

INCH-POUND

MIL-STD-627A  
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6 September 1962

MILITARY STANDARD  
SPROCKET WHEELS  
FOR  
POWER TRANSMISSION  
AND CONVEYING CHAINS



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## MIL-STD-627A

## FOREWORD

1. This military standard is approved for use by all Departments and Agencies of the Department of Defense.

2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, U.S. Army Missile Command, ATTN: AMSMI-RD-SE-TD-ST, Redstone Arsenal, AL 35898-5270 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

3. The production of sprockets is widespread throughout the United States among many chain and equipment manufacturers. Due to this widespread production, sprockets are produced in a variety of tooth profiles, body types, materials, and qualities.

4. Over the years there have been many schools of thought covering sprocket-tooth-profile design. As a result, standardization has been difficult and actually accomplished in only a few areas. It must be recognized that this is quite logical because each type or class of chain as well as application requirements has an effect upon a suitable functional design.

5. Each class of chain should have its sprocket design requirements separately discussed for proper understanding. Since the American National Standards Institute ANSIB29.1 is one of long standing and widely accepted for cut-tooth sprockets used with MIL-STD-421 and MIL-STD-423, it will be presented first on the following pages. This design is basically acceptable to cut-tooth sprockets and usually needs some modification before it can be used with other methods of manufacture.

6. The next type of sprocket-tooth profile that has been standardized by the American National Standards Institute is ANSIB29.2 for MIL-STD-425 chains. This standard is presented next after B29.1.

7. The most recent standardization of sprocket-tooth profiles appears in the American National Standards Institute ANSIB29.10. It specifically applies to MIL-STD-424 chains. The attachments often require clearance considerations not present on plain chains.

8. The tooth-profile design covered by the American National Standards Institute ANSIB29.10 is suitable for all methods of manufacture mentioned above and is adaptable for all classes of chains referenced on page 1 except for MIL-STD-425 chains which require their own unique tooth profile.

9. Research and development is a continuing program and it is anticipated that further refinements of sprocket-tooth-profile designs will result.

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1. SCOPE

1.1 Scope. This is a design standard covering the various tooth forms for sprockets used with power transmission and conveyor chains adopted for standardization by the Military.

1.2 Application. The sprockets described by this standard shall be required on all new equipment where such sprockets are applicable. This standard does not apply to equipment already in the Military supply system except insofar as technical characteristics will permit in replacing existing sprockets with sprockets covered by this standard.

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## 2. APPLICABLE DOCUMENTS

2.1 Non-Government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

## AMERICAN NATIONAL STANDARDS INSTITUTE (ANSI)

ANSI B29.1	-	Precision Power Transmission Roller Chains, Attachments, and Sprockets
ANSI B29.2	-	Inverted Tooth (Silent) Chains and Sprockets
ANSI B29.4	-	Double-Pitch Conveyor Roller Chains, Attachments, and Sprockets
ANSI B29.10	-	Heavy Duty Offset Sidebar Power Transmission Roller Chains and Sprocket Chains

(Application for copies should be addressed to the American National Standards Institute, 1430 Broadway, New York, NY 10018-3308.)

(Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.2 Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

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3. DEFINITIONS

American National Standards Institute (ANSI) numbers referenced herein are based on chains covered by the B29 series.

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## 4. GENERAL REQUIREMENTS

4.1 Recycled, reclaimed, and virgin materials. Except when intended use of the sprocket wheel and its components will be jeopardized, reclaimed or recycled materials will be used.

4.2 Sprocket wheel types. Sprocket manufacturers have compiled lists of what is known as "standard sprockets." Such listings were compiled based on the type and design of sprockets more commonly used in this country. Manufacturer's production and listing of stock sprockets are further confined to the number of teeth on the sprocket depending on the length of chain pitch. Types I, II, and III, the three basic types, are arranged by their hub arrangement. In industry they are referred to as A, B, and C. Among the various types of special purpose sprockets are modifications of types I, II, and III.

4.2.1 Type I sprockets. Type I sprockets, sometimes called plate sprockets, do not have hubs. These sprockets are made from bar stock or hot-rolled steel plate and used for mounting on hubs or flanges. They are furnished solid or split and with or without drilled or tapped holes (see figure 1).



FIGURE 1. Type I

4.2.2 Type II sprockets. Type II sprockets have a hub on one side only. Small-diameter sprockets are usually furnished as type II. Type II sprockets are made of steel, fabricated either from bar stock, forgings, or hot-rolled plate with welded hub construction. Large diameter sprockets may be finished plate and welded hub construction or machined from gray iron castings (see figure 2).

