 7/32
C 102B	4.000	24,000	3.0	6.4	4 9/16	2 25/32	5/8	3/8	1 1/2	1 1/2	1.0

Combination chains consist of heat treated pearlitic malleable iron centre links with carbon steel side bars.  
 \*Available in riveted or pin & cotter construction.  
 SS pins & cotters also available from stock.



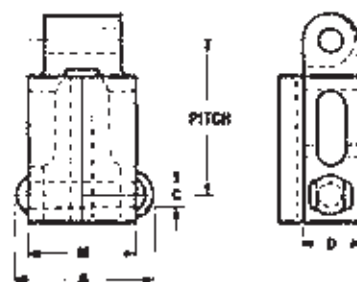
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# MALLEABLE CHAIN

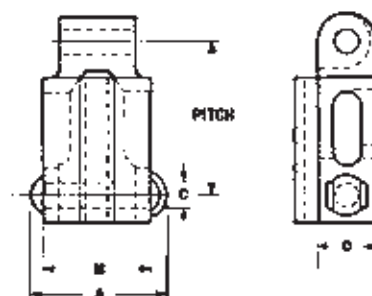
## MALLEABLE TRANSFER CHAIN

Rooftop and Camelback are widely used in the lumber industry on transfer decks, where the load is carried transversely on two or more strands of chain and entry or discharge is endways. Maximum advisable speed is 100 feet per minute.

### ROOF TOP H-78A, H-130



### CAMELBACK H-78B, H-138



## COMBINATION

### ROOF TOP C-55A

### CAMELBACK C-55B

### UNITOP C-55D



NOTE: Snap-on urethane caps available for non-marking applications.

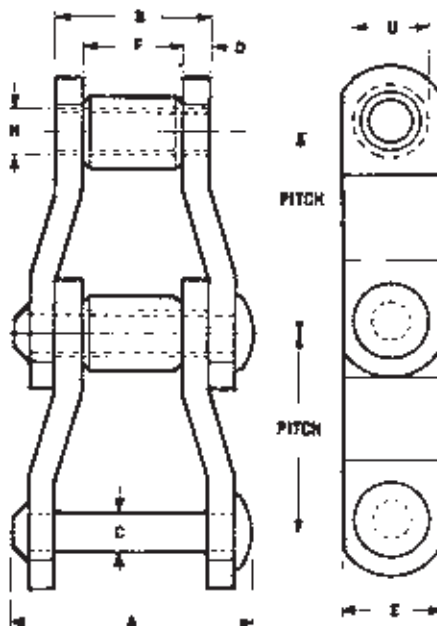
Chain Number	Average Pitch in Inches	Ultimate Strength lbs.	Links per Foot	Weight per Foot lbs.	Overall Width	Roof Width	Rivet Dia.	Side bar Height	Overall Height
					A	M	C	D	H
H-78A	2.609	16,000	4.6	5.6	3 1/4	2 3/4	1/2	1 11/16	1 11/16
H-78B	2.609	16,000	4.6	6.1	3 1/4	2 3/4	1/2	1 11/16	1 11/16
H-130	4.000	14,000	3.0	5.2	3 1/4	2 13/16	1/2	1 7/64	1 11/16
H-138	4.000	15,000	3.0	5.8	3 1/4	2 13/16	1/2	1 7/64	1 11/16
C55A, C55B, C55D	1.630	9,000	7.4	3.2	2	1.2	3/8	3/4	1 1/4

# POWER TRANSMISSION AND TRIMMER CHAIN

## POWER TRANSMISSION CHAINS

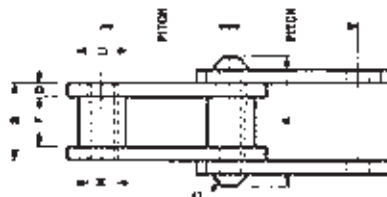
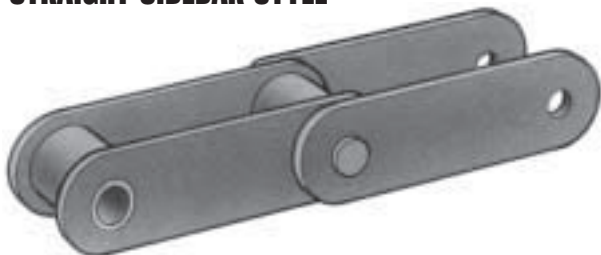
are widely used throughout the lumber industry in a broad range of conveying, transmission, and elevating applications. They are available in either offset or straight sidebar design. The majority of bushed roller chains are best suited for slow or moderate speed drive and conveyor applications since they are made to commercial standards for clearance, fits, and limits. Broaches on one end of the rivet and flats on both ends of the bushing prevent these parts from rotating in the sidebar holes. These chains are widely used throughout the industry with our cast steel bullnose or other special attachments for use on trim tables. (See pages 22 and 23.)

### OFFSET SIDEBAR STYLE



Chain Number	Chain Style	Avg. Pitch inches	Ultimate Strength lbs.	Allow. Working Load lbs.	Links per Foot	Weight per Ft. lbs.	Sidebars			Material	C	Pins		Bushing		Roller			L. of Brng B
							D	E	Material			A	Material	H	Material	U	F	Material	
SO-578	0	2.609	19,000	2,200	4.6	2.7	5/32	1	CH	3/8	2 5/64	CH	9/16	CC	7/8	1 1/16	CC	1 7/16	
MO-88	0	2.609	20,000	2,400	4.6	3.8	1/4	1 1/8	C	7/16	2 11/32	CH	5/8	CC	7/8	1 1/16	CC	1 5/8	
LXS-882	0	2.609	29,000	2,800	4.6	3.9	1/4	1 1/8	CH	7/16	2 11/32	AH	5/8	AC	7/8	1 1/8	CH	1 11/16	
MOH-578	0	2.609	19,000	2,200	4.6	2.7	7/32	1	CH	3/8	2 5/64	CH	9/16	CC	7/8	1 1/16	CH	1 27/64	

