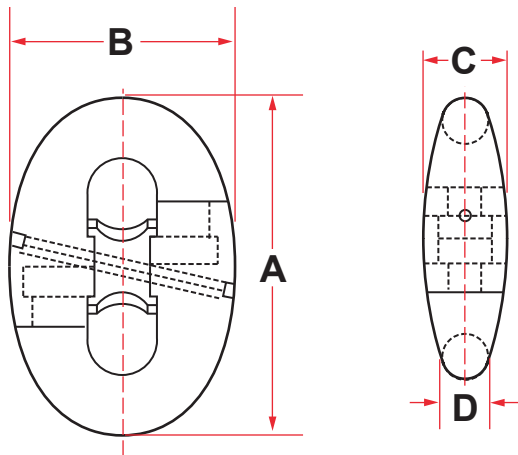




FITTINGS



KENTER JOINING SHACKLE



GRADE 3

FITTINGS

NOMINAL DIAMETER D		A (MM)	B (MM)	C (MM)	WEIGHT		PROOF TEST KGF	BREAK TEST KGF
MM	INCHES				KG.	LBS.		
16	5/8	96	67	24	0.57	1.25	15100	21600
19	3/4	120	84	30.5	1.09	2.40	21600	30900
22	7/8	134	93	33	1.75	3.8	29300	41700
24	15/16	144	101	36	2.1	4.6	34000	48500
25	1	152	107	38	2.5	4.8	38000	54300
29	1-1/18	174	122	44	4.8	10.5	49200	70400
32	1-1/4	192	134	49	5.0	11.0	59500	84900
34	1-3/8	210	146	54	6.5	14.3	70400	100900
36	1-7/16	216	151	55	8.0	17.6	76700	109400
38	1-1/2	228	160	58	9.0	19.8	83300	118900
42	1-5/8	252	176	64	12.0	26.5	102000	143400
44	1-3/4	264	185	67	14.0	30.9	111900	159900
46	1-13/16	276	193	70	15.0	33.1	119800	171100
48	1-7/8	288	202	73	18.0	39.7	130000	185100
51	2	306	214	78	21.0	46.3	145400	207700
54	2-1/8	324	227	82	24.0	52.9	162000	231500
56	2-3/16	336	235	85	26.0	57.3	174000	248000
58	2-1/4	348	244	88	31.0	68.3	185400	265000
60	2-3/8	360	252	91	34.0	75.0	199600	285200
62	2-7/16	372	260	94	36.0	79.4	210000	300000
64	2-1/2	384	269	97	38.0	83.8	223000	319000
67	2-5/8	402	281	102	41.0	90.4	242900	347000
70	2-3/4	420	294	106	52.4	115.7	263500	376400
73	2-7/8	438	307	111	60.0	132.3	285000	407000
76	3	456	319	116	70.0	154.3	308200	440200
78	3-1/16	468	328	119	71.0	156.5	322000	459000
84	3-5/16	504	353	128	92.0	202.8	369300	527600
87	3-7/16	522	365	132	103.0	227.1	395100	564300
89	3-1/2	534	374	135	113.0	249.1	409000	584300
92	3-5/8	552	386	140	115.0	253.5	434800	621200
95	3-3/4	570	399	144	132.0	291.0	462300	660100
102	4	612	428	155	163.0	359.4	522100	746000
108	4-1/4	648	454	164	196.0	432.1	577000	825000
111	4-3/8	666	466	169	213.0	469.6	607000	867200
114	4-1/2	684	479	173	233.0	513.7	637300	910900

To convert to lbs., multiply by 2.2046



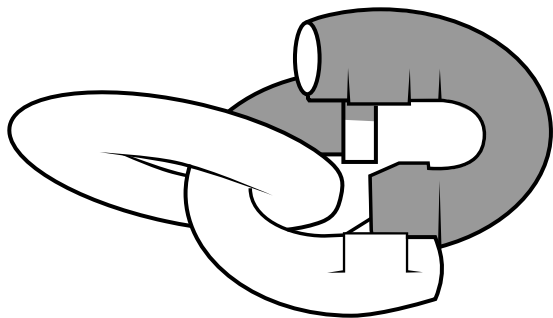
KENTER JOINING LINK ASSEMBLY

The Kenter-type joining link contains three parts plus taper pin and lead plug. The two main halves have numbers to be matched and arrows to be lined up for ease of assembly with the third piece (stud). The two main parts are attached to the ends of the chain in a vertical position and then fitted together (1), and the stud is then slid into place (2), which locks the link. The stud is secured by hammering a tapered pin into the hole drilled diagonally (3) through all three parts of the joining link. This hole is tapered, and when the pin is driven home, a small conical recess (called the "dovetail chamber") is left clear above its head. A lead pellet is hammered broad end first into this chamber (4) so as to fill it completely and thereby keep the pin in place. Precaution

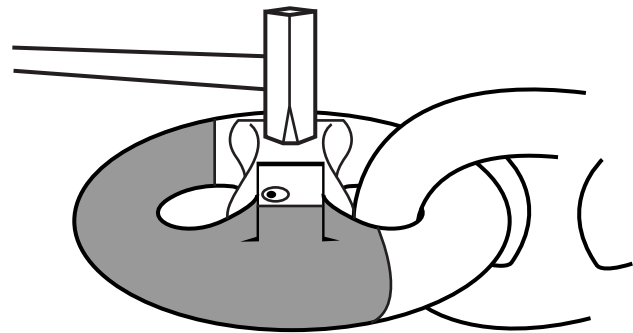
must be used to prevent flat, small pieces of lead from flying off the joining link into the face or eyes.

Prior to assembly, the internal mating surfaces should be coated with molybdenum disulphide grease (MIL-G-23529) or an equivalent lithium based grease. When assembling and before inserting the new lead, any remaining lead must be reamed out.

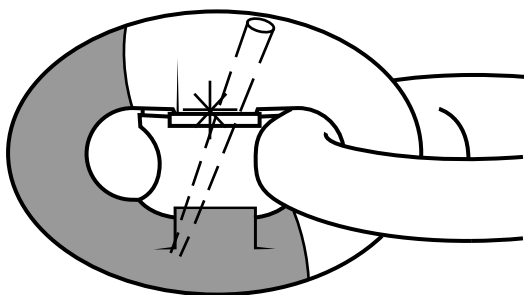
When disassembling, the locking pin is driven out with a "drift." To part the link, a top swage (shaped to the curvature of the link) must always be used between the hammer and link so as to avoid damaging the machined surfaces.



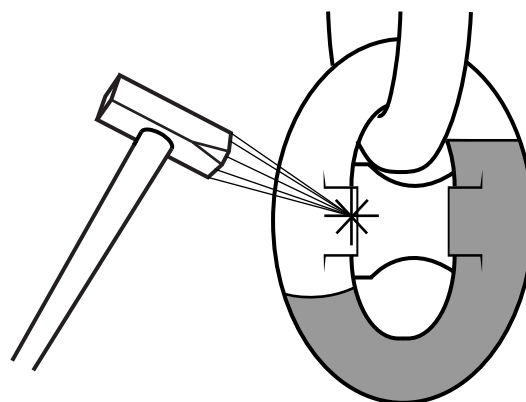
(1) After inserting the first half of the link through chain, the other link is inserted in the other and driven together.



(2) The center stud is inserted.



(3) When the center chock is in correct position the taper pin can with out a hammer be inserted as shown on the figure which also shows the center chock in correct postion.



(4) The taper pin is driven in and is secured by the lead pellet which is inserted into place with a hammer.

FITTINGS