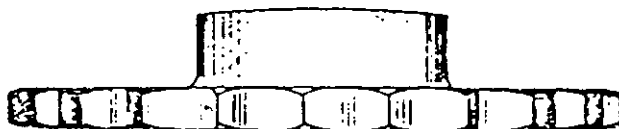


FIGURE 2. Type II.

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4.2.3. Type III sprockets. Type III sprockets have hubs on both sides. The hub projections are usually furnished equidistant from the centerline of the sprocket but may be offset if required. Large diameter sprockets are usually furnished as type III and may be made of gray iron, cast steel, or fabricated from hot-rolled plate with a hub welded to both sides. The type III hub arrangement provides stability and assures even stress distribution on shaft and key because the line of action due to chain pull reacts through the center of the hub (see figure 3).

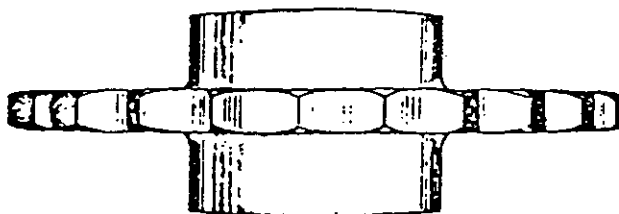


FIGURE 3. Type III.

4.2.4 Type IV sprockets. Type IV, multiple width sprockets, are provided for multiple width chains and have a row of teeth to engage each strand of chain. They are made in the same general design as single width sprockets. That is, smaller diameter sprockets are regularly furnished with hub on one side and the larger diameter sprockets are furnished with a hub on both sides (see figure 4).

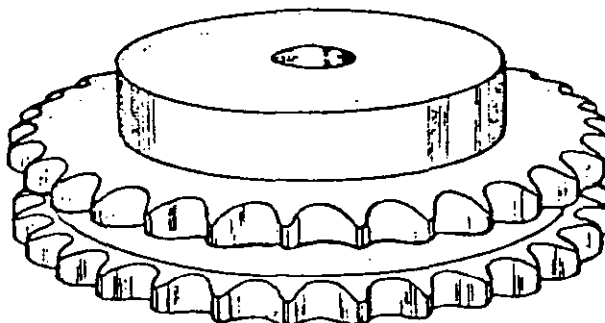


FIGURE 4. Type IV.

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4.2.5 Split-type sprockets. The split-type sprocket is a modified version of the type III sprocket. The sprocket shown in figure 5 is typical of the split type. Various other designs of this type are produced. The type shown in Figure 5 has a split hub and rim construction designed for bolting the two halves together on the shaft. The split-type sprocket lends itself to ease of installation and replacement of sprockets where accessibility is difficult.

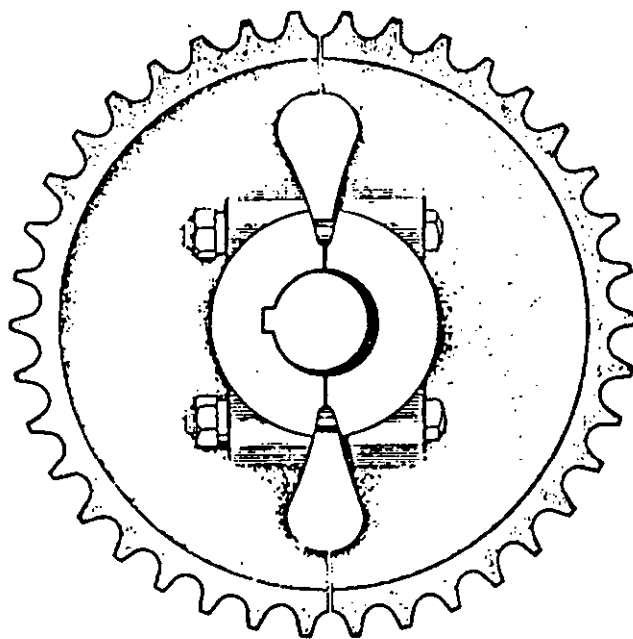


FIGURE 5. . Type V.

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4.2.6 Taper lock sprockets. Taper lock sprockets are used where a positive, full compression grip on the shaft is desired. These sprockets are provided in a range of sizes for single-strand and multiple-strand chains. Taper lock bushings are usually stocked in .0625 inch bore increments, complete with keyseats.

