Rexnord

... MOVING AHEAD

Rexnord Chains

Quality for Agricultural Machines

Think like partners – act like partners

Speed

The speed with which modern technologies change our world is breathtaking.

For us two aims are certain:

We are determined, with our products for our customers, to occupy a leading position as regards technology.

We want, together with our customers, to achieve quality and sales growth.

Consulting

Our application engineers concentrate on the customer's interests.

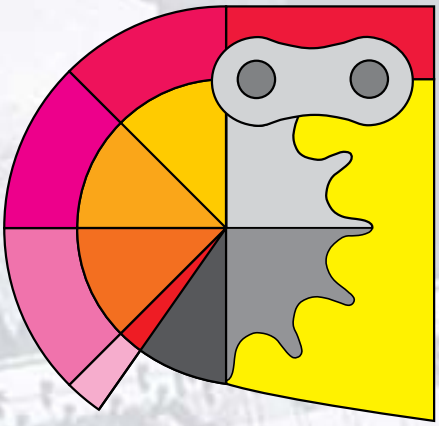
We concentrate on the individual wishes and needs of the customer when calculating and identifying the correct chain drive.

Together with our customers, we find solutions, which optimize the factors of safety, service life and price.

Partnership

We know what the customer needs in his market for his product in the future.

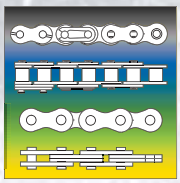
We listen to you and observe driving and conveying world-wide. We carry out analyses on the customer's premises and apply practicable solutions. So that you remain competitive.

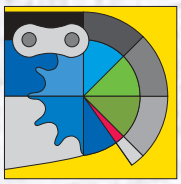


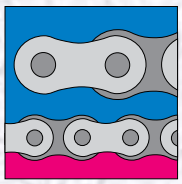
Service

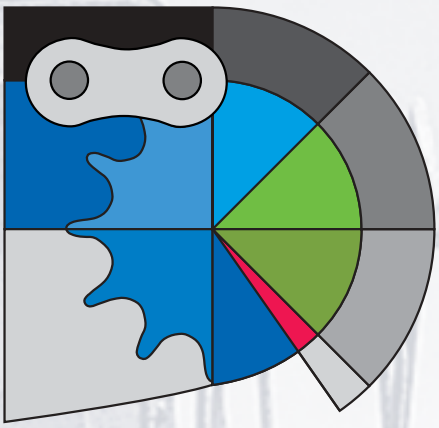
We are only satisfied when you are.

We have created the conditions for this by means of intensive consulting, partnership and our own sales activities. Thus there is a combination of our market know-how, technical competence, customer service and the satisfaction of our customers.

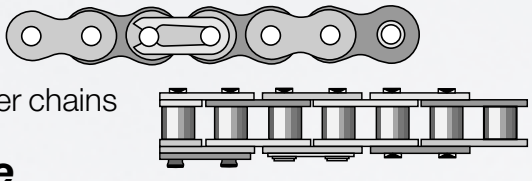




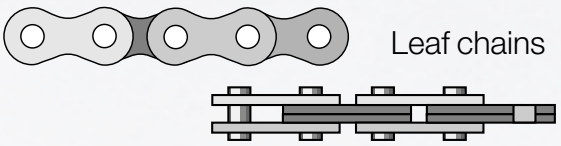




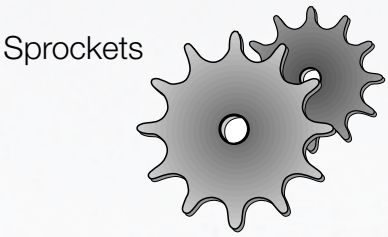
Product range



Roller chains



Leaf chains



Sprockets

Competence

As the manufacturer of one of the most extensive chain ranges for drives and conveying we are an established partner of leading companies. Our 5,000 chain variants provide an impressively large number of solutions and flexibility.

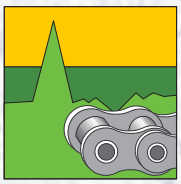
Innovation

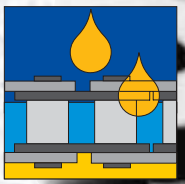
The secret lies in the production methods and the material.

Several thousand tools developed by ourselves rotate in the flow of production.
650 special tools were constructed by us for the manufacture of special chains.
30 special steels, alloyed, stainless, patented, are processed.
Moreover, we offer many different lubrications.
Through our customers we have become a specialist in surface refinement and the heat treatment of steel.

Quality

For Rexnord means that the customer comes back and not the chain.





Rexnord Methods of Production Towards Optimizing Quality

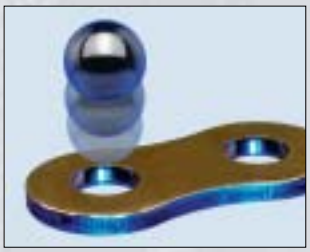
High Case Hardness

The pins and bushes that constitute the chain bearing area are furnished with an optimally deep hardness layer. This stratum contributes essentially to the life span. Surface hardness is approximately 60 HRc.

High Case and Depth Hardness.

Ball-Drifting

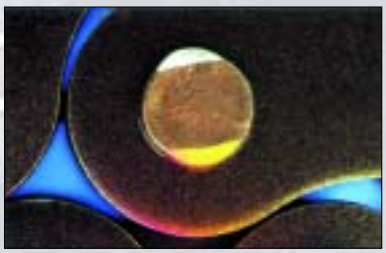
Ball-drifting of the plate bores serves to achieve strain-hardening of the material. All punching flutes and sharp edges are simultaneously removed. Press fits and fatigue strength are so optimally improved.



Ball-Drifting.

Shot Peening

All plates, bushes and rollers are shot peened for further improving fatigue resistance. This effective cold processing moreover consolidates the surfaces and increases their load-bearing properties. Such parts have a built-in tension and therefore higher resistance against loading.



Shot Peening.

