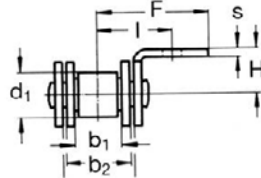
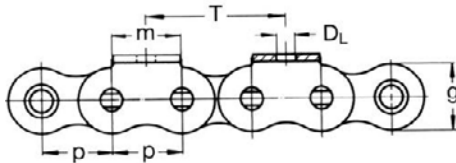


# Metric Attachment Chain

E-Series - Din 8187-1/ISO 606

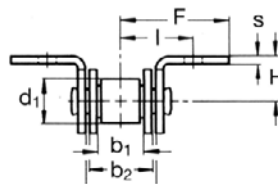
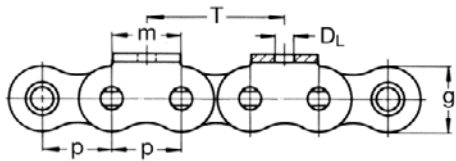


## A1 - Bent Tab, 1 Hole, 1 Side



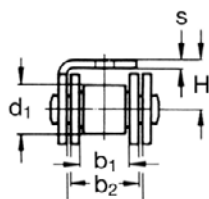
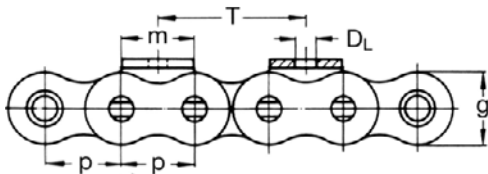
Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - A1
06B-1	E06B-1 CL - A1
08B-1	E08B-1 CL - A1
10B-1	E10B-1 CL - A1
12B-1	E12B-1 CL - A1
16B-1	E16B-1 CL - A1
20B-1	E20B-1 CL - A1
24B-1	E24B-1 CL - A1

## K1 - Bent Tab, 1 Hole, 2 Sides



Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - K1
06B-1	E06B-1 CL - K1
08B-1	E08B-1 CL - K1
10B-1	E10B-1 CL - K1
12B-1	E12B-1 CL - K1
16B-1	E16B-1 CL - K1
20B-1	E20B-1 CL - K1
24B-1	E24B-1 CL - K1

## R1 - Bent Tab, Reversed 1 Hole



Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - R1
06B-1	E06B-1 CL - R1
08B-1	E08B-1 CL - R1
10B-1	E10B-1 CL - R1
12B-1	E12B-1 CL - R1
16B-1	E16B-1 CL - R1
20B-1	E20B-1 CL - R1
24B-1	E24B-1 CL - R1

T = 2p as shown, other spacing as required.

Chain Size	Pitch p		Inner Width b <sub>1</sub> min mm	Inner Link Width b <sub>2</sub> max mm	Roller Dia. d <sub>1</sub> min mm	Plate Height g max. mm	Breaking Load DIN F <sub>B</sub> min	Attachment Dimensions					
	mm	in						m	D <sub>L</sub>	l	F	H	S
05B-1	8	—	3.00	4.77	5.00	7.1	5,000	8.0	3.20	6.6	12.0	5.0	0.80
06B-1*	9.525	3/8	5.72	8.53	6.53	6.53	9,000	8.0	3.50	9.5	13.5	6.5	1.25
08B-1	12.7	1/2	7.75	11.30	8.51	11.8	18,000	12.5	4.50	13.1	19.0	10.0	1.50
10B-1	15.875	5/8	9.65	13.28	10.16	14.7	22,400	15.0	5.50	16.7	27.0	10.0	1.70
12B-1	19.05	3/4	11.68	15.62	12.07	16.1	29,000	18.5	6.60	18.6	29.0	11.0	1.80
16B-1	25.4	1	17.02	25.40	15.88	21.0	60,000	25.0	9.00	28.9	41.8	18.0	3.00
20B-1	31.75	1/4	19.56	29.00	19.05	26.4	95,000	35.0	9.00	33.4	50.0	18.0	3.75
24B-1	38.1	1/2	25.40	37.90	25.40	33.4	160,000	38.0	11.00	44.0	64.0	25.0	5.00

\* With straight side plates only.