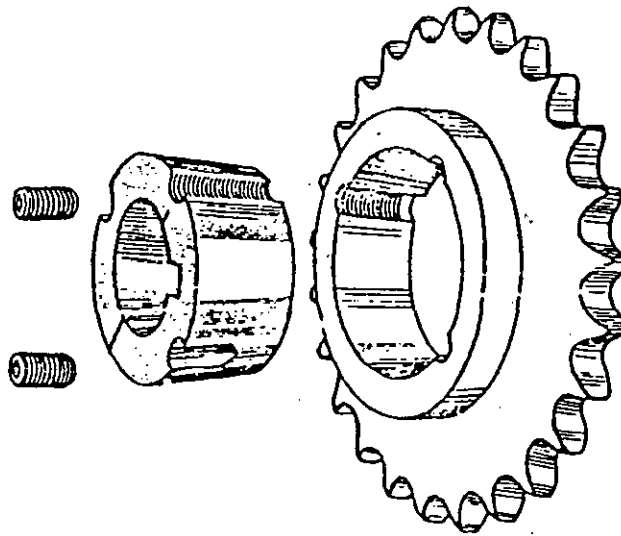


FIGURE 6. Type VI.



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4.2.7 Split-type sprocket or V-a. A split-type sprocket, also known as a double duty sprocket or type V-a, consists of a split plate. Type I, the plate sprocket, is split and drilled for bolting to a hub in two sections. Such sprockets lend themselves to ease of maintenance and permit drive ratio changes if necessary.

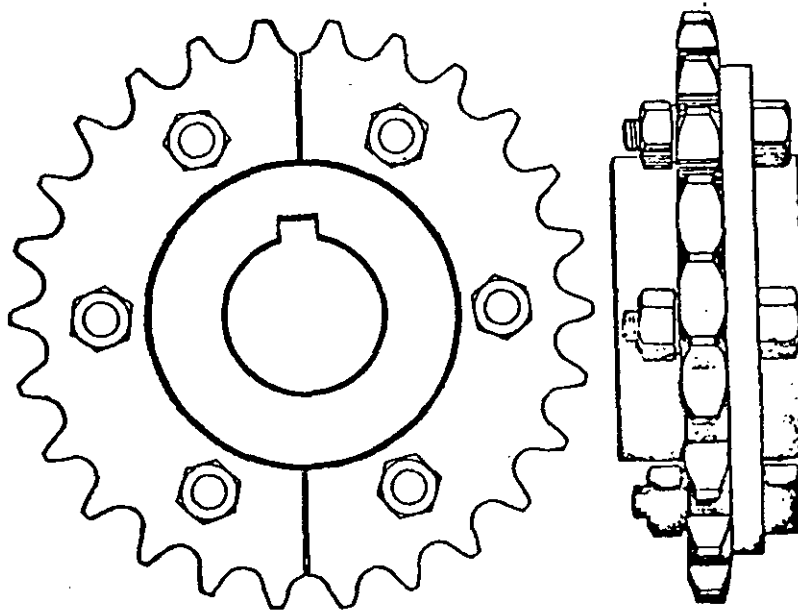


FIGURE 7. Type V-a double duty sprockets.

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## 5. DETAILED REQUIREMENTS

5.1 Diameters of sprocket wheels for roller chains.

5.1.1 Pitch diameter (PD). The pitch diameter is the diameter of the pitch circle that passes through the centers of the link pins as the chain is wrapped on the sprocket (see figure 8). Since the chain pitch is measured on a straight line between centers of adjacent pins, the chain pitch lines form a series of chords of the pitch circle. The PD is computed as follows:

$$PD = \frac{P}{\sin \left( \frac{180^\circ}{N} \right)}$$

P	=	Chain Pitch	D	=	Roller Diameter
PD	=	Pitch Diameter	N	=	Number of Teeth

5.1.2 Bottom diameter (BD). The bottom diameter (BD) is the diameter of a circle tangent to the curve (called the seating curve) at the bottom of the tooth gap. To permit the chain roller centers to follow the sprocket pitch circle, the bottom diameter must be:

$$BD = PD - D$$

5.1.3 Caliper diameter (CD). The caliper diameter (CD) is used as a quality control method to check the precision to which the bottom diameter has been cut. For a sprocket with an even number of teeth, the caliper diameter is the distance measured by calipers across the bottoms of seating curves of the two opposite tooth gaps and is equal to the bottom diameter.

With an odd number of teeth no two tooth gaps are diametrically opposite, and the caliper diameter is not a true diameter. However, its value for a given odd-tooth sprocket is computed as follows:

$$CD = PD \left( \cos \frac{90^\circ}{N} \right) - D$$

Tolerances on caliper diameter of sprockets:

Plus tolerance = 0.000  
 Minus tolerance =  $0.001P \sqrt{N} + 0.003$

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5.1.4 Outside diameter (OD). The outside diameter is the diameter over the tips of the teeth and is computed as follows:

$$OD = P \left( 0.6 + \cot \frac{180^\circ}{N} \right)$$

5.1.5 Maximum hub and groove diameter (MHD). Maximum hub and groove diameter is to insure clearance for link plates and is computed as follows:

$$MHD = P \left( \cot \frac{180^\circ}{N} - 1 \right) - 0.030$$

$$H \cong \sqrt{F^2 - \left( 1.4D - \frac{P}{2} \right)^2}$$

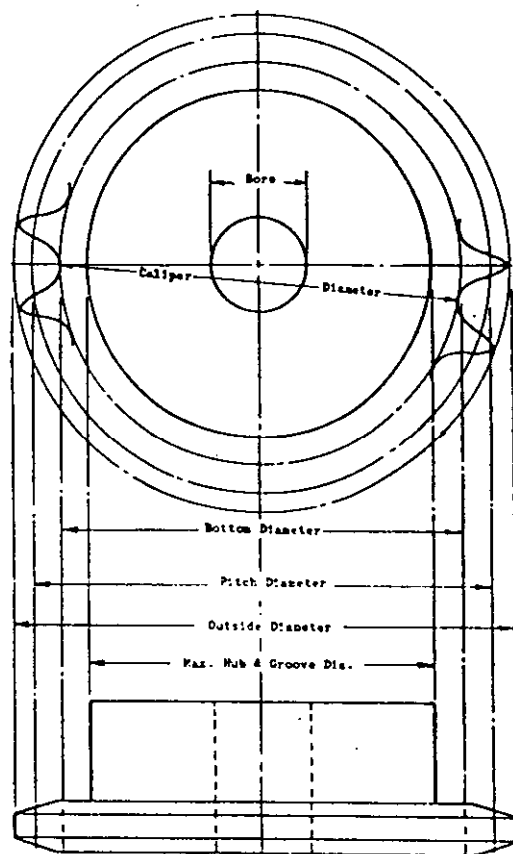


FIGURE 8. Diameters.

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5.2 Sprocket tooth form. The drawing of the sprocket tooth form shown in figure 9 is based on the following data and dimensions (inches).

Chain Pitch (P) = 2.00                      Roller Diameter (D) = 1.125

Seating Curve Diameter (Ds) = 1.134                      R = 0.567

Pitch Diameter (PD) = 6.472                      Pitch Radius (PR) = 3.236

Bottom (Root) Diameter = 5.347                      Number of Teeth (N) = 10

Construction Circles Radius (CCR) =  $3.236 + \frac{(1.134 - 1.125)}{2} = 3.2405$

Angle  $\frac{180^\circ}{10} = 18^\circ$                       Angle  $\frac{360^\circ}{10} = 36^\circ$                       Angle A =  $41^\circ$

Angle B =  $12^\circ 24'$                       Pressure Angle for a new chain =  $23^\circ$

Minimum Pressure Angle =  $10^\circ 36'$

Average Pressure Angle =  $16^\circ 48'$

M = 0.679                      T = 0.590                      V = 0.487                      S = 1.189

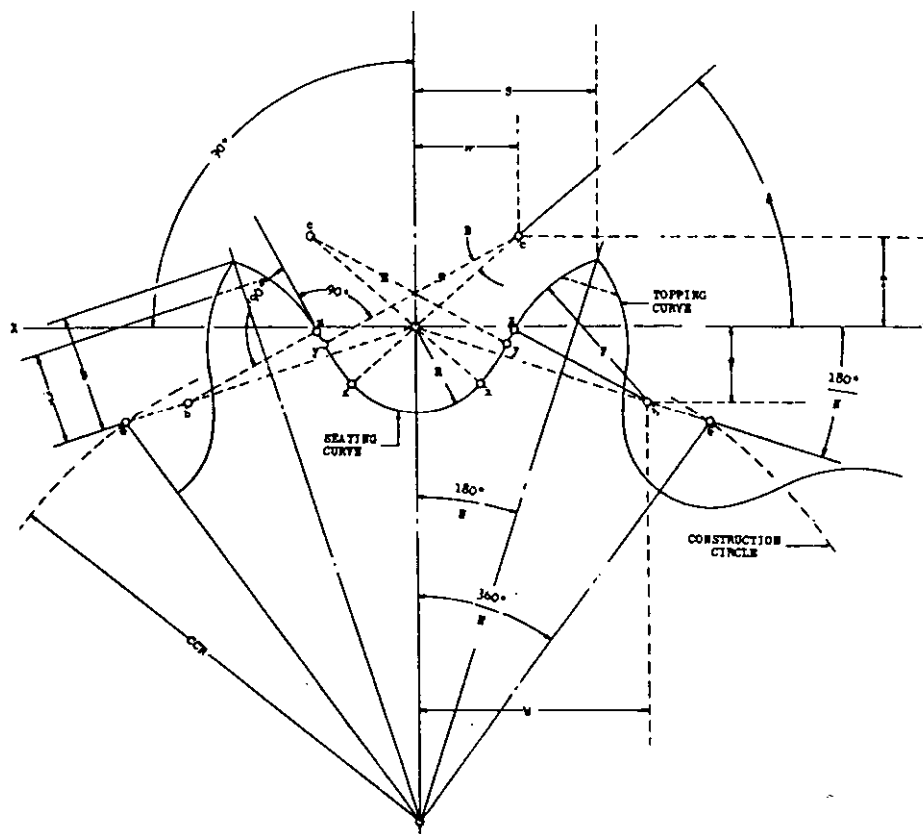
W = 1.498                      a to c = 0.900                      E = c to y = 1.467

x to y = 0.317                      y to z = 0.097                      a to b = 1.575