### STRAIGHT SIDEBAR STYLE



Chain Number	Chain Style	Avg. Pitch inches	Ultimate Strength lbs.	Allow. Working Load lbs.	Links per Foot	Weight per Ft. lbs.	Sidebars (D)			Mat.	C	Pins		Bushing		Roller			Length of Bearing B
							Block	Conn	Height			Mat.	A	Mat.	H	Mat.	U	F	
MS-88	S	2.609	26,000	2,500	4.6	3.8	1/4	1/4	1 1/8	C	7/16	2 11/32	CH	5/8	CC	7/8	1 1/16	CC	1 5/8
81-X	S	2.609	22,000	2,200	4.6	2.6	5/32	5/32	1 1/8	CH	7/16	1 55/64	AC	5/8	AC	29/32	1 1/16	CH	1 3/8
81-XH	S	2.609	41,800	5,000	4.6	3.9	5/16	7/32	1 1/4	CH	7/16	2.330	AC	5/8	AC	29/32	1 1/16	CH	1 11/16
81-XHS	S	2.609	41,800	5,000	4.6	4.2	5/16	5/16	1 19/64	CH	7/16	2.50	AC	5/8	AC	29/32	1 1/16	CH	1 11/16
SS-188	0	2.609	26,000	2,500	4.6	3.8	1/4	1/4	1 1/8	CH	7/16	2 11/32	AC			7/8	1 1/16	CC	1 5/8

See page 29 for "J" Bar sorter chains.  
Zero = no roller.

**Letter designation of material**

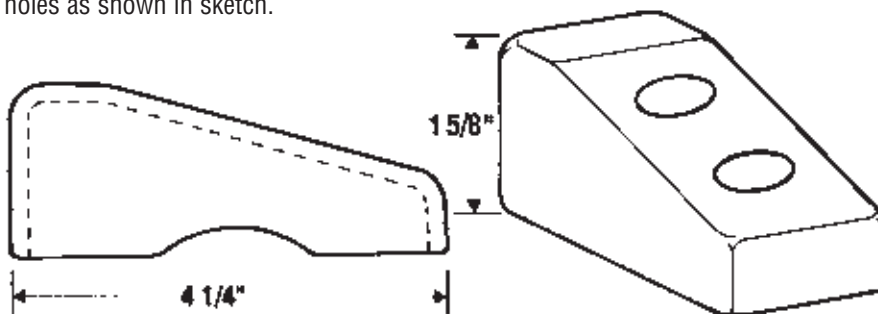
C: carbon steel  
CC: carbon steel case hardened  
AC: alloy steel case hardened

CH: carbon steel heat treated  
AH: alloy steel heat treated

# TRIMMER CHAIN ATTACHMENTS

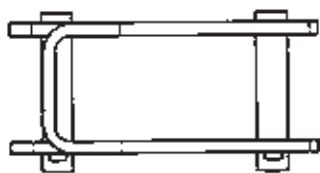
## CAST STEEL TRIMMER LUGS

- Suitable for the following chains: SO-578, 81X, 81-XH, MS-88, MO-88, LXS-882
- Lugs available with self cleaning holes as shown in sketch.



## 81-X PUSHER LUGS

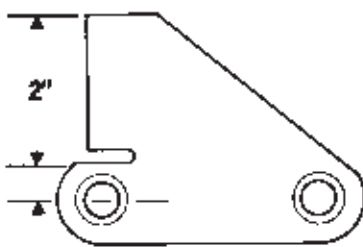
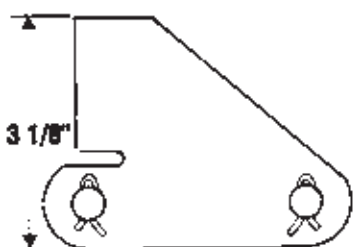
- Strong integral pusher lug for many sawmill applications.
- Available from stock as a connecting link or roller link.



Connecting Link



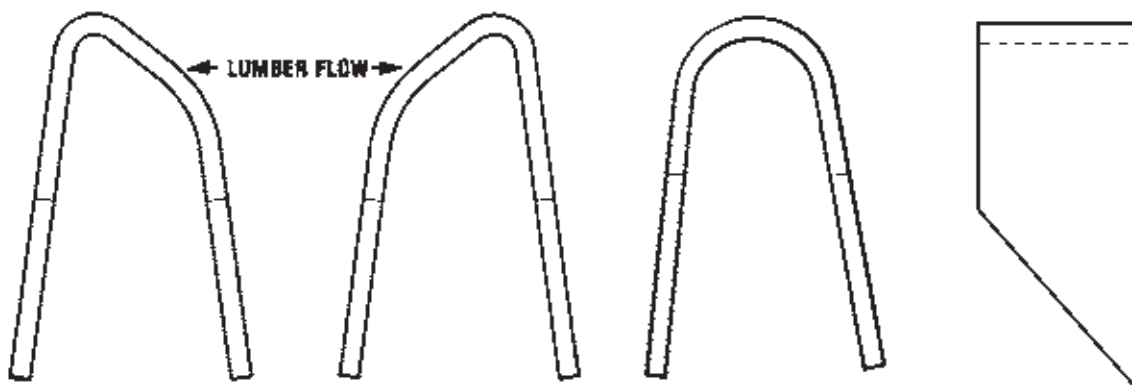
Roller Link



9/16"

## CAN-AM FABRICATED STEEL BULLNOSE ATTACHMENTS

Standard heights of 1 1/2" - 1 3/4" - 2" are available from stock.  
 Manufactured for welded steel chain and trimmer chain.