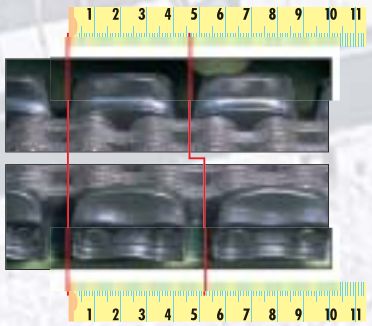
Shock-Resistant Rollers

Rexnord Rollers are produced to high precision, of a uniform wall thickness and absolutely free from any taper. An optimal seating and smooth running is so warranted. The Rollers are shot-peened and posses a high fatigue strength for resisting running-in impacts.

Shock-Resistant Rollers.

Pre-Loading

Rexnord Roller Chains are “pre-run-in” under high load. Customary chain run-in elongation is thereby minimized and expensive tensioning in application avoided. All Chains are subjected to a severe length control. High pre-loading enhances their load-bearing property and reliability.



Pre-Loading.

Uniform Quality

The uniform quality of Rexnord chains is not merely ensured by initial and final inspections, but far more, also by in-process routine testing of the individual elements.

Uniform Quality.

Advantages of Rexnord Chains

Contrary to widespread opinion, the breaking load of a chain is not an indicator of resistance to fatigue and long wear life.

Therefore, chains manufactured to specified standards, and with equal breaking loads, differ in quality from manufacturer to manufacturer.

Important for quality are fatigue strength and wear resistance.

Special manufacturing techniques developed by Rexnord formulate such factors as fatigue resistance, wear resistance and tensile strength to provide their optimum combination.

This jig boring machine plays a large role in the precision of the Rexnord chain tools.

For the testing of fatigue strength, we use, among others, this – designed according to the latest technological knowledge – high frequency fatigue testing machine.

Quality Management System

Rexnord Kette GmbH employs a quality management system which is reflected in the special commitments to our customers.

The quality management handbook contains the quality management system from Rexnord Kette GmbH.

Thereby all our customers have access to the information how Rexnord realises and guarantees its products.

We wish to provide all our colleagues with some helpful guidelines, which will help to support and motivate them in their endeavours to work with quality consciousness.

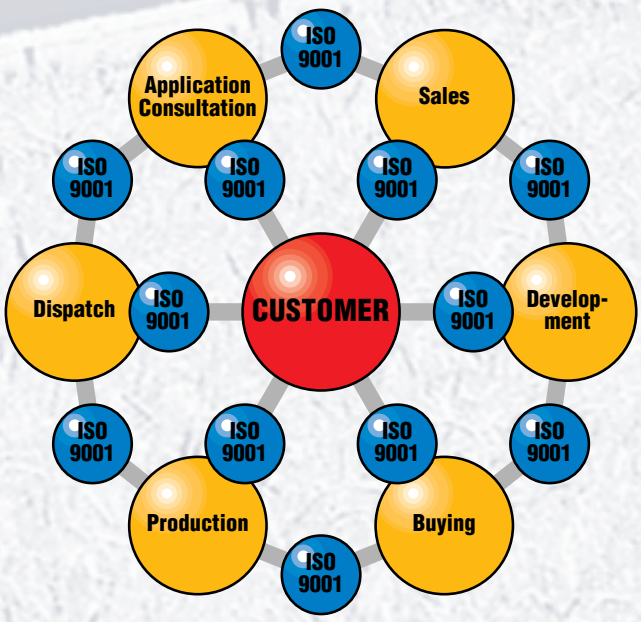
Contents:

This handbook contains an all-round binding description, which is written in 20 elements and according to the internationally known DIN EN ISO 9001.

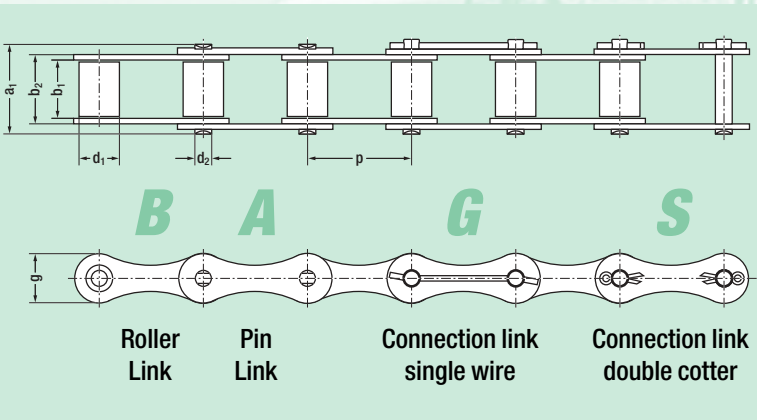
Therefore, the colleagues involved have access to process details, working details and testing methods as well as all-round processing practices.

Furthermore, we are constantly improving our products and organisation. Part of this improvement involves following up internal and external developments with positive interest and constant evaluation of our market.

The fruits of this policy are shown by the certification awarded according to
DIN EN ISO 9001, DIN EN ISO 14001 and
API Spec Q1 and Spec 7F
through American Petroleum Institute