F = 0.960                      H = 0.769                      J = 0.60

OD (pointed teeth) = 7.701                      OD (truncated teeth) = 7.355

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FIGURE 9. Tooth form.

5.3 Tooth form and dimensions. The dimensions and angles of the tooth shown in figure 9 were determined according to the following formulas.

$$D_s = \text{Seating curve diameter} = 1.005D + 0.003$$

$$R = \frac{D_s}{2} = 0.5025D + 0.0015$$

Tolerance on  $D_s$  is all plus and equal to  $0.003D + 0.005$ .

Points a and e are located on the construction circle.

a to e may be assumed to equal pitch of chain.

Points a and e are the center of the seating curve radius,  $R$ .

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$$\text{Angle A} = 35^\circ + \frac{60^\circ}{N}$$

$$a \text{ to } c = 0.8D$$

$$\text{Angle B} = 18^\circ - \frac{56^\circ}{N}$$

$$\text{Distance E from c to y} = 1.3025D + 0.0015$$

$$\text{Chord of arc x to y} = (2.605D + 0.003) \sin \left( 9^\circ - \frac{28^\circ}{N} \right)$$

yz is a straight line tangent to the working curve xy and the topping curve.

$$y \text{ to } z = D \left[ 1.4 \sin \left( 17^\circ - \frac{64^\circ}{N} \right) - 0.8 \sin \left( 18^\circ - \frac{56^\circ}{N} \right) \right]$$

Point b lies on the chordal pitch line (a-e) which makes an angle with the line xy of  $\frac{180^\circ}{N}$ .

$$a \text{ to } b = 1.4D$$

Line zb is parallel to line cy

$$M = 0.8D \cos \left( 35^\circ + \frac{60^\circ}{N} \right)$$

$$T = 0.8D \sin \left( 35^\circ + \frac{60^\circ}{N} \right)$$

$$W = 1.4D \cos \frac{180^\circ}{N}$$

$$V = 1.4D \sin \frac{180^\circ}{N}$$

$$F = D \left[ 0.8 \cos \left( 18^\circ - \frac{56^\circ}{N} \right) + 1.4 \cos \left( 17^\circ - \frac{64^\circ}{N} \right) - 1.3025 - 0.0015 \right]$$

$$H = \frac{P^2}{2} - 1.4D - \frac{P}{2}$$

$$S = \frac{P}{2} \cos \frac{180^\circ}{N} + H \sin \frac{180^\circ}{N}$$

$$PR = \frac{P}{2} \sin \left( \frac{180^\circ}{N} \right)$$

$$CCR = PR + \frac{Ds - D}{2}$$

$$J = .3P$$

$$\text{Approximate outside diameter of sprocket when } J \text{ is } .3P = P \left( 0.6 + \cot \frac{180^\circ}{N} \right)$$

$$\text{Outside diameter of sprocket when tooth is pointed} = P \cot \frac{180^\circ}{N} + \cos \frac{180^\circ}{N} (Ds - D) + 2H$$

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Pressure angle for a new chain =  $x_{ab} = 35^\circ - \frac{120^\circ}{N}$

The minimum pressure angle =  $x_{ab} - B = 17^\circ - \frac{64^\circ}{N}$

The average pressure angle is  $26^\circ - \frac{92^\circ}{N}$

TABLE I. Seating curve data.