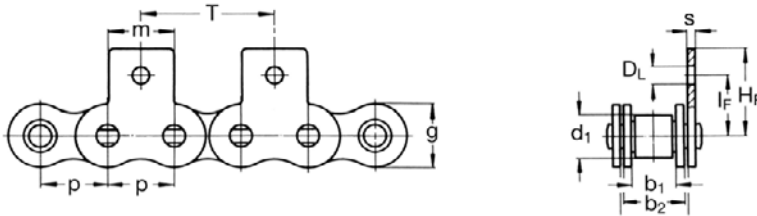
Note: The above attachments are Connecting Type Links for simple assembly by the equipment user. Chain with riveted attachments can be assembled to order at PTI in Charlotte. Inner Links with attachments, although not as common, are also possible from production. For custom chains, please detail the requirements on the Attachment Detail page.

# Metric Attachment Chain

E-Series - Din 8187-1/ISO 606

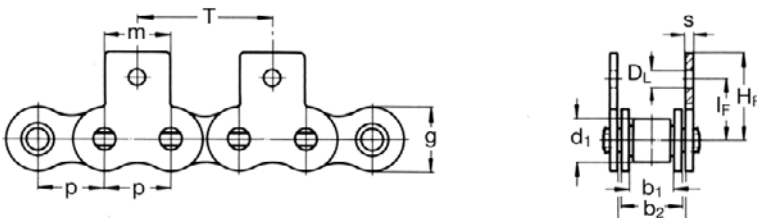


## SA1 = Straight Attachment, 1 Hole, 1 Side



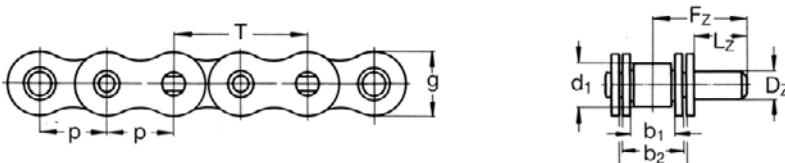
Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - SA1
06B-1	E06B-1 CL - SA1
08B-1	E08B-1 CL - SA1
10B-1	E10B-1 CL - SA1
12B-1	E12B-1 CL - SA1
16B-1	E16B-1 CL - SA1
20B-1	E20B-1 CL - SA1
24B-1	E24B-1 CL - SA1

## SK1 = Straight Attachment, 1 Hole, 2 Sides



Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - SK1
06B-1	E06B-1 CL - SK1
08B-1	E08B-1 CL - SK1
10B-1	E10B-1 CL - SK1
12B-1	E12B-1 CL - SK1
16B-1	E16B-1 CL - SK1
20B-1	E20B-1 CL - SK1
24B-1	E24B-1 CL - SK1

## EP1 = Extended Pin, 1 Side



Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - EP1
06B-1	E06B-1 CL - EP1
08B-1	E08B-1 CL - EP1
10B-1	E10B-1 CL - EP1
12B-1	E12B-1 CL - EP1
16B-1	E16B-1 CL - EP1
20B-1	E20B-1 CL - EP1
24B-1	E24B-1 CL - EP1

T = 2p as shown, other spacing as required.

Chain Size	Pitch p		Inner Width b <sub>1</sub> min mm	Inner Link Width b <sub>2</sub> max mm	Roller Dia. d <sub>1</sub> min mm	Plate Height g max. mm	Breaking Load DIN F <sub>B</sub> min	Attachment Dimensions							
	mm	in						m	D <sub>L</sub>	I <sub>F</sub>	H <sub>F</sub>	S	D <sub>Z</sub> h9	L <sub>Z</sub> **	F <sub>Z</sub>
05B-1	8	—	3.00	4.77	5.00	7.1	5,000	8.0	3.00	7.5	13.0	0.80	4.0	10	13.3
06B-1*	9.525	3/8	5.72	8.53	6.53	6.53	9,000	8.0	3.50	9.0	13.8	1.25	5.0	15	20.7
08B-1	12.7	1/2	7.75	11.30	8.51	11.8	18,000	12.5	4.50	14.7	20.3	1.50	6.0	15	22.4
10B-1	15.875	5/8	9.65	13.28	10.16	14.7	22,400	15.0	5.50	17.2	26.7	1.70	6.5	20	28.5
12B-1	19.05	3/4	11.68	15.62	12.07	16.1	29,000	18.5	6.60	18.7	29.0	1.80	7.0	20	29.8
16B-1	25.4	1	17.02	25.40	15.88	21.0	60,000	25.0	9.00	28.6	41.5	3.00	10.0	30	45.9
20B-1	31.75	1/4	19.56	29.00	19.05	26.4	95,000	35.0	9.00	30.5	45.7	3.75	12.0	30	48.4
24B-1	38.1	1/2	25.40	37.90	25.40	33.4	160,000	38.0	11.00	41.0	60.0	5.00	16.0	35	59.1

\* With straight side plates only. \*\* Other lengths on request.