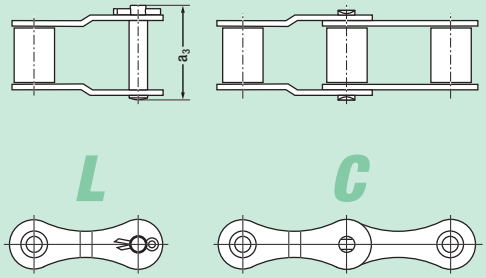
Agricultural Roller Chains



Industry Standard

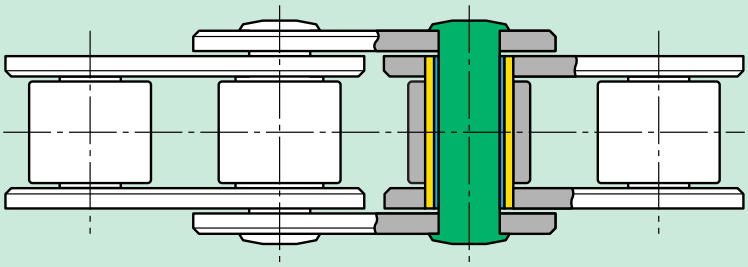
Chain Description		Pitch p		Roller Width	Roller Diameter	Pin Diameter	Inner Width	Linkplate Height	Pin Width	Overall Width	Bearing Area	Ultimate Strength	Weight	Loose Parts			
old	new	inch	mm	b_1 min. mm	d_1 max. mm	d_2 max. mm	b_2 max. mm	g max. mm	a_1 max. mm	a_3 max. mm	A cm^2	F_B N	≈ q kg/m	G	S	C	L
SK 627	30-1 BG GL	1.18	30.0	19.05	15.88	8.27	25.45	20.5	35.6	39.0	2.1	45 000	2.45	●	●		
RL 726	S 52 BK	1.50	38.1	16.0	15.24	5.72	21.9	17.0	30.5	33.8	1.2	28 000	1.42	●	●	●	●
RL 738 [1]	38.4 W GL [1]	1.50	38.4	19.05	15.88	6.92	23.9	17.0	33.7	37.55	1.67	31 500	1.68	●	●	●	●
SK 717 [1]	38.4 H GL [1]	1.50	38.4	19.05	15.88	8.27	25.45	20.1	35.6	39.75	2.1	45 000	2.10	●	●	●	●
RL 753	S 55 SK8 H	1.63	41.4	20.5	15.88	7.97	27.0	20.0	37.2	41.6	2.15	42 500	1.75	●	●	●	●
RL 764	S 55 H	1.63	41.4	22.23	17.9	8.26	29.23	20.5	39.3	42.8	2.36	47 500	2.04	●	●		●
RL 766 [1]	S 55 SK2 GL [1]	1.63	41.4	22.23	15.88	8.26	28.03	20.5	39.3	44.6	2.56	60 000	2.20	●	●		●
RL 774 [1]	S 55 SK6 GL [1]	1.63	41.4	19.81	16.87	7.19	25.45	19.0	35.6	39.7	1.86	47 500	1.95	●	●		●
SK 838	216 B SK1 GR	2.00	50.8	19.0	19.05	9.53	27.4	26.0	40.0	44.0	2.62	85 000	2.62		●		

[1]) Chains with straight link plates



Offset link single

Offset link double



Roller Chains with Thermoplastic Bearings

Bushing
Pin
Thermoplastic bearing

ISO 487/DIN 8189

Chain Description		Pitch p		Roller Width	Roller Diameter	Pin Diameter	Inner Width	Linkplate Height	Pin Width	Overall Width	Bearing Area	Ultimate Strength	Weight	Loose Parts			
old	new	inch	mm	b_1 min. mm	d_1 max. mm	d_2 max. mm	b_2 max. mm	g max. mm	a_1 max. mm	a_3 max. mm	A cm^2	F_B N	≈ q kg/m	G	S	C	L
RL 640	S 32 W	1.15	29.21	15.88	11.43	4.47	20.19	13.5	26.7	29.6	0.90	20 000	0.76	●	●		●
RL 670	S 42 W	1.375	34.93	19.05	14.27	7.0	25.4	19.6	34.25	36.7	1.78	27 000	1.49	●	●		●
SK 742	S 45 W	1.63	41.4	22.23	15.24	5.74	28.58	17.2	38.1	40.6	1.63	25 000	1.46	●	●	●	●
RL 741	S 52 W	1.50	38.1	22.23	15.24	5.74	28.58	17.3	38.1	40.6	1.63	25 000	1.56	●	●	●	●
SK 744	S 55 W	1.63	41.4	22.23	17.78	5.74	28.58	17.3	38.1	40.6	1.63	25 000	1.65	●	●	●	●
RL 747	S 62 W	1.65	41.91	25.4	19.05	5.72	30.6	17.0	40.5	42.6	1.82	28 000	1.95	●	●		●
RL 942	S 77	2.30	58.34	22.23	18.26	8.92	30.9	24.6	43.8	49.2	2.77	45 000	2.35	●	●		●
RL 1042	S 88	2.60	66.27	28.58	22.86	8.92	37.52	24.2	50.2	55.5	3.34	45 000	2.78	●	●		●

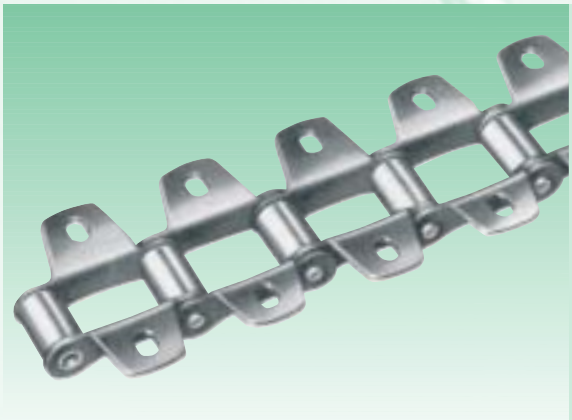
with Thermoplastic Bearings

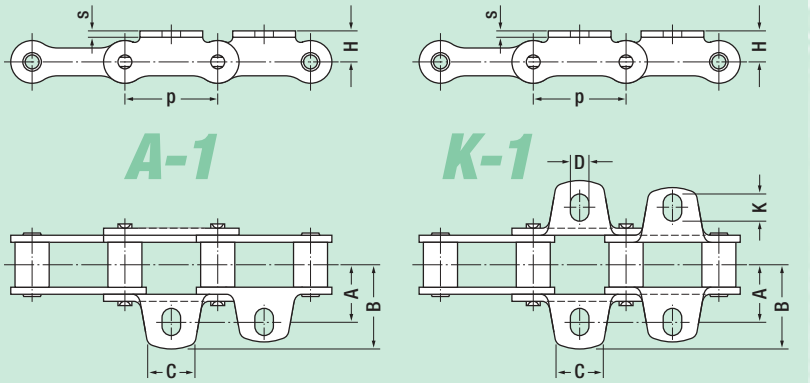
Chain Description		Pitch p		Roller Width	Roller Diameter	Pin Diameter	Inner Width	Linkplate Height	Pin Width	Overall Width	Bearing Area	Ultimate Strength	Weight	Loose Parts			
old	new	inch	mm	b_1 min. mm	d_1 max. mm	d_2 max. mm	b_2 max. mm	g max. mm	a_1 max. mm	a_3 max. mm	A cm^2	F_B N	≈ q kg/m	G	S	C	L
RLK 738 [1]	38.4 W GL KL [1]	1.50	38.4	19.05	15.88	6.93	24.2	17.0	32.8	30.5	1.66	23 600	1.63	●	●	●	●