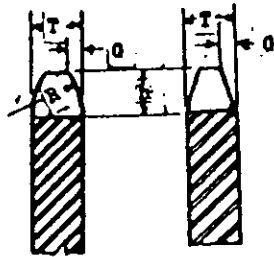
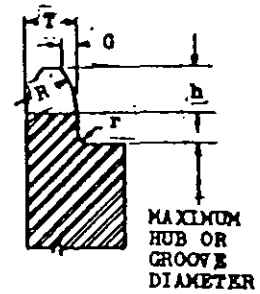
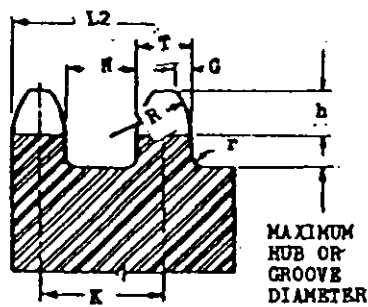
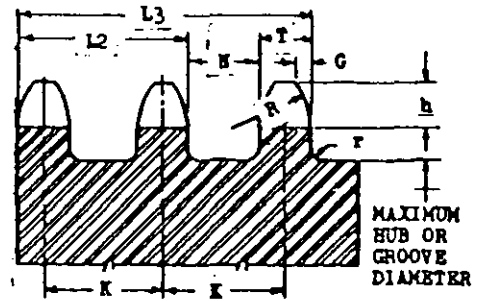
ASA Chain Number	Chain Pitch (P)	Roller Diameter (D)	Minimum Seating Curve Radius (R)	Minimum Seating Curve Diameter (D)	Plus Tolerance on Diameter (*)
25	0.250	0.130	0.0670	0.134	0.0055
**35	0.375	0.200	0.1020	0.204	0.0055
**40	0.500	0.312	0.1585	0.317	0.0060
41	0.500	0.306	0.1585	0.317	0.0060
50	0.625	0.400	0.2025	0.405	0.0060
60	0.750	0.469	0.2370	0.474	0.0065
80	1.000	0.625	0.3155	0.631	0.0070
100	1.250	0.750	0.3785	0.757	0.0070
120	1.500	0.875	0.4410	0.882	0.0075
140	1.750	1.000	0.5040	1.008	0.0080
160	2.000	1.125	0.5670	1.134	0.0085
180	2.250	1.406	0.7080	1.416	0.0090
200	2.500	1.562	0.7870	1.574	0.0095
240	3.000	1.875	0.9435	1.887	0.0105

(\*) Plus only, no minus tolerance

(\*\*) Without rollers

5.4 Tooth cross-sectional profiles. The cross-sectional profiles of the teeth are shown in figures 10, 11, 12, 13, 14, 15, and 16.

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FIGURE 10. Single hot rolled steel plate.FIGURE 11. Single width.FIGURE 12. Double width.FIGURE 13. Triple width.





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Table II. Single width sprockets.

ASA Chain Number	Chain Pitch Inches	h	G	R	r	T	Tolerances on Dimension T			
							Fully machined sprocket	Hot rolled steel plate sprocket or unfinished forging		
							Inches			
25	0.250	.125	0.031	0.266	0.031	.110	+ .000	- .007	+ .000	- .021
35	0.375	.188	0.047	0.406	0.031	.168	+ .000	- .008	+ .000	- .027
40	0.500	.250	0.063	0.531	0.031	.284	+ .000	- .009	+ .000	- .035
41	0.500	.250	0.063	0.531	0.031	.227	+ .000	- .009	+ .000	- .032
50	0.625	.313	0.078	0.656	0.031	.343	+ .000	- .010	+ .000	- .036
60	.750	.375	0.094	0.781	0.031	.459	+ .000	- .011	+ .000	- .036
80	1.000	.500	0.125	1.063	0.047	.575	+ .000	- .012	+ .000	- .040
100	1.250	.625	0.156	1.328	0.047	.692	+ .000	- .014	+ .000	- .046
120	1.500	.750	0.188	1.500	0.062	.924	+ .000	- .016	+ .000	- .057
140	1.750	.875	0.219	1.860	0.062	.924	+ .000	- .016	+ .000	- .057
160	2.000	1.000	0.250	2.125	0.078	1.156	+ .000	- .019	+ .000	- .062
180	2.250	1.125	0.281	2.391	0.094	1.301	+ .000	- .020	+ .000	- .068
200	2.500	1.250	0.313	0.313	0.094	1.389	+ .000	- .021	+ .000	- .072
240	3.000	1.500	0.375	0.375	0.125	1.738	+ .000	- .025	+ .000	- .088

ASA Chain Number	Chain Pitch Inches	h	G	R	r	T	N	K	L <sub>2</sub>	L <sub>3</sub>	Tolerances on T and L dimensions
							Inches				
35	0.375	.188	0.047	0.406	0.031	.162	.236	.398	.560	.958	+ .000 - .008
40	0.500	.250	0.063	0.531	0.031	.275	.291	.566	.841	1.407	+ .000 - .009
50	0.625	.313	0.078	0.656	0.031	.332	.381	.713	1.045	1.758	+ .000 - .010
60	0.750	.375	0.094	0.781	0.031	.444	.454	.898	1.342	2.240	+ .000 - .011
80	1.000	.500	0.125	1.063	0.007	.557	.595	1.152	1.709	2.861	+ .000 - .012
100	1.250	.625	0.156	1.328	0.047	.669	.739	1.408	2.077	3.485	+ .000 - .014
120	1.500	.750	0.188	1.074	0.063	.894	.895	1.789	2.683	4.472	+ .000 - .016
140	1.750	.875	0.219	1.959	0.063	.894	1.030	1.924	2.818	4.742	+ .000 - .016
160	2.000	1.000	0.750	2.125	0.078	1.119	1.186	2.305	3.424	5.729	+ .000 - .019
180	2.250	1.125	0.281	2.390	0.094	1.259	1.333	2.592	3.851	6.443	+ .000 - .020
200	2.250	1.250	0.313	2.656	0.094	1.344	1.473	2.817	4.161	6.978	+ .000 - .021
240	3.000	1.500	0.375	3.188	0.125	1.682	1.775	3.457	5.139	8.596	+ .000 - .025