Right Hand Angle

Left Hand Angle

Straight

Side View

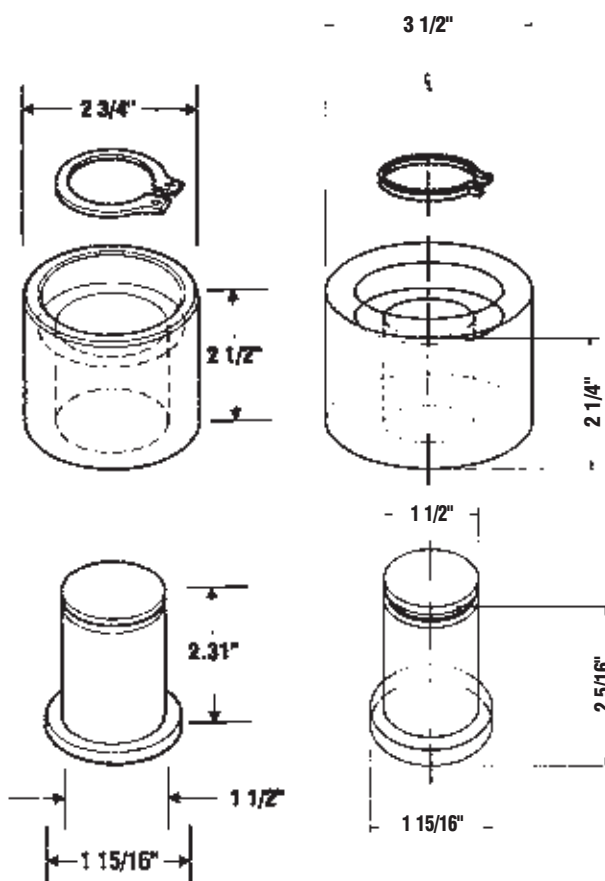


# TRIMMER CHAIN ATTACHMENTS

## TRIMMER CHAIN LUGS

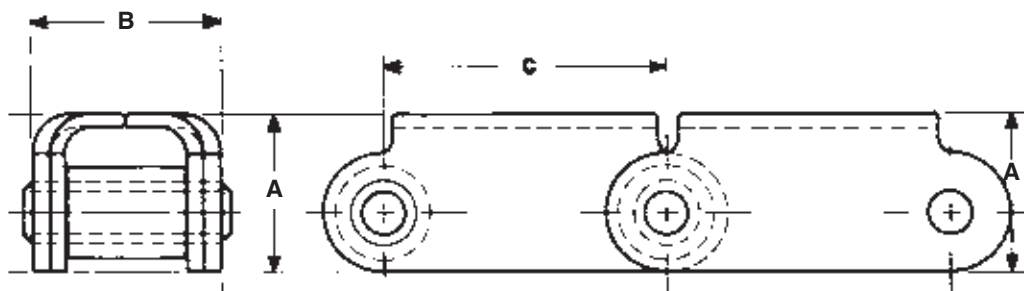
Roller Style

- Suitable for all trimmer chains SO-578, 81X, 81-XH, MS88-MO88, LXS882, MOH578.
- For maximum chain life LXS882 recommended.
- **Height and Outside Diameter can be manufactured to your specific requirements.**



Standard size is 2 1/2" high x 2 3/4" O.D.

## 81-X ROOFTOP



Chain Number	A	B	C
81-X Rooftop	1 1/2	1 13/16	2.609

## MILL CHAIN RIVETS

- All CAN-AM Mill Chain Rivets are through heat treated as standard.
- All Super Hog and Whole Hog Chain Rivets 1" diameter and larger are supplied through and induction hardened as standard
- All Trimmer Chain Rivets are supplied Heat Treated as standard
- Other Induction Hardening & Heat Treating options are available on request, as are zinc plating and galvanizing.


**STYLE 1**

**STYLE 2**

**STYLE 3**

	Chain Number	Rivet Style	Rivet Size Dia. x Length Under Head	Approx. Weight per 100 Rivets
Trimmer Chain	SO-578	3	3/8 x 1 15/16"	10
	MS-88	3	7/16 x 2 1/4"	16
	81-X, 3939	3	7/16 x 1 59/64"	12
	MO-88	3	7/16 x 2 1/4"	16
	LXS-882	3	7/16 x 2 3/8"	15
Malleable Chain	C102-B	3	5/8 x 4	50
	C-131	1	5/8 x 3 1/4"	48
	C-188	3	1/2 x 2 1/2"	16
	H-78, H-130, H-138	2	1/2 x 3 1/16"	18
	H-82	2	9/16 x 3 5/8"	28
Mill Chain	WR-78, 78-4, 130, 138, 78 Rolltop	1	1/2 x 2 13/16"	17
	WR-78 (5") XHD	1	9/16 x 3 1/2"	26
	WR-78 XHD	1	9/16 x 3 3/32"	26
	WR-82	1	9/16 x 3 1/8"	26
	WR-82XHD/WR-720S	1	3/4 x 3 9/16"	52
	WR-124, WR-106	1	3/4 x 4"	58
	WR-111	1	3/4 x 4 5/8"	64
	WR-144	1	1 x 4 1/8"	97
	WR-124XHD/WR-106XHD	1	1 x 4 5/8"	101
	WR-150, WR-WRC-132	1	1 x 6"	138
	WR-WRC-132XHD	1	1 x 6 1/2"	155
	WR-WRC-157, WR-155	1	1 1/8 x 6 9/16"	188
	WHX-157XHD, WR-159	3	1 1/4 x 6.54"	200
	WRC-131	1	3/4 x 3 1/4"	52
	Drag Chain	WD-102	1	3/4 x 8 7/8"
WD-104		1	3/4 x 6 11/16"	88.4
WD-110, WD-112		1	3/4 x 11 17/32"	150
WD-116		1	3/4 x 15 13/32"	198
WD-113		1	7/8 x 11 15/16"	210
WD-118		1	7/8 x 16 9/16"	290
WD-118-1		1	1" x 16.57"	372
WD-118XHD		1	1" x 17"	380
WD-120, WD-122		1	7/8 x 11 15/16"	210
WD-120XHD		1	1" x 12 15/16"	278
WD-480		1	7/8 x 14 7/16"	258
WD-480XHD		1	1 x 14 15/16"	344
WD-480-1	1	7/8 x 14 3/16"	334	

# TECHNICAL SECTION

## AVAILABLE OPTIONS TO CAN-AM CHAINS

Most CAN-AM products can be ordered with mechanical properties to suit specific or unique applications. Some of the variables are listed below.

1. Non heat treated sidebars or barrels.
2. Through heat treated sidebars, barrels or rivets.
3. Induction hardening of already through hardened sidebars, barrels and rivets
4. Carborized barrels
5. Normalized sidebars and barrels to improve notch toughness for cold weather applications
6. Zinc plated, hard chrome plated, stainless and other rivets in optional steels e.g. 1541, 8620, 4140, 4340
7. Shot peened rivets
8. Prelubricated chain, (molyslip or other)
9. Construction by means of standard riveting, welded rivets, or pins

Note: All standard mill class chains are supplied with heat treated rivets.

## WELDING PROCEDURE FOR CAN-AM STEEL CHAIN

Preheat chain and attachments to 200° – 350° F before welding. Preheat temperature is affected by many variables, some are thickness of material, geometry of attachment, and chemical composition of the steel.

1. Use a dry 7018 electrode, or #116 flux core, or wire feed with argon/CO<sub>2</sub> shield.
2. Always observe proper welding techniques.

