

**BUREAU OF INDIAN STANDARDS****DRAFT FOR COMMENTS ONLY**

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*भारतीय मानक मसौदा*

**कन्वेयर चेन, चेन-पहिये और अटैचमेंट — विशिष्टि****भाग 3 अटैचमेंट**

[ आईएस 6834 (भाग 3) का पहला पुनरीक्षण ]

**DRAFT** *Indian Standard*

**CONVEYOR CHAINS, CHAIN-WHEELS AND  
ATTACHMENTS— SPECIFICATION****PART 3 ATTACHMENTS**

[*First Revision* of 6834 (Part 3)]

ICS 53.020.30

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Continuous Bulk Conveying, Elevating, Hoisting Aerial  
Ropeways and Related Equipment Sectional Committee, MED 06

Last date for receipt of comments  
is **31 August 2024**

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**FOREWORD**

*(Formal clause to be added later)*

This Indian standard (Part 3) was first published in 1976.

This revision has been taken up to keep pace with the latest technological developments and the practices followed in conveyor industry and the standard has been brought into the latest style and format of Indian Standards. This revision incorporates the following major changes:

- a) A reference clause has been added mentioning the latest version of all the referred standards;
- b) Editorial changes have been made;
- c) Marking clause has been added.

The specification for conveyor chains, chain-wheels and attachments is in three parts. This standard (Part 3) covers the chain-wheels. Other parts in this series under the general title are as follows:

Part 1 Chain

Part 2Chain – Wheels

The composition of the Committee responsible for the formulation of this standard is given at (*to be added later*).

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2:2022 ‘Rules for rounding off numerical values (*second revision*)’. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

**DRAFT Indian Standard****CONVEYOR CHAINS, CHAIN-WHEELS AND  
ATTACHMENTS — SPECIFICATION****PART 3 ATTACHMENTS***(First Revision)***1 SCOPE**

This standard covers the requirements for *K* attachments and deep plate attachments for use with conveyor chains and chain-wheels.

**2 REFERENCES**

The standard listed below contains provision, which through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standard listed below:

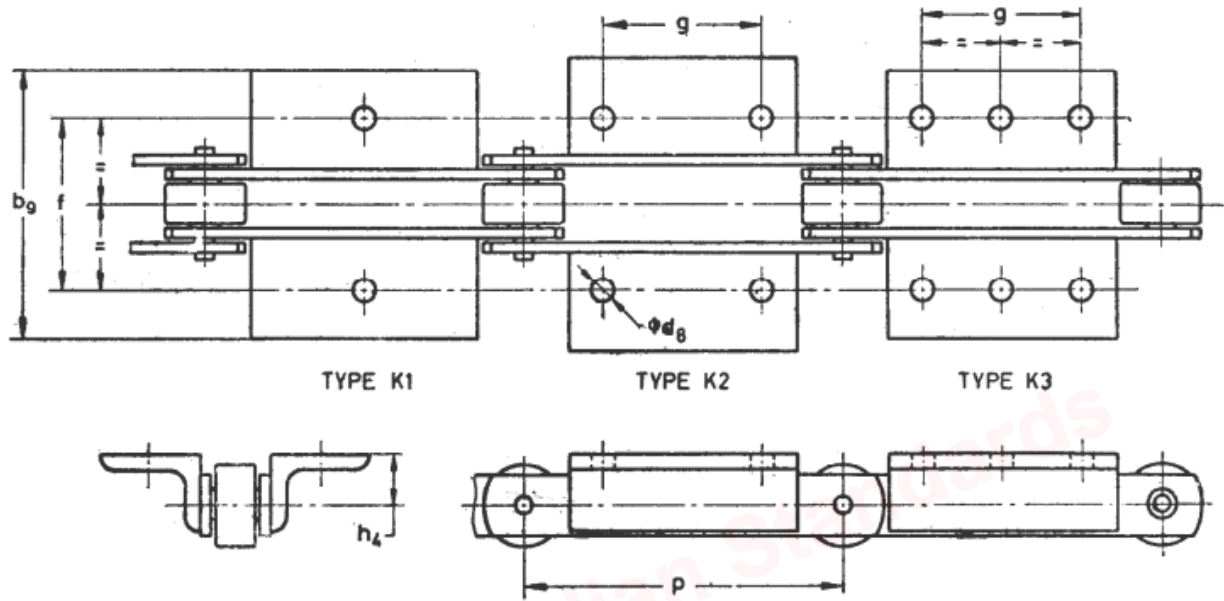
<i>IS No.</i>	<i>IS Title</i>
IS 2062: 2011	Hot rolled medium and high tensile structural steel - Specification (Seventh Revision)

**3 TYPES**

The *K* attachment shall be of the following three types:

- a) *K1* Attachment – With one attachment hole centrally disposed in each plate.
- b) *K2* Attachment – With two attachment holes disposed in each plate as shown in figure in **4.1**.
- c) *K3* Attachment – As *K2* but with a third hole centrally positioned between the other two.