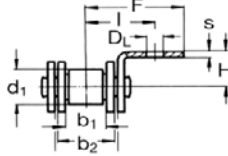
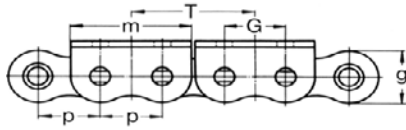
Note: The above attachments are Connecting Type Links for simple assembly by the equipment user. Chain with riveted attachments can be assembled to order at PTI in Charlotte. Inner Links with attachments, although not as common, are also possible from production. For custom chains, please detail the requirements on the Attachment Detail page.

# Metric Attachment Chain

E-Series - Din 8187-1/ISO 606

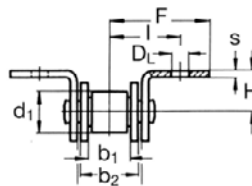
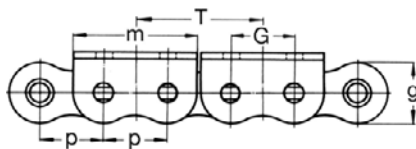


## A2 = Bent Tab, 2 Holes, 1 Side



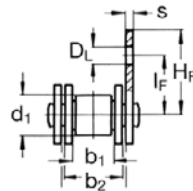
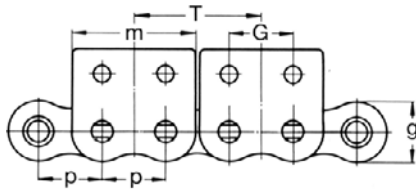
Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - A2
06B-1	E06B-1 CL - A2
08B-1	E08B-1 CL - A2
10B-1	E10B-1 CL - A2
12B-1	E12B-1 CL - A2
16B-1	E16B-1 CL - A2
20B-1	E20B-1 CL - A2
24B-1	E24B-1 CL - A2

## K2 = Bent Tab, 2 Holes, 2 Sides



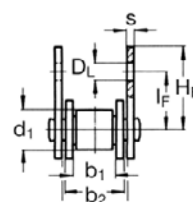
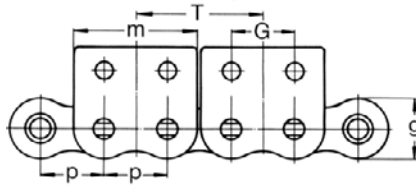
Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - K2
06B-1	E06B-1 CL - K2
08B-1	E08B-1 CL - K2
10B-1	E10B-1 CL - K2
12B-1	E12B-1 CL - K2
16B-1	E16B-1 CL - K2
20B-1	E20B-1 CL - K2
24B-1	E24B-1 CL - K2

## SA2 = Straight Attachment, 2 Holes, 1 Side



Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - SA2
06B-1	E06B-1 CL - SA2
08B-1	E08B-1 CL - SA2
10B-1	E10B-1 CL - SA2
12B-1	E12B-1 CL - SA2
16B-1	E16B-1 CL - SA2
20B-1	E20B-1 CL - SA2
24B-1	E24B-1 CL - SA2

## SK2 = Straight Attachment, 2 Holes, 2 Sides



Chain Size	Attachment Connecting Link Part No.
05B-1	E05B-1 CL - SK2
06B-1	E06B-1 CL - SK2
08B-1	E08B-1 CL - SK2
10B-1	E10B-1 CL - SK2
12B-1	E12B-1 CL - SK2
16B-1	E16B-1 CL - SK2
20B-1	E20B-1 CL - SK2
24B-1	E24B-1 CL - SK2

T = 2p as shown, other spacing as required.