[1] Chains with straight link plates

Agricultural Roller Chains

Bent Attachment Plates – Standard Type





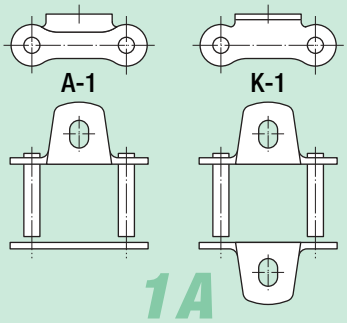
ISO 487/DIN 8189

Chain Description		Bent Attachment Plate No.		Pitch	Roller Width	Roller Diameter							
old	new	Exterior Angle	Interior Angle	p mm	b_1 min. mm	d_1 max. mm	A mm	B max. mm	H mm	C mm	D min. mm	K min. mm	s mm
RL 640	S 32 W	W 590		29.21	15.88	11.43	21.5	30.8	8.6	14.0	5.3	8.0	1.75
SK 742	S 45 W	W 720	W 723	41.4	22.23	15.24	27.0	37.1	11.4	20.0	8.3	11.5	2.6
RL 741	S 52 W	W 644	W 645	38.1	22.23	15.24	29.4	39.0	11.5	20.0	8.4	10.0	2.6
SK 744	S 55 W	W 720	W 723	41.4	22.23	17.78	27.0	37.1	11.5	20.0	8.3	11.5	2.6
RL 747	S 62 W	W 796	W 797	41.91	25.4	19.05	33.4	47.7	11.4	22.0	8.3	8.3	2.5
RL 942	S 77	W 870	W 873	58.34	22.23	18.26	38.1	50.8	20.8	26.0	8.6	12.5	4.0
RL 1042	S 88	W 930	W 933	66.27	28.58	22.86	48.4	59.7	20.8	32.0	8.6	11.2	4.0

Industry Standard

Chain Description		Bent Attachment Plate No.		Pitch	Roller Width	Roller Diameter							
old	new	Exterior Angle	Interior Angle	p mm	b_1 min. mm	d_1 max. mm	A mm	B max. mm	H mm	C mm	D min. mm	K min. mm	s mm
RL 738 [1]	38.4 W GL [1]	W 682		38.4	19.05	15.88	28.5	40.25	15.4	20.0	8.4	–	2.4
RL 753	S 55 SK8 H	W 810	–	41.4	20.5	15.88	28.0	43.75	13.0	40.0	8.5	–	2.9
RL 764	S 55 H	W 804		41.4	22.23	17.78	27.0	37.25	13.2	20.0	8.5	–	2.9
RL 765	S 55 SK7	W 804	–	41.4	20.0	16.0	27.0	37.25	13.2	20.0	8.5	–	2.9
RL 774 [1]	S 55 SK6 GL [1]	W 900		41.4	19.81	16.87	27.0	36.0	12.7	20.0	8.5	–	2.6

[1] Chains with straight link plates



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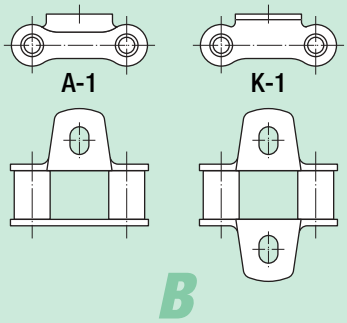
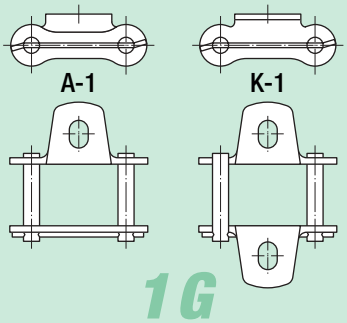


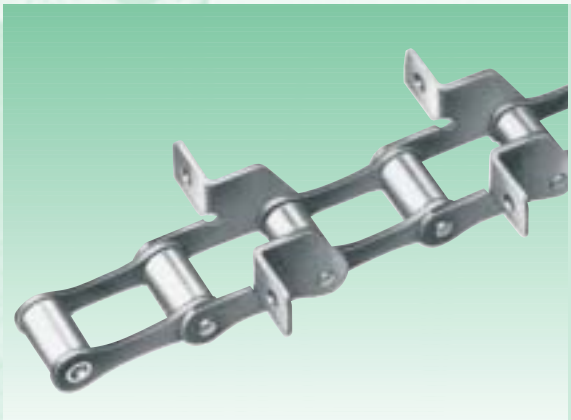
Roller Link

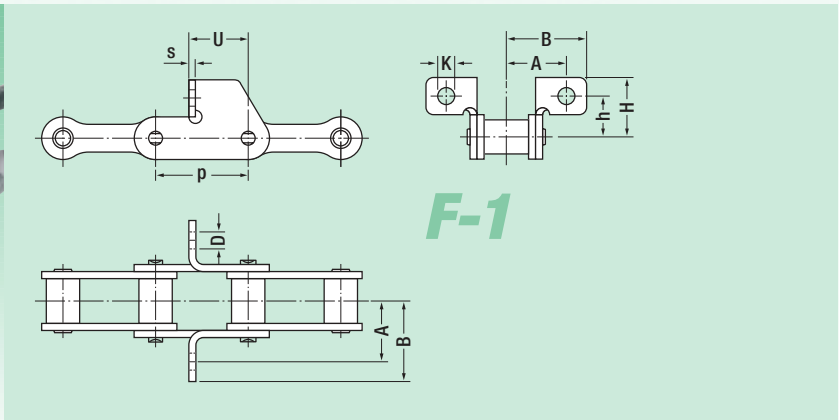


Connection link single wire

Agricultural Roller Chains

Front Bent Attachment – Standard Type





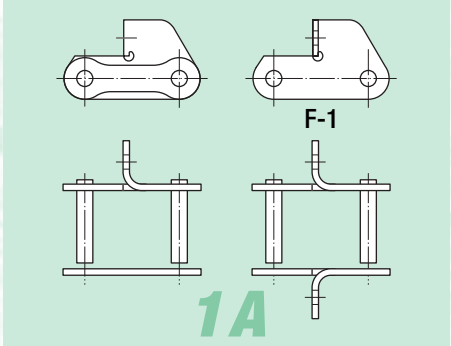
ISO 487/DIN 8189

Chain Description		Front Bent Attachment No.	Pitch	Roller Width	Roller Diameter							
old	new		p mm	b_1 min. mm	d_1 max. mm	A mm	B max. mm	H mm	h mm	D min. mm	K min. mm	s mm	U mm
SK 742	S 45 W	F 722	41.4	22.23	15.24	29.0	41.2	33.7	21.0	6.6	6.6	2.5	28.6
RL 741	S 52 W	F 668	38.1	22.23	15.24	31.0	42.0	29.0	20.0	6.4	6.4	2.5	19.0
SK 744	S 55 W	F 722	41.4	22.23	17.78	29.0	41.2	33.7	21.0	6.6	6.6	2.5	28.6