Note: CAN-AM Chains is not responsible for chain, or attachment failure, or welding defects, when ex-factory welding is the cause of the failure or defect, and that welding has been performed by other than our own factory certified welders.

## LUBRICATION

Normal chain wear is often the result of friction between the rivet and I.D. of the barrel. Sprocket size and pitch angle will determine the relative motion between parts, and the degree of wear.

Lubrication of these surfaces would lessen wear and slow the progress of corrosion.

Since lubrication significantly reduces the amount of wear to a chain, it would seem to be good economics to pre-lube chain at the point of manufacture and to lubricate that chain throughout its service life. Even a fine spray of water adds to service life.

## BREAK-IN PERIOD

Following a proper and logical “break-in” routine will enhance the service life of welded steel chain products.

## CAN-AM RECOMMENDS:

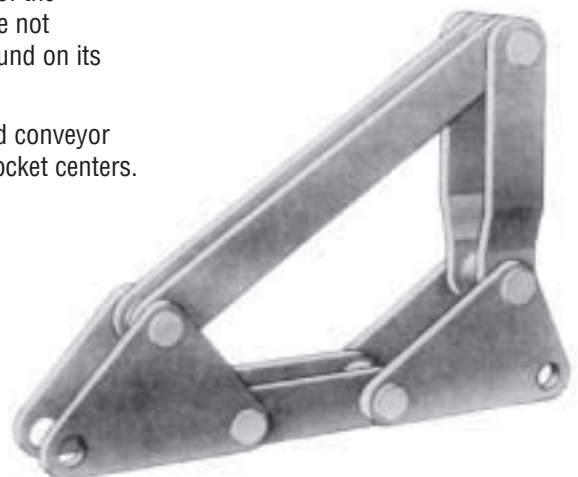
1. Chain should be run empty for a period of 6–8 hours, or whatever is practical. A fine spray of water or other lubricant would promote surfaces to polish up.
2. Make sure sprockets are correctly aligned and that wear strip is in good condition.
3. New chain should always be run on new sprockets. Even if the sprockets are only slightly out of pitch, or have even the smallest “hook” to the teeth, those sprockets will dramatically reduce chain life.
4. Check to ensure that chain will not “bind” or “hang up” along the conveyor path.

## SIDELIFT LOG HAUL CONVEYORS

The following recommendations will help in the maintenance of existing conveyors and the design and installation of new systems.

1. **Chair Height** – This dimension is controlled by the angle of incline in degrees of the conveyor. The most satisfactory incline is 30 degrees. Using that figure the chair height should be 1/3 the diameter of the largest log expected. In other words a 36" diameter log must have a 12" high chair minimum.
2. **Head End Design** – The sprocket centre must be far enough back from the end of the log haul conveyor to allow for a skid between the top of the sprocket and the end of the log haul conveyor trough. If this were not designed in this manner, the chair could bump it as it travels around on its way back down the sidelift conveyor.
3. **Chain Return** – A catenary return is best for the chain, chairs and conveyor structure, and the slack of the chain should be 5-10% of the sprocket centers.

## CAN-AM SIDELIFT LOG CHAIRS



## CONVEYOR INSTALLATION AND MAINTENANCE FOR THE FOREST PRODUCTS INDUSTRY

CAN-AM welded steel chains are manufactured of high quality steels, not available “off the shelf” from any steel supplier. These steels, in combination with careful design and expert manufacturing, have produced a high quality chain product that will give superior life and performance when properly maintained.

The recommendations in this catalog are based on our own experience and observations after almost 40 years of manufacturing chain for the forest products and other industries. The thoughts and suggestions of millrights, maintenance people, engineers, and others have contributed to our philosophy of the maintenance of chain in an industrial environment.

### INSTALLATION OF NEW CHAIN IN A NEW CONVEYOR

Check the following:

1. The width of the trough need not be more than 1/2" wider, on each side, than the overall width of the chain including attachments. Chains should not wander from side to side.
2. The wear strip must be full width of the conveyor so that the chain runs on the sidebar, the barrel of the chain does not support the chain itself.
3. Chains that are run in a trough should be at the correct height. Half the height of the sidebar is a good rule of thumb. If the chain is too low, the log or boards will be slowed in their movement. Conversely, a chain running too high in the trough can be easily forced out of the trough by side loads.
4. The root line of the sprocket or drum should be approximately 1/2" above the level of the conveyor wear strip. This allows the chain to be lifted slightly as it contacts the sprocket. The benefits are: immediate contact with the sprocket tooth, rather than 1/3 the way around the drum, and, improved wear life. A low root line relationship between the sprocket and wear strip causes the chain to be pulled down across the end of the wearstrip. This causes premature wear on the sidebars.
5. Be certain the chain has the correct amount of slack on the return. A good rule of thumb for conveyor chain is 5-10% of the sprocket centers depending on the size and weight of the chain.
6. Pay as much attention to the chain return as to the load side. Use a trough if possible. If not, again, the correct amount of slack is important. Too much slack can cause the chain to sway or jump—a condition that increases chain wear.
7. The last step is never to be forgotten for successful operation. Breaking in a new chain is a very important procedure. The chain should be run, no load, for a few hours (6–8). This will smooth up the chain running surfaces as well as the wear strip and the sprocket tooth face and allow rivet OD and barrel ID to polish up. This will ensure maximum life. It is advisable to have a film of clean water on the chain during the break-in period, and for that matter all the time. Water is an excellent lubricant because it will carry away the dirt generated by the chain rubbing the wear strip and sprocket. A fine spray on the chain at the tail end is enough. It is not necessary to have so much water that it makes a mess under the conveyor.