Chain Size	Pitch p		Inner Width		Inner Link Width	Roller Dia.	Plate Height	Breaking Load DIN	Attachment Dimensions							
	mm	in	b <sub>1</sub> min mm	b <sub>2</sub> max mm					d <sub>1</sub> min mm	g max. mm	F <sub>B</sub> min	m mm	D <sub>L</sub> mm	G mm	I mm	F mm
06B-1*	9.525	3/8	5.72	8.53	6.53	8.2	9,000	18.2	3.20	9.525	9.8	13.2	5.7	9.2	12.6	1.25
08B-1	12.7	1/2	7.75	11.30	8.51	11.8	18,000	23.2	4.50	12.7	13.1	19.0	10.0	14.7	20.3	1.50
10B-1	15.875	5/8	9.65	13.28	10.16	14.7	22,400	28.5	5.50	15.9	16.7	27.0	10.0	17.2	26.7	1.70
12B-1	19.05	3/4	11.68	15.62	12.07	16.1	29,000	33.6	6.60	19.1	18.6	29.0	11.0	18.7	29.0	1.80
16B-1	25.4	1	17.02	25.40	15.88	21.0	60,000	46.5	9.00	25.4	28.9	42.0	18.0	28.6	41.5	3.00
20B-1	31.75	1 1/4	19.56	29.00	19.05	26.4	95,000	55.7	9.00	31.75	33.4	50.0	18.0	30.5	45.7	3.75
24B-1	38.1	1 1/2	25.40	37.90	25.40	33.4	160,000	77.0	11.00	38.1	44.0	63.0	25.0	41.0	60.0	5.00

\* With Straight side Plates Only.

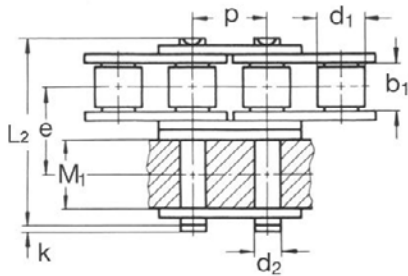
Note: The above attachments are Connecting Type Links for simple assembly by the equipment user. Chain with riveted attachments can be assembled to order at PTI in Charlotte. Inner Links with attachments, although not as common, are also possible from production. For custom chains, please detail the requirements on the Attachment Detail page.

# Metric Attachment Chain

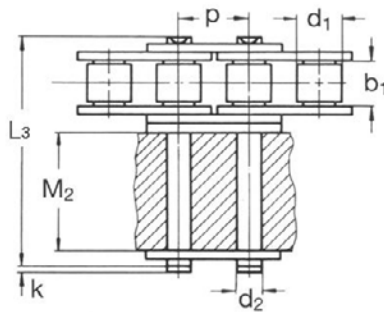
## Extended Pins



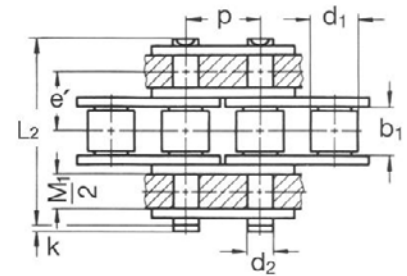
**Simplex Chain**  
with Duplex Connecting Link



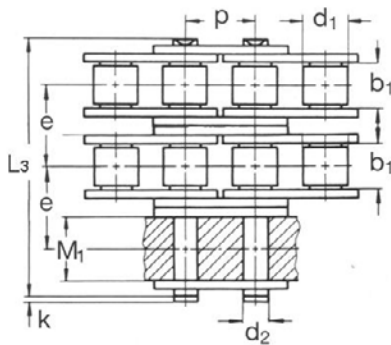
**Simplex Chain**  
with Triplex Connecting Link



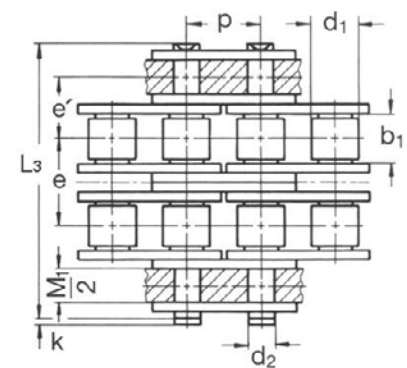
**Simplex Chain**  
with Duplex Connecting Link