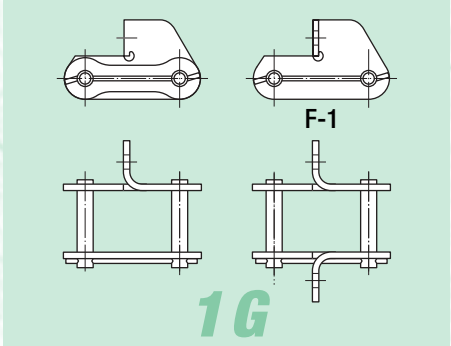
Industry Standard

Chain Description		Front Bent Attachment No.	Pitch	Roller Width	Roller Diameter							
old	new		p mm	b_1 min. mm	d_1 max. mm	A mm	B max. mm	H mm	h mm	D min. mm	K min. mm	s mm	U mm
RL 726	S 52 BK	F 668	38.1	15.88	15.24	27.3	38.3	29.0	20.0	6.4	6.4	2.5	19.0
RL 738 [1]	38.4 W GL [1]	F 648	38.4	19.05	15.88	26.0	36.0	33.0	24.0	8.6	8.6	2.4	37.4
SK 717 [1]	38.4 H GL [1]	F 616	38.4	19.0	15.88	26.0	36.0	36.75	24.0	8.4	8.4	2.9	38.7
RL 753	S 55 SK8 H	F 758	41.4	20.5	15.88	27.5	38.7	29.5	20.0	6.6	9.8	2.9	54.3

[1] Chains with straight link plates



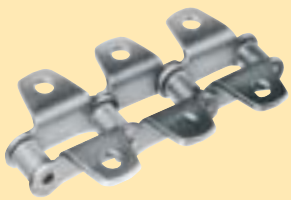
Pin Link

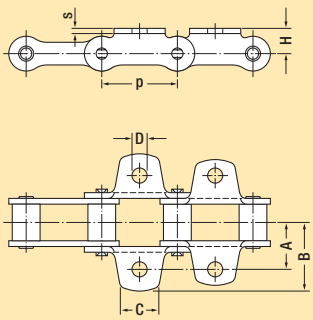


Connection link single wire

Agricultural Roller Chains
with Special Attachments

1



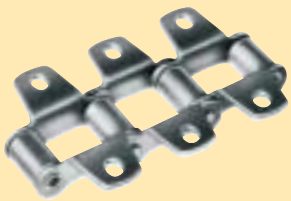


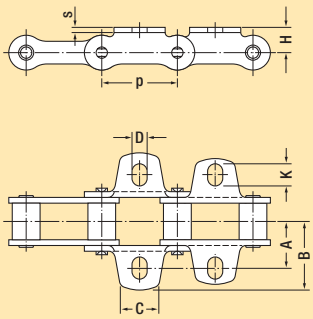
Chain Description (old) SK 742, SK 744

Chain Description (new) S 45 W, S 55 W

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	W 702	28.0	37.3	20.0	10.0	–	–	–	11.5	–	2.6

2



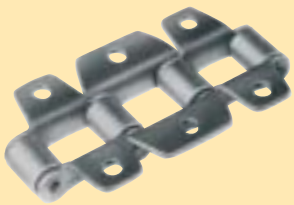


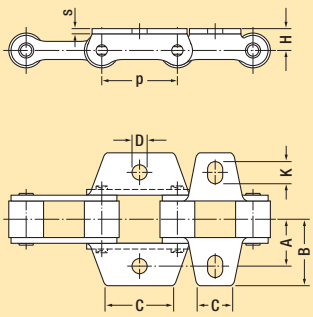
Chain Description (old) RL 741

Chain Description (new) S 52 W

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
38.1	W 670	29.4	38.8	20.0	6.5	–	–	–	11.5	8.2	2.6

3



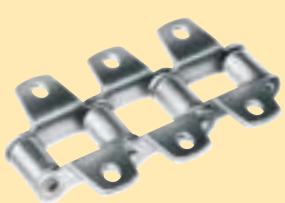


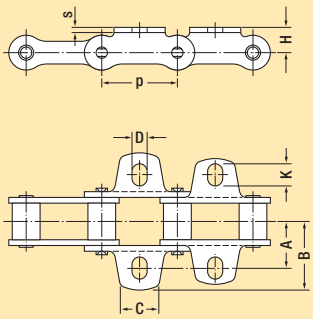
Chain Description (old) SK 742, SK 744

Chain Description (new) S 45 W, S 55 W

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	W 844	27.5	37.2	20.0	8.5	–	–	–	–	–	2.6
41.4	W 845 [1]	27.5	37.2	20.0	8.3	–	–	–	11.4	14.5	2.6

4





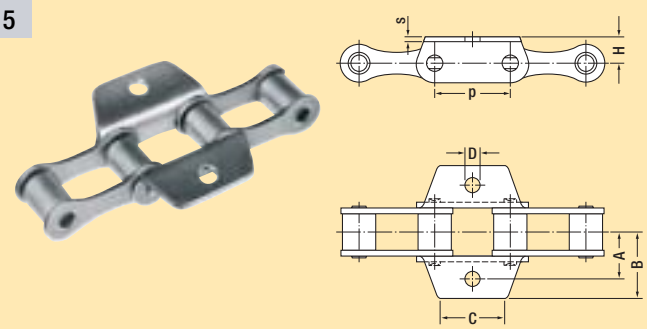
Chain Description (old) RL 726

Chain Description (new) S 52 BK

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
38.1	W 644	25.0	37.0	20.0	8.4	–	–	–	11.5	10.0	2.6
38.1	W 645 [1]	25.0	37.0	20.0	8.4	–	–	–	11.5	10.0	2.6
38.1	W 670	29.4	38.3	20.0	6.6	–	–	–	11.5	8.2	2.6