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## CUT DOWN ON MAINTENANCE COSTS

1. The overall width of the attachment, including the link, should not exceed twice the length of the chain pitch. For example, WR 132 is 6.050 pitch x 2 = 12.1" so, a 13" cradle would be suitable. Anything longer might cause the chain to twist under leverage, and break the link.
2. Head and tail sprockets, when used with attachment chain, should be flanged to locate the attachment when it enters and travels around the sprocket. Flanges are meant only to locate the attachment, not support it. If contact is made, fatigue failures may occur on the attachment welds. Remember to mount the sprocket or idler so that the root line is slightly higher than the wear strip.
3. Flare the trough and return ends slightly to prevent the attachments from hanging up on a squared edge.
4. Wear strips must be full width of the conveyor to support the attachments.
5. The preferred wear strip is a minimum of 450 BHN plate or one of several hardened UHMW products. UHMW, of course, has a very low coefficient of friction, and is best suited for **non-abrasive** locations.
6. Sprocket pitch diameters should be about 4 X's the chain pitch, for mill chains and 3 X's the pitch for drag chains. Also, it's better to use sprockets with an odd number of teeth.
7. Sprocket wear – A hooked sprocket tooth will eventually hold onto the chain beyond it's normal release point. The worst scenario would have the chain "wrap" the sprocket and break or tear up the drive. Install new chain and sprockets when the chain starts to climb the sprocket tooth, the pitch has now elongated due to wear between the rivet and barrel and possibly elongation of the sidebar hole. This chain will continue to wear itself and the sprocket even more rapidly from this point onward.

Keep the area around tail idlers clear and the idlers themselves turning. Use sprockets if necessary to avoid excess wear on the barrels being dragged around the idler face, if the idler isn't functioning, for the small difference in cost, it's always advisable to install sprockets at the tail end of the conveyor.

Keep idlers and drive sprockets aligned.

## CONVEYOR CHAIN SELECTION

1. Minimize the number of different sizes of chain in use throughout the mill. Quite often the same chain used on a log deck will also be suitable in a waste conveyor by adding on some weld-on cross flights.
2. Conveyor speeds have increased over the years and the chart below, showing recommended maximum FPM, may be of assistance when selecting conveyor chain. Don't forget that **Induction Hardened** pins & barrels can **further increase** these maximums. Consult with your CAN-AM factory representative.

Note the effect that a larger diameter sprocket has on the maximum FPM allowable.

If larger sprockets are not practical then often the best answer is to go to a smaller pitch chain. The shorter pitch length will be able to run faster over a given diameter sprocket as its pin & barrel articulation will be less than the larger pitch chain.

Also, when reviewing the above, consider using the smaller chain in its **XHD** version to increase the maximum working load.

3. Chain wear can be affected by many factors. We have listed some below with our suggestions:

### Side Bar Wear

- Check the wear strip for galling. Use a hard wear plate, minimum 400 BHN.
- Grit & dirt can cause excessive wear and if it cannot be eliminated then Induction Hardened components will help increase the service life.
- UHMW or nylon wear strips can help reduce wear, friction and horsepower and are best used in a non-abrasive environment.

### Pin to Barrel Wear

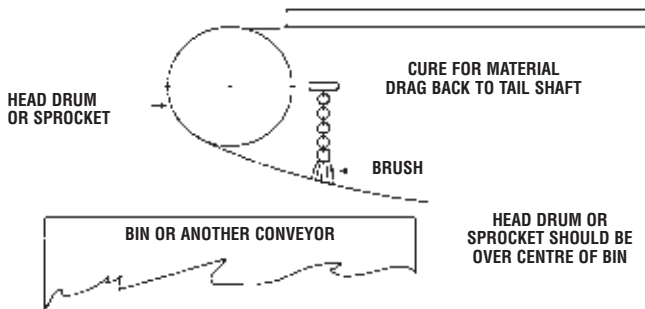
- Excessive speed and/or load are two common factors. Induction hardened components will help increase the service life.

CAN-AM can also supply chains with special components to tackle these problems, regreasable pins and specially hardened components are tools we have suggested and used with great success.

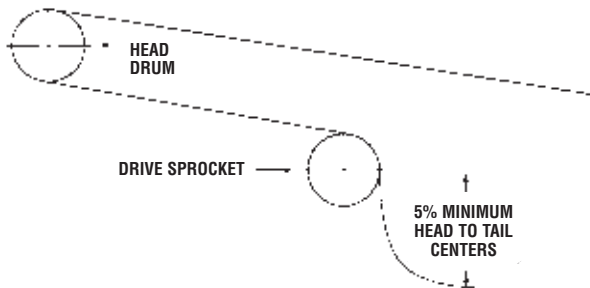
## MAXIMUM FPM ALLOWABLE

Number of Teeth Sprocket	Pitch in Inches						
	2	4	6	9	12	18	24
6	254	180	147	120	104	85	68
7	297	210	171	140	121	99	80
8	340	240	196	160	138	113	91
9	382	270	220	180	155	127	103
10	425	300	245	200	173	141	115
11	466	330	270	220	190	156	125
12	509	360	294	240	207	170	
13	551	390	318	260	224	184	
14	594	420	343	280	242	198	
15	636	450	367	300	259	212	
16	677	480	392				
17	717	510	416				
18	761	540	440				
19	803	570	465				
20	844	600					
21	886	630					