**Duplex Chain**  
with Triplex Connecting Link



**Duplex Chain**  
with Triplex Connecting Link



Dimensions in mm

Chain Size	Pitch p		Inner Width b <sub>1</sub> min mm	Roller Dia. d <sub>1</sub> min mm	Pin d <sub>2</sub> max. mm	Traverse Pitch		Attachment Width		Projection over Connecting Link k max	Pin Length	
	mm	in				e	e'	M <sub>1</sub> max. mm	M <sub>2</sub> max. mm		L <sub>2</sub> max. mm	L <sub>3</sub> max. mm
06B-1	9.525	3/8	5.72	6.35	3.28	10.24	7.24	8.5	—	3.3	23.8	—
06B-2	9.525	3/8	5.72	6.35	3.28	10.24	7.24	8.5	—	3.3	—	34.0
08B-1	12.7	1/2	7.75	8.35	4.45	13.92	10.10	11.3	25.6	3.9	31.0	—
08B-2	12.7	1/2	7.75	8.51	4.45	13.92	10.10	11.3	—	3.9	—	44.9
10B-1	15.875	5/8	9.65	10.16	5.08	16.59	11.62	13.3	30.0	4.1	36.2	—
10B-2	15.875	5/8	9.65	10.16	5.08	16.59	11.62	13.3	—	4.1	—	52.8
12B-1	19.05	3/4	11.68	12.07	5.72	19.46	13.63	15.6	34.8	4.6	42.2	—
12B-2	19.05	3/4	11.68	12.07	5.72	19.46	13.63	15.6	—	4.6	—	61.7
16B-1	25.4	1	17.02	15.88	8.28	31.88	22.30	25.4	56.8	5.4	68.0	—
16B-2	25.4	1	17.02	15.88	8.28	31.88	22.30	25.4	—	5.4	—	99.9

Note: All designs can also be supplied as Marathon roller chains (maintenance free) or Stainless Steel.

# Attachment Chain Worksheet



## Overview

Attachment Chain is unique to the machine or application. The position and type of links are important. If a drawing exists of the chain, this will be adequate to produce a replacement. If no drawing is available, completing the following detail will help determine the replacement chain requirements.

European or Metric Chain is produced according to an ISO / DIN Standard. Attachments of different European brands may have slight dimensional differences. Frequently these small differences may not be critical. The details below will identify important parameters. Therefore if a brand of chain

can be identified on a side plate marking, this will assist our Sales Department for an exact match. Brand attachments may have slight dimensional differences and DIN attachments are generally considered universal attachments. PTI Sales will assist you with this detail and/or comparison.

On a Bent Tab Attachment for instance, the distance of the Tab Hole from the chain center line or the height of the Tab may be important. All of these comparable dimensions between brands are similar and should be considered. Application requirements may also be a determining factor as to which dimensions are critical to duplicate.

## Attachment Types

PTI stocks Attachment Links that are Connecting Links. These Links can be used to custom assemble or repair an Attachment Chain. PTI also stocks Riveting Attachment Links that allow an Attachment Chain to be produced rather quickly and to be a continuous riveted chain with one or no master links. Our production capability in Europe will also produce these custom chains, especially when long strands, volume or delivery time allows.

Attachments are most commonly part of the chain outer links. Similar or matching links are also possible on the Inner or Roller Link. These types are less common, but considered standard. So please detail requirements carefully. Lastly, as a guide, if you prefer that PTI help identify the attachment details, we can issue a Return of Goods Shipping Number for you to send us a sample of the chain.

## Application:

Chain Size or Pitch: Single, Double, Triple, Brand or Drawing (if available): \_\_\_\_\_

Material requirements: Steel, Stainless Steel, Nickel Plated, Marathon Lube Free, Marathon Stainless Lube Free, Other: \_\_\_\_\_

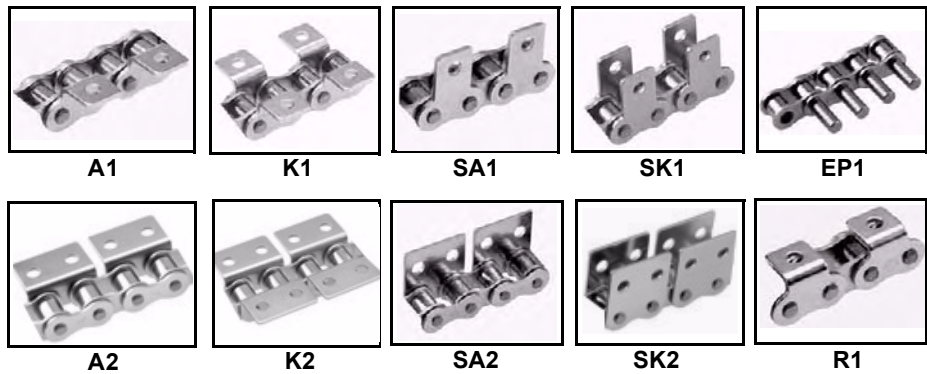
Length of strands: Feet or Meters or total number of links: \_\_\_\_\_

Total number of Strands and other details: \_\_\_\_\_

## Most Common Attachments

### Chain Sets, Matching

Metric chain typically assembles in 5 meter (16.5 ft) lengths unless specified. Longer lengths are possible. Strands in notched pairs are clearly marked for final assembly. All chain is pre-stretched so matching becomes as simple as assembly.



Use the chain sketch below to indicate attachment position.

