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Other materials and methods have been used to manufacture the rivetless chain. However, this standard is promulgated for the Drop Forged type of heat-treated medium carbon steel chain in the sizes that comprise the vast majority of use. Cast or fabricated chains of alloys or stainless steel are not considered.

Particularly worthy of note is the actual and reference pitch of these chains. Rivetless chains, in general, are a slight degree longer than reference pitch. This allows the use of ANSI and ISO standard roller chains in combination with attached “dogs” to act as drives. According to the experienced estimate of the subcommittee members, roller chain/dog drives are used with more than half the drop forged rivetless chain systems in existence. Use of these drives permits systems of unlimited length.

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TABLE 3 X-TYPE DROP FORGED RIVETLESS CHAIN
General Chain Dimensions, Minimum Ultimate Strength Rating, Strand Length, and Measuring
Load for Checking Chain Lengths

Chain No.	Dimensions, in. (mm)							
	X228 (X50-6)		X348 (X75-13)		X458 (X100-16)		X678 (X150-22)	
	in.	(mm)	in.	(mm)	in.	(mm)	in.	(mm)
Reference pitch	2	(50)	3	(75)	4	(100)	6	(150)
P	2.010	(51.5)	3.015	(76.6)	4.031	(102.4)	6.031	(153.2)
B – Min.	0.31	(7.9)	0.53	(13.5)	0.66	(16.8)	0.95	(24.1)
D	0.25	(6.4)	0.49	(12.4)	0.63	(16.0)	0.87	(22.1)
F – Max.	0.71	(18.0)	1.10	(27.9)	1.44	(36.6)	2.03	(51.6)
L – Max.	1.09	(27.7)	1.73	(43.9)	2.25	(57.2)	3.03	(77.0)
T	0.25	(6.4)	0.40	(10.2)	0.48	(12.2)	0.70	(17.8)
X	0.47	(11.9)	0.74	(18.8)	1.00	(25.4)	1.28	(32.5)
X_a	0.37	(9.4)	0.51	(13.0)	0.64	(16.3)	0.83	(21.1)
Z	0.51	(13.0)	0.79	(20.1)	1.07	(27.2)	1.35	(34.3)
Minimum ultimate tensile strength, lb (kN)	6,000	(27)	22,000	(98)	42,000	(187)	72,000	(320)
No. of chain pitches in standard measuring length	60	(60)	40	(40)	30	(30)	20	(20)
Standard measuring length								
Max.	121.85	(3095.0)	121.85	(3095.0)	121.68	(3090.7)	121.37	(3082.8)
Min.	120.10	(3050.5)	120.10	(3050.5)	120.43	(3058.9)	120.37	(3057.4)
Measuring load, lb (kN)	100	(0.4)	100	(0.4)	200	(0.9)	300	(1.3)

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Reference pitch	2	(50)	3	(75)	4	(100)	6	(150)
P	2.010	(51.5)	3.015	(76.6)	4.031	(102.4)	6.031	(153.2)
B – Min.	0.31	(7.9)	0.53	(13.5)	0.66	(16.8)	0.95	(24.1)
D	0.25	(6.4)	0.49	(12.4)	0.63	(16.0)	0.87	(22.1)
F – Max.	0.71	(18.0)	1.10	(27.9)	1.44	(36.6)	2.03	(51.6)
L – Max.	1.09	(27.7)	1.73	(43.9)	2.25	(57.2)	3.03	(77.0)
T	0.25	(6.4)	0.40	(10.2)	0.48	(12.2)	0.70	(17.8)
X	0.47	(11.9)	0.74	(18.8)	1.00	(25.4)	1.28	(32.5)
X_a	0.37	(9.4)	0.51	(13.0)	0.64	(16.3)	0.83	(21.1)
Z	0.51	(13.0)	0.79	(20.1)	1.07	(27.2)	1.35	(34.3)
Minimum ultimate tensile strength, lb (kN)	6,000	(27)	22,000	(98)	42,000	(187)	72,000	(320)
No. of chain pitches in standard measuring length	60	(60)	40	(40)	30	(30)	20	(20)
Standard measuring length								
Max.	121.85	(3095.0)	121.85	(3095.0)	121.68	(3090.7)	121.37	(3082.8)
Min.	120.10	(3050.5)	120.10	(3050.5)	120.43	(3058.9)	120.37	(3057.4)
Measuring load, lb (kN)	100	(0.4)	100	(0.4)	200	(0.9)	300	(1.3)

CAUTION: The numerical values in this table must be read in conjunction with the definition and explanatory note appearing in Section 6, "Dimensions for Chain Links." The M.U.T.S. values do not provide a sufficient or appropriate basis for determining chain application.

TABLE 3 X-TYPE DROP FORGED RIVETLESS CHAIN
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Load for Checking Chain Lengths

Chain No.	Dimensions, in. (mm)							
	X228 (X50-6)		X348 (X75-13)		X458 (X100-16)		X678 (X150-22)	
	in.	(mm)	in.	(mm)	in.	(mm)	in.	(mm)
Reference pitch	2	(50)	3	(75)	4	(100)	6	(150)
P	2.010	(51.5)	3.015	(76.6)	4.031	(102.4)	6.031	(153.2)
B – Min.	0.31	(7.9)	0.53	(13.5)	0.66	(16.8)	0.95	(24.1)
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