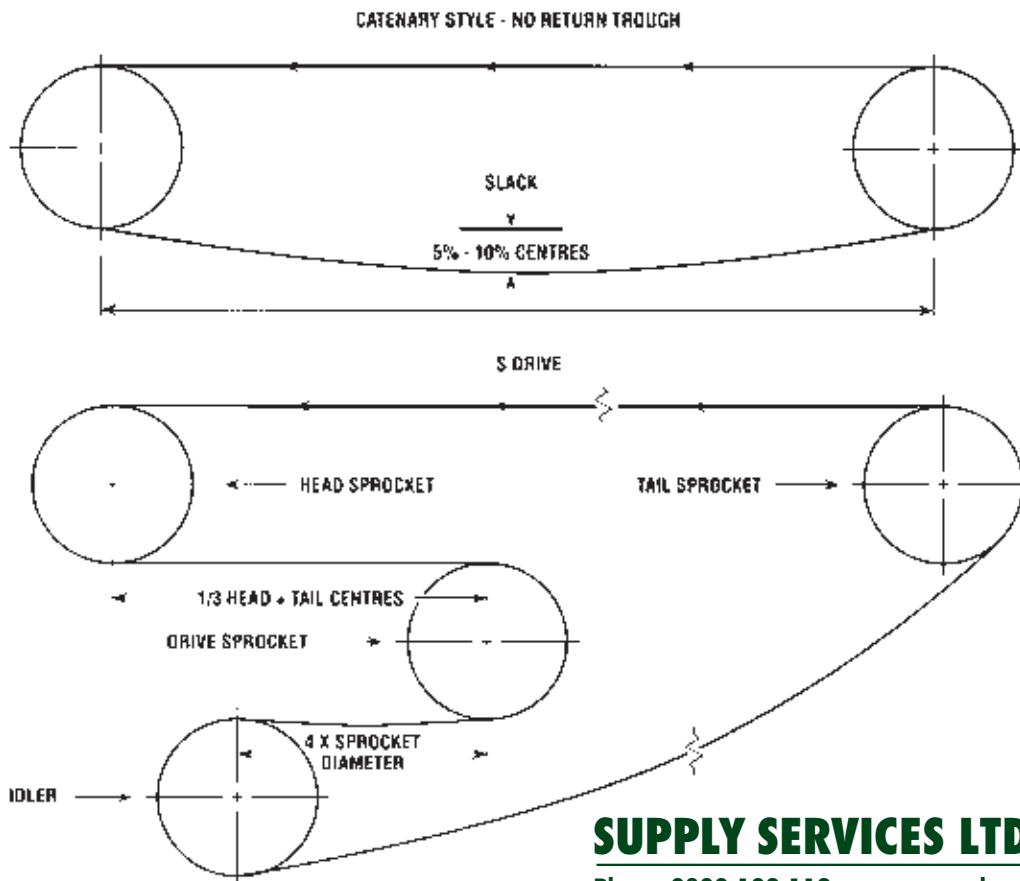
## HEAD END DRIVE FOR CHAIN CONVEYORS



## "WATERFALL" DRIVE FOR CHAIN CONVEYORS



## TYPICAL MILL CHAIN DRIVE ARRANGEMENTS



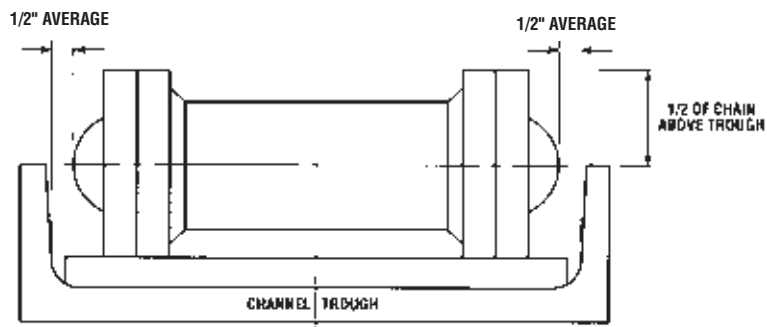
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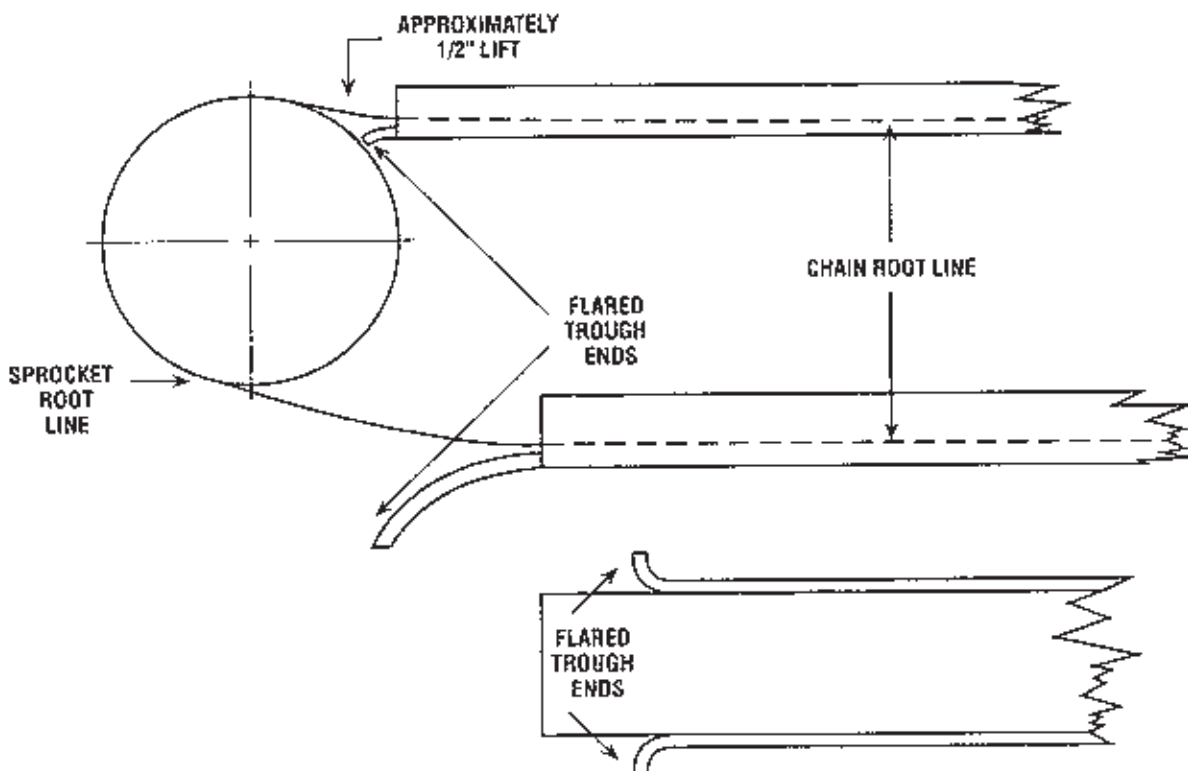




## MILL CHAIN FIT IN TROUGH



## SPROCKET TO TROUGH ALIGNMENT



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## LONG LINK CHAIN CONVEYORS

**Sprocket** – The sprocket should be 7 tooth for longer chain life. Also the sprocket should be drum flanged to a width equal to the length of the conveyor flights, to prevent the flights from flopping around as they travel around the sprocket. It will also help in keeping them level so they will lead into the return conveyor trough smoother.

**Lubrication** – A spray of clean water can be applied directly to the chain as it contacts the top tooth of the sprocket. This will lubricate the chain at the heaviest load point.