**4 DIMENSIONS****4.1 *K* Attachments**

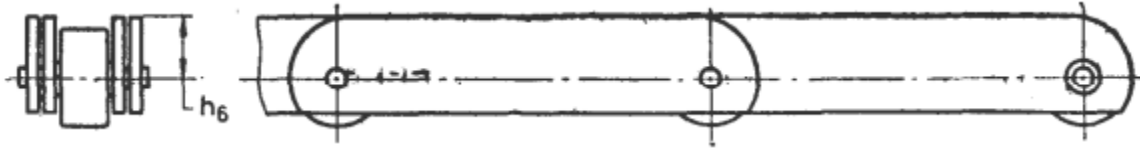


All dimensions in millimetres.

Sl No.	Chain Number	Hole Diameter	Platform Height	Transverse Distance Between Hole Centres	Width Over Attachments $b_2$ (Max)	Longitudinal Distance Between Hole Centres					
						Short		Medium		Long	
						$p_{Min}^*$	$g$	$p_{Min}^*$	$g$	$p_{Min}^*$	$g$
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)
i)	M20	6.6	16	54	84	63	20	80	35	100	50
ii)	M28	9.0	20	64	100	80	25	100	40	125	65
iii)	M40	9.0	25	70	112	80	20	100	40	125	65
iv)	M56	11.0	30	88	140	100	25	125	50	160	85
v)	M80	11.0	35	96	160	125	50	160	85	200	125
vi)	M112	14.0	40	110	184	125	35	160	65	200	100
vii)	M160	14.0	45	124	200	160	50	200	85	250	145
viii)	M224	18.0	55	140	228	200	65	250	125	315	190
ix)	M315	18.0	65	160	250	200	50	250	100	315	155
x)	M450	18.0	75	180	280	250	85	315	155	400	240
xi)	M630	24.0	90	230	380	315	100	400	190	500	300
xii)	M900	30.0	110	280	480	315	65	400	155	500	240
xiii)	MC28	9.0	25	70	112	80	20	100	40	125	65
xiv)	MC56	11.0	35	88	152	125	50	160	85	200	125
xv)	MC112	14.0	45	110	192	160	50	200	85	250	145
xvi)	MC224	18.0	65	140	220	200	50	250	100	315	155

Note - \*Minimum chain pitch for  $g$ .

## 4.2 Deep Plates



All dimensions in millimetres.

Sl No.	Chain Number	M 20	M28	M40	M 56	M80	M 112	M 160	M 224	M 315	M 450	M 630	M 900	MC 28	MC 56	MC 112	MC 224
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)	(14)	(15)	(16)	(17)	(18)
i)	Plate Height $h^6$	16	20	22.5	30	32.5	40	45	60	65	80	90	120	22.5	32.5	45	65

## 5 MATERIAL

The attachments may be manufactured from angle type rolled steel conforming to IS 2062.

## 6 REQUIREMENT

### 6.1 K Attachment

**6.1.1** The attachments are illustrated as being manufactured from rolled steel angle section fastened to the chain plates but actual construction is at the discretion of the manufacturer and may include integral chain plates bent over to form the platform, or fabricated construction.

**6.1.2** The length of the attachment shall be at the discretion of the manufacturer but shall be sufficient to accommodate the attachment holes of the K2 attachments.

**6.1.3** Attachments may be fitted on one or both sides of the chain.

### 6.2 Deep Plates

The requirements, including the chain breaking strength, shall be the same as those for basic chain plates.

## 7 PRESERVATION

When the attachments are to be used in atmospheres corrosive in nature, suitable anti-corrosive coating shall be employed.

## 8 MARKING

**8.1** The attachment shall be marked with manufacturer's name and/or trade-mark, the type of attachment and the appropriate chain number for which the attachment is suitable.

### 8.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the standard mark.

(MED 06)