[1] interior angle

5

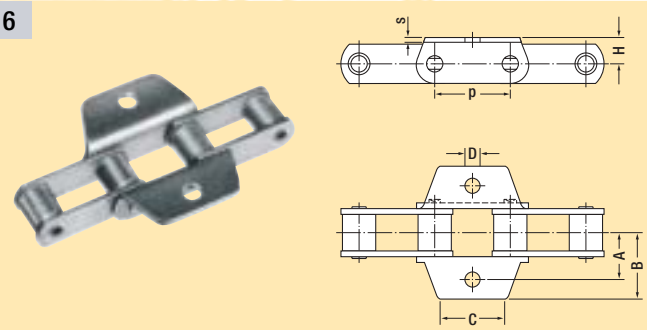


Chain Description (old) RL 764, RL 765

Chain Description (new) S 55 H, S 55 SK7

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	**W 816**	27.0	42.5	40.0	8.6	–	–	–	14.8	–	2.9

6



Chain Description (old) RL 738

Chain Description (new) 38.4 W GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
38.4	**W 652**	28.5	38.0	40.0	8.6	–	–	–	13.0	–	2.4
38.4	**W 908**	28.5	42.0	40.0	10.5	–	–	–	16.0	–	2.4

Chain Description (old) SK 717

Chain Description (new) 38.4 H GL

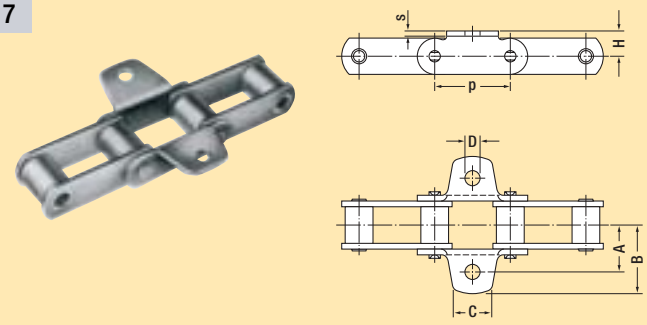
38.4	**W 824**	28.5	43.0	40.0	10.5	–	–	–	14.0	–	2.9

Chain Description (old) RL 766

Chain Description (new) S 55 SK2 GL

41.4	**W 816**	28.2	38.7	40.0	8.6	–	–	–	14.8	–	2.9

7

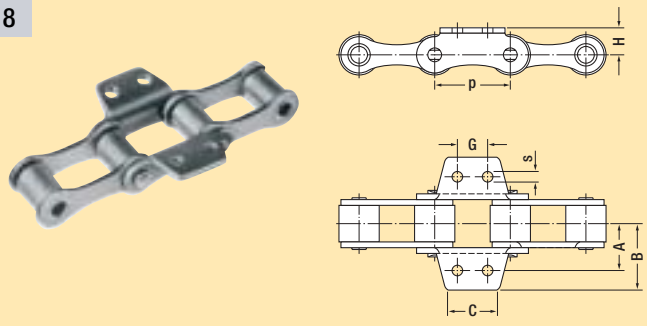


Chain Description (old) RL 738

Chain Description (new) 38.4 W GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
38.4	**W 672**	28.5	37.0	20.0	8.6	–	–	–	11.0	–	2.4
38.4	**W 680**	28.5	37.0	20.0	6.4	–	–	–	11.0	–	2.4

8

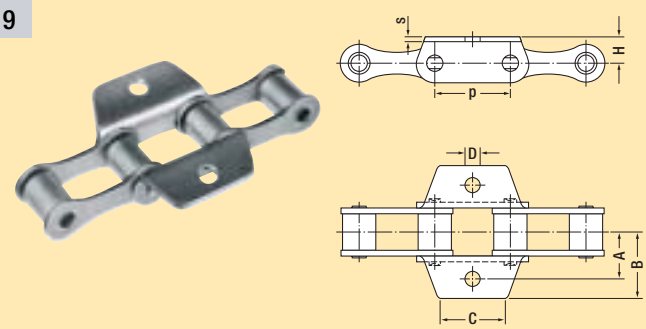


Chain Description (old) RL 753

Chain Description (new) S 55 SK8 H

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	**W 776**	26.5	35.5	25.4	6.2	–	18.0	–	12.8	–	2.9

9

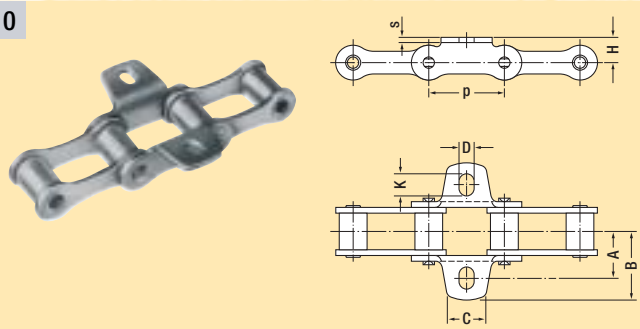


Chain Description (old) RL 753

Chain Description (new) S 55 SK8 H

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	**W 780**	30.0	42.5	41.3	8.5	–	–	–	15.0	–	2.9

10

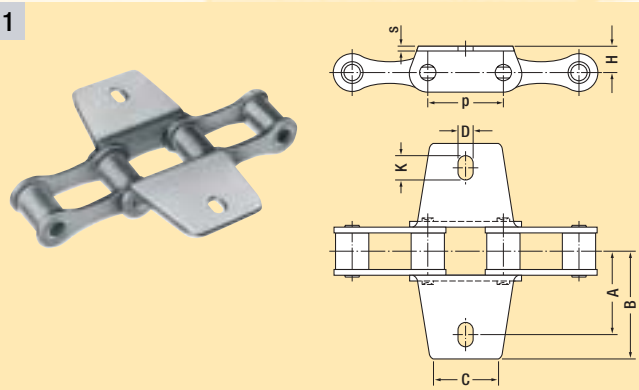


Chain Description (old) RL 753

Chain Description (new) S 55 SK8 H

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	**W 770**	27.5	39.5	22.0	6.8	–	–	–	15.0	10.0	2.9