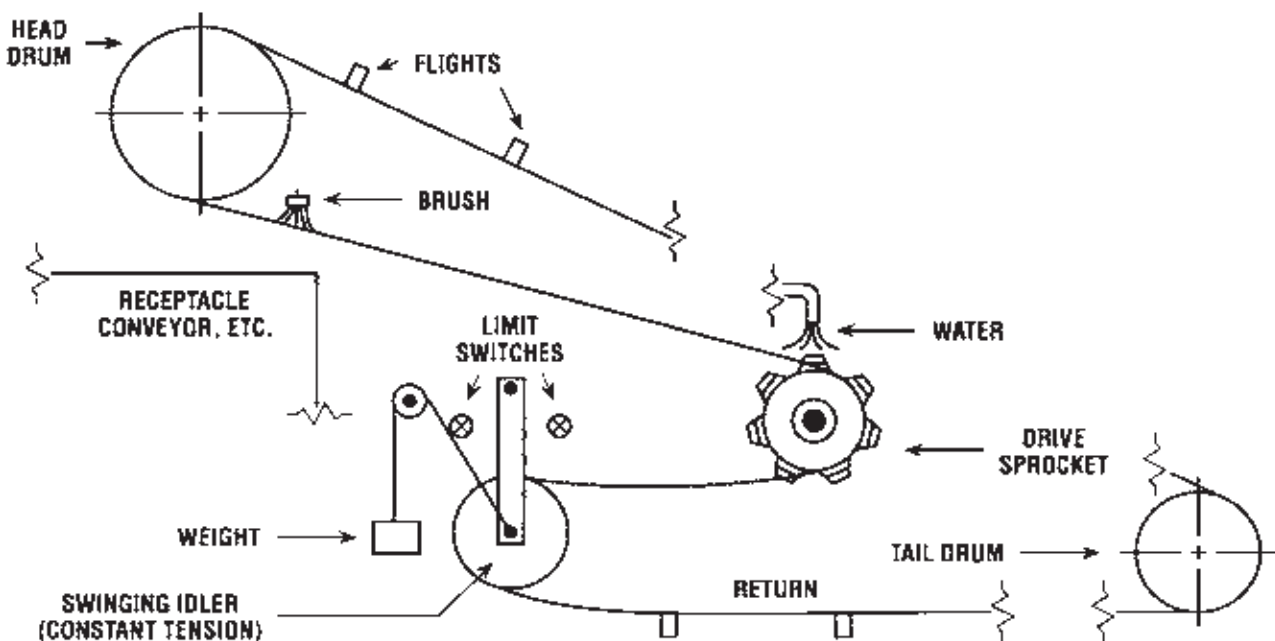
**Head Drum** – The head drum should be a diameter that is 5 times the chain pitch in inches. For example, the head drum dimension for 6" chain would be 30" in diameter. The head drum is the load drum of the conveyor. That is why we stress the importance of the large diameter.

**Tail and Idler Drum** – The tail drum should be 4 times the chain pitch in diameter, or 24" for 6" pitch chain. This drum has a tendency to plug up from trash collection dragged back on the return. That is why it is important to have a brush installed behind the head drum touching the chain and flights keeping the sawdust, etc. from being moved through the system.

The idler drum should be a swinging idler to provide constant tension to the chain. (See drawing). A good insurance policy is a pair of limit switches wired to the conveyor power source, one on each side of the swing structure, to stop the conveyor should it become too tight or too loose during operation. IT IS 100% NECESSARY THAT ALL DRUMS TURN FREELY!

**Flights** – Selection of the flights for long link conveyors is every bit as important as any other part of the system. They must fit the chain correctly, otherwise adverse wear on the chain and the flights can occur. CAN-AM offers different types of flights, as shown on pages 31 and 32 of the CAN-AM catalog. The oldest and probably the most widely used is the "Skookum" flight. It is fabricated mild steel and available as a bolt together or weld together part. Other flights are our "Tang" style which is a cast steel slip together and weld flight with large surfaces top and bottom where they slide on the conveyor bottom, UHMW flights are also available, see page 33.

## LONG LINK CHAIN DRIVE



## TERMS AND CONDITIONS

### General

These conditions supersede those contained in all previous quotations, orders and agreements whether written or oral and shall be the only conditions governing future transactions between the seller and the buyer, unless otherwise specifically agreed to in writing by the seller. Clerical errors are subject to correction. Time is of the essence hereof.

### Quotation Period

A quotation is valid for a period of Thirty (30) days from quotation date. It is subject to partial acceptance only upon written consent of the seller.

### Delays

Delivery dates are estimates only and are predicated on conditions as known to the Seller at the time of the quotation and the Seller shall not be liable for any direct, indirect or consequential damages due to delays or inability to perform caused by factors beyond its control including but not limited to acts of God, flood, war, riot, fire, accident, explosion, labour trouble, acts of Government, delay or default by sub-contractors or suppliers of material or services or transportation difficulties. Delivery dates shall be extended by the period of such delay.

### Terms

All orders are subject to approval of Seller's Credit Department. All payments past due shall bear interest at the rate of 1-1/2% per month (equivalent to 18% per annum) until paid. Orders cannot be cancelled or changed or deliveries deferred, except on terms satisfactory to the Seller. If the Buyer fails to pay an installment of the purchase price when due, the Seller may stop work and, at the Seller's option, the entire purchase price shall become immediately due and payable.

### Payment

All prices quoted are F.O.B. Seller's plant. Sale shall be deemed complete and the property in the goods pass when the goods are ready for delivery. Goods shall be invoiced when ready for delivery and payment thereof shall be net cash Thirty (30) days from the date of invoice. The Seller reserves the right to alter the terms of payment or to require payment prior to the time of delivery if, in the Seller's opinion, the Buyer's financial condition or other circumstances do not warrant delivery on the terms originally agreed upon.

### Taxes

Prices quoted are exclusive of all sales and excise taxes, customs duties or other taxes or levies, and the Buyer is to be responsible therefor.

### Shipment

If transportation is quoted, the Seller shall decide carrier and method of shipment unless Buyer's instructions have been agreed to by the Seller prior to quotation. The Seller will not be responsible for any loss or damage to the goods after they are ready for delivery to carrier and the Buyer agrees to assume such risks, insurance premiums, special crating or shipping charges shall be arranged and paid for by the Buyer.

### Escalation

Prices quoted are based on correct labour rates and material costs and, if applicable, current freight rates, customs duties, taxes and foreign exchange rates and are therefore subject to change to the extent of any change (either before or after acceptance of this quotation and during the contract period) in any of the foregoing items.