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TABLE IV. Quadruple, quintuple, and sextuple width sprockets, h - K.

ASA Chain Number	Chain Pitch Inches	h	G	R	r	N	K
		Inches					
35	.375	.188	.047	.0406	.031	.249	.398
40	.500	.250	.063	.631	.031	.310	.566
50	.625	.313	.078	.656	.031	.402	.713
60	.750	.375	.094	.782	.031	.480	.898
80	1.000	.500	.125	1.063	.047	.626	1.152
100	1.250	.625	.150	1.328	.047	.775	1.408
120	1.500	.750	.188	1.594	.063	.941	1.789
140	1.750	.875	.219	1.859	.063	1.076	1.924
160	2.000	1.000	.250	2.125	.078	1.242	2.305
180	2.250	1.125	.280	2.391	.094	1.389	2.592
200	2.500	1.250	.313	2.656	.094	1.539	2.817
240	3.000	1.500	.375	3.188	.125	1.856	3.457

TABLE V. Quadruple, quintuple, and sextuple width sprockets, T - L6.

ASA Chain Number	Chain Pitch Inches	T	L2	L3	L4	L5	L6	Tolerances on T and L dimensions
Inches								
35	.375	.149	.547	.945	1.343	1.741	2.139	+ .000 - .008
40	.500	.256	.822	1.388	1.954	2.520	3.086	+ .000 - .009
50	.625	.311	1.024	1.737	2.450	3.163	3.876	+ .000 - .010
60	.750	.418	1.316	2.214	3.112	4.010	4.908	+ .000 - .011
80	1.000	.526	1.678	2.830	3.982	5.134	6.286	+ .000 - .012
100	1.750	.633	2.041	3.449	4.857	6.265	7.673	+ .000 - .014
120	1.500	.848	2.637	4.426	6.215	8.004	9.793	+ .000 - .016
140	1.750	.848	2.772	4.696	6.620	8.544	10.468	+ .000 - .016
160	2.000	1.063	3.368	5.673	7.978	10.283	12.588	+ .000 - .019
180	2.250	1.197	3.789	6.381	8.973	11.565	14.157	+ .000 - .020
200	2.500	1.278	4.095	6.912	9.729	12.546	15.363	+ .000 - .021
240	3.000	1.601	5.058	8.515	11.972	15.429	18.886	+ .000 - .025

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.250	.130	8.	.653	.523	.754	.324	.5230
.250	.130	9.	.731	.601	.837	.407	.5899
.250	.130	10.	.809	.679	.919	.489	.6790
.250	.130	11.	.887	.757	1.001	.571	.7480
.250	.130	12.	.966	.836	1.083	.653	.8360
.250	.130	13.	1.045	.915	1.164	.734	.9074
.250	.130	14.	1.123	.993	1.245	.815	.9930
.250	.130	15.	1.202	1.072	1.326	.896	1.0654
.250	.130	16.	1.281	1.151	1.407	.977	1.1510
.250	.130	17.	1.361	1.231	1.487	1.057	1.2252
.250	.130	18.	1.440	1.310	1.568	1.138	1.3100
.250	.130	19.	1.519	1.389	1.648	1.218	1.3838
.250	.130	20.	1.598	1.468	1.728	1.298	1.4680
.250	.130	21.	1.677	1.547	1.809	1.379	1.5423
.250	.130	22.	1.757	1.627	1.889	1.459	1.6270
.250	.130	23.	1.836	1.706	1.969	1.539	1.7017
.250	.130	24.	1.915	1.785	2.049	1.619	1.7850
.250	.130	25.	1.995	1.865	2.129	1.699	1.8611
.250	.130	26.	2.074	1.944	2.209	1.779	1.9440
.250	.130	27.	2.153	2.023	2.289	1.859	2.0194
.250	.130	28.	2.233	2.103	2.369	1.939	2.1030
.250	.130	29.	2.312	2.182	2.449	2.019	2.1786
.250	.130	30.	2.392	2.262	2.529	2.099	2.2620
.250	.130	31.	2.471	2.341	2.608	2.178	2.3378
.250	.130	32.	2.551	2.421	2.688	2.258	2.4210
.250	.130	33.	2.630	2.500	2.768	2.338	2.4970
.250	.130	34.	2.709	2.579	2.848	2.418	2.5790
.250	.130	35.	2.789	2.659	2.928	2.498	2.6562
.250	.130	36.	2.868	2.738	3.008	2.578	2.7380
.250	.130	37.	2.948	2.818	3.087	2.657	2.8153
.250	.130	38.	3.027	2.897	3.167	2.737	2.8970
.250	.130	39.	3.107	2.977	3.247	2.817	2.9745