11

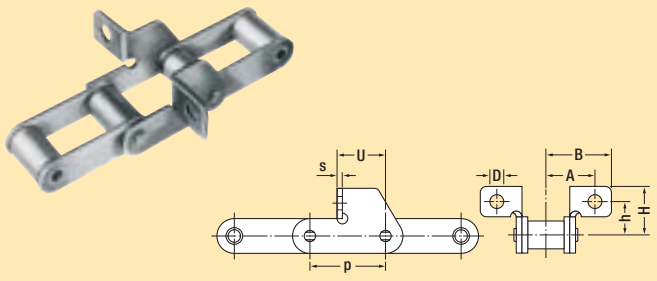


Chain Description (old) RL 753

Chain Description (new) S 55 SK8 H

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
41.4	**W 812**	55.0	70.0	40.0	11.2	–	–	–	15.0	20.2	2.9

12

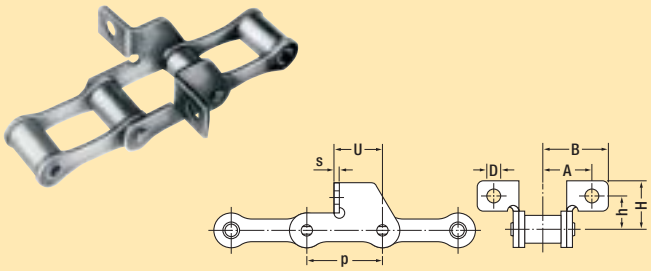


Chain Description (old) RL 738

Chain Description (new) 38.4 W GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	K	s
38.4	**F 688**	30.0	38.0	–	6.4	–	–	24.0	33.0	35.6	2.4

13

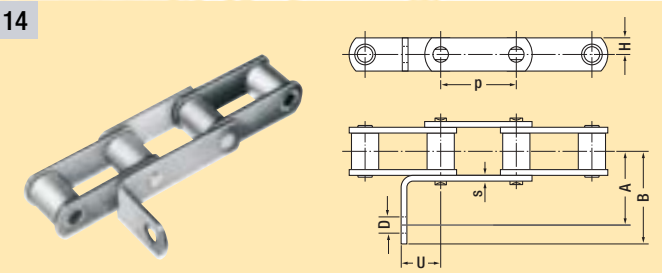


Chain Description (old) SK 742, SK 744

Chain Description (new) S 45 W, S 55 W

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	G	h	H	K	U	s
41.4	**F 728**	30.65	41.25	–	8.4	–	16.5	25.0	–	28.6	2.6
41.4	**F 738**	29.0	39.3	6.0	5.5	–	16.0	25.0	–	28.6	2.6

14

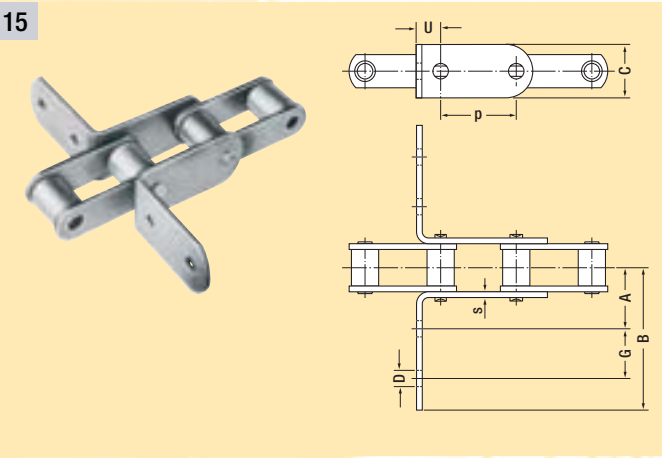


Chain Description (old) RL 738

Chain Description (new) 38.4 W GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	G	h	H	K	U	s
38.4	**F 696**	37.3	48.35	–	8.2	–	–	17.2	–	20.0	2.9

15

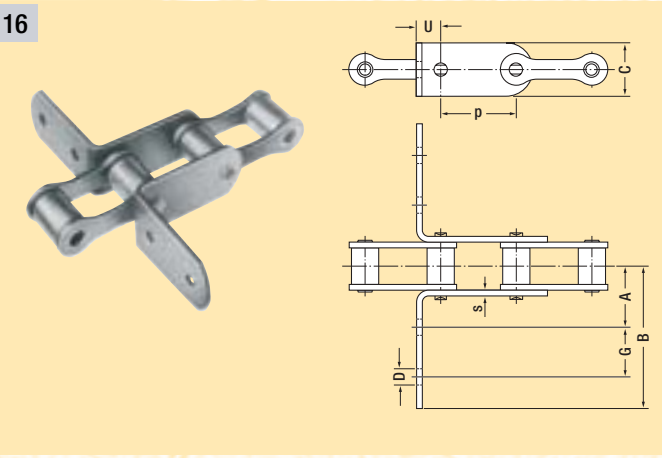


Chain Description (old) RL 738

Chain Description (new) 38.4 W GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	G	h	H	K	U	s
38.4	**F 850**	31.3	66.8	27.0	6.8	25.0	–	–	–	12.7	2.4

16

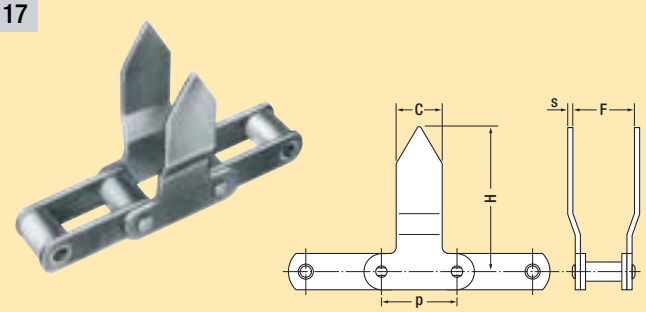


Chain Description (old) RL 764, RL 765

Chain Description (new) S 55 H, S 55 SK 7

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	G	h	H	K	U	s
41.4	**F 888**	32.0	74.0	30.0	6.5	30.0	–	–	–	13.5	2.9