### Inspection

If Buyer reserves the right to inspect the goods prior to delivery such inspection shall be made within Seven (7) days of Buyer receiving written notice from Seller that the goods are ready for delivery; otherwise Buyer shall be deemed to have waived all rights of inspection and delivery to the Buyer shall be deemed to be complete at the end of the Seven (7) day period.

### Storage and Return of Goods

If the Buyer is unable to remove the goods within Thirty (30) days of their delivery ex Seller's plant, the Seller shall be entitled to charge storage on the goods. Goods cannot be returned except upon Seller's written consent, and will be subject to a restocking charge equal to 25% of the Buyer's invoice.

### Patents

The Buyer agrees to save the Seller harmless from all patent infringement claims, liability and expense resulting from the Seller's compliance with the Buyer's specifications or designs now or hereafter forming a part of any work or from written instructions of the Buyer directing the manner in which the Seller shall perform any work.

### Applicable Law

Any contract between the Buyer and Seller shall be subject to and construed in accordance with the laws of the state or province wherein the goods were supplied from.

### Specifications

In accordance with the policy of the Seller to constantly improve its products, the specifications, designs, and dimensions contained in this catalog are subject to change without notice.

### Responsibility

The Seller declines responsibility for any damages incurred as a result of improper installation of attachments installed by firms other than the Seller.

### Packaging

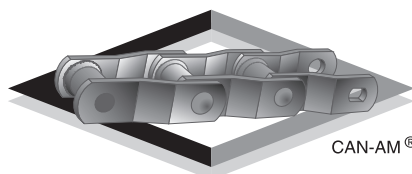
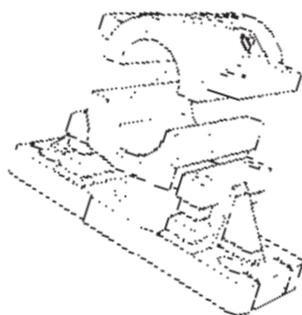
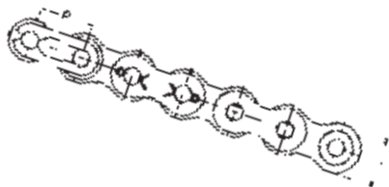
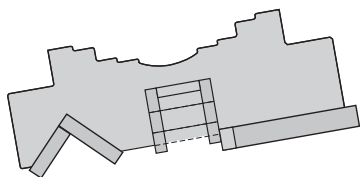
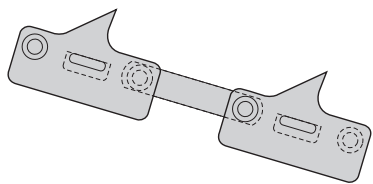
Chain is shipped in wired bundles of approximately 10 foot lengths. Any other lengths required shall be made on Buyer's authorization at time of order.

### Dimensions and Weights

Tabular dimensions and weights are approximate and non-binding. Design improvements may result in variations to published figures. Verification is recommended.

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## PRODUCTS AND SERVICES PROVIDED BY CAN-AM CHAINS

### SHARP CHAINS D.L.I. CHAINS AUTO ROTATE CHAINS

CAN-AM Chains make a full range of specialty chain and flights to suit all facets of industry. Pictured here are two examples of high speed scanner/canter feed chains for the lumber industry.

### CAN-AM FABRICATED STEEL SPROCKETS

Normally made of mild steel plate. Heat treated and induction hardened plate sprockets with hardnesses from 360 to 500 BHN are available.

### CAN-AM ROLLER CHAIN

Built to our exacting standards and requirements to exceed ANSI standards. These chains are all made with solid rollers and bushings.

### SPLIT SLEEVE BEARINGS 2-2500 SERIES

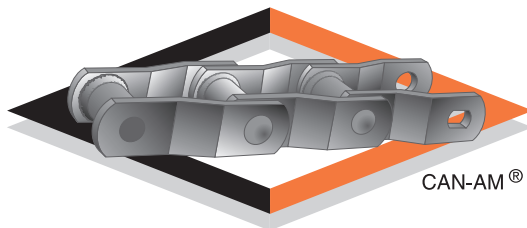
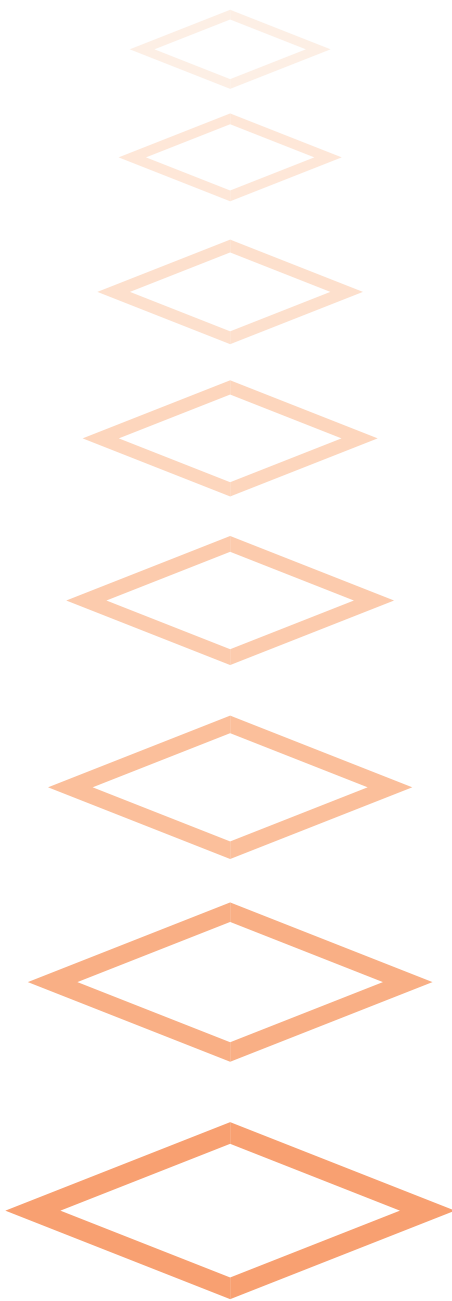
CAN-AM manufactures a full line of these bearings and stocks them with liners of polyurethane, bronze, babbitt or Zinc Aluminum.

Please contact us for further information or visit our web site at [www.can-amchains.com](http://www.can-amchains.com)

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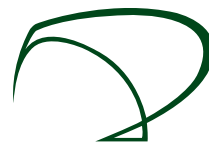
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