17

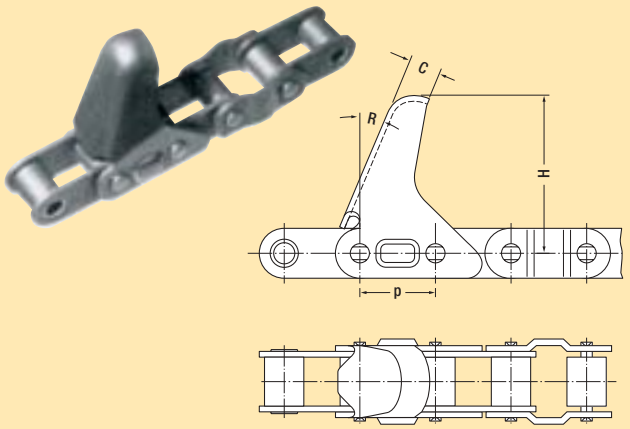


Chain Description (old) RL 738, RLK 738

Chain Description (new) 38.4 W GL, 38.4 W GL KL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	R	s
38.4	M 820	–	–	24.0	–	37.5	–	–	75.0	–	2.5

18

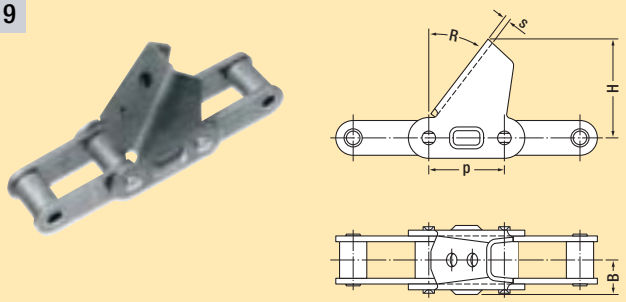


Chain Description (old) SK 627

Chain Description (new) 30-1 BG GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	R	s
30.0	U 698 K 328	–	–	–	14.0	–	–	–	63.0	22.5°	–

19

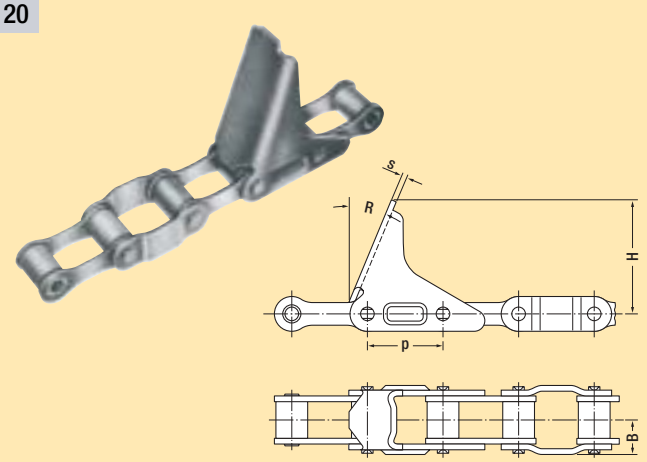


Chain Description (old) RL 766

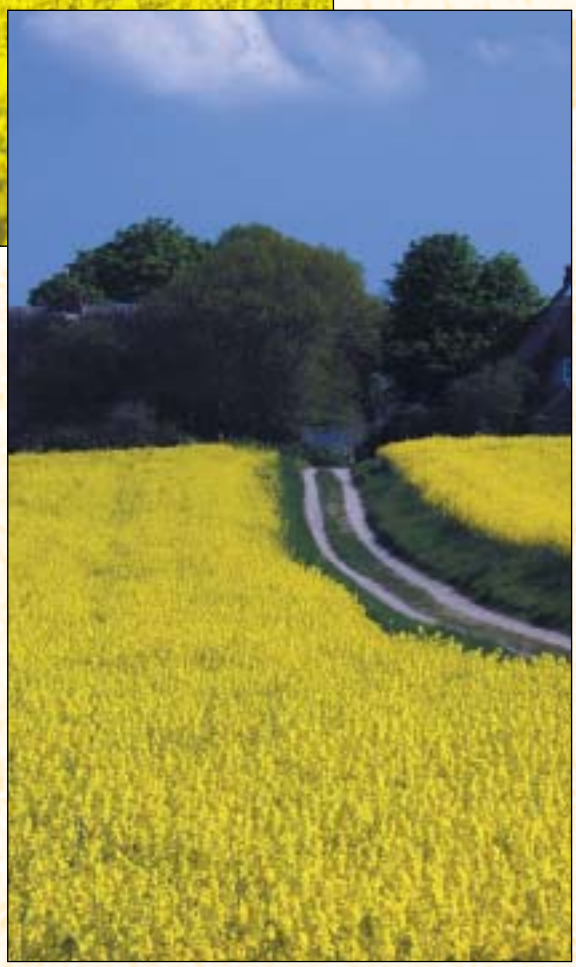
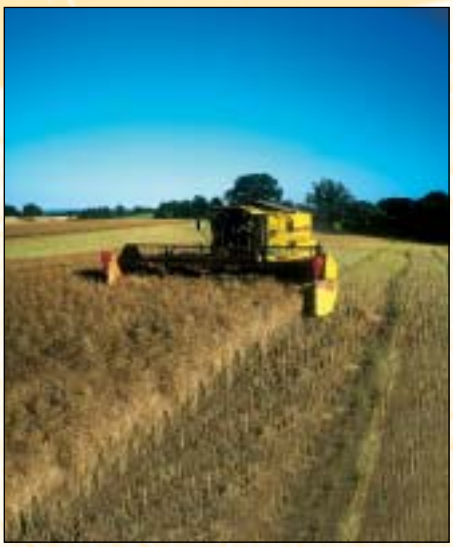
Chain Description (new) S 55 SK2 GL

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	R	s
41.4	U 173	–	–	–	–	–	–	–	55.0	37°	3.0

20



Chain Description (old) RL 764, RL 765

Chain Description (new) S 55 H, S 55 SK7

Pitch	Special Attachment No.	Dimensions in mm									
p		A	B	C	D	F	G	h	H	R	s
41.4	U 924	–	–	–	–	–	–	–	63.0	22.5°	3.0