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.250	.130	40.	3.186	3.056	3.327	2.897	3.0560
.250	.130	41.	3.266	3.136	3.406	2.976	3.1336
.250	.130	42.	3.345	3.215	3.486	3.056	3.2150
.250	.130	43.	3.425	3.295	3.566	3.136	3.2927
.250	.130	44.	3.504	3.374	3.645	3.215	3.3740
.250	.130	45.	3.584	3.454	3.725	3.295	3.4518
.250	.130	46.	3.663	3.533	3.805	3.375	3.5330
.250	.130	47.	3.743	3.613	3.885	3.455	3.6109
.250	.130	48.	3.822	3.692	3.964	3.534	3.6920
.250	.130	49.	3.902	3.772	4.044	3.614	3.7700
.250	.130	50.	3.981	3.851	4.124	3.694	3.8510
.250	.130	51.	4.061	3.931	4.203	3.773	3.9291
.250	.130	52.	4.141	4.011	4.283	3.853	4.0110
.250	.130	53.	4.220	4.090	4.363	3.933	4.0881
.250	.130	54.	4.300	4.170	4.442	4.012	4.1700
.250	.130	55.	4.379	4.249	4.522	4.092	4.2472
.250	.130	56.	4.459	4.329	4.602	4.172	4.3290
.250	.130	57.	4.538	4.408	4.681	4.251	4.4063
.250	.130	58.	4.618	4.488	4.761	4.331	4.4880
.250	.130	59.	4.697	4.567	4.841	4.411	4.5653
.250	.130	60.	4.777	4.647	4.920	4.490	4.6470
.250	.130	61.	4.856	4.726	5.000	4.570	4.7244
.250	.130	62.	4.936	4.806	5.080	4.650	4.8060
.250	.130	63.	5.015	4.885	5.159	4.729	4.8834
.250	.130	64.	5.095	4.965	5.239	4.809	4.9650
.250	.130	65.	5.175	5.045	5.319	4.889	5.0435
.250	.130	66.	5.254	5.124	5.398	4.968	5.1240
.250	.130	67.	5.334	5.204	5.478	5.048	5.2025
.250	.130	68.	5.413	5.283	5.557	5.127	5.2830
.250	.130	69.	5.493	5.363	5.637	5.207	5.3616
.250	.130	70.	5.572	5.442	5.717	5.287	5.4420
.250	.130	71.	5.652	5.522	5.796	5.366	5.5206
.250	.130	72.	5.731	5.601	5.876	5.446	5.6010

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.250	.130	73.	5.811	5.681	5.956	5.526	5.6797
.250	.130	74.	5.891	5.761	6.035	5.605	5.7610
.250	.130	75.	5.970	5.840	6.115	5.685	5.8387
.250	.130	76.	6.050	5.920	6.194	5.764	5.9200
.250	.130	77.	6.129	5.999	6.274	5.844	5.9977
.250	.130	78.	6.209	6.079	6.354	5.924	6.0790
.250	.130	79.	6.288	6.158	6.433	6.003	6.1568
.250	.130	80.	6.368	6.238	6.513	6.083	6.2380
.250	.130	81.	6.447	6.317	6.593	6.163	6.3158
.250	.130	82.	6.527	6.397	6.672	6.242	6.3970
.250	.130	83.	6.607	6.477	6.752	6.322	6.4758
.250	.130	84.	6.686	6.556	6.831	6.401	6.5560
.250	.130	85.	6.766	6.636	6.911	6.481	6.6348
.250	.130	86.	6.845	6.715	6.991	6.561	6.7150
.250	.130	87.	6.925	6.795	7.070	6.640	6.7939
.250	.130	88.	7.004	6.874	7.150	6.720	6.8740
.250	.130	89.	7.084	6.954	7.229	6.799	6.9529
.250	.130	90.	7.163	7.033	7.309	6.879	7.0330
.250	.130	91.	7.243	7.113	7.389	6.959	7.1119
.250	.130	92.	7.323	7.193	7.468	7.038	7.1930
.250	.130	93.	7.402	7.272	7.548	7.118	7.2709
.250	.130	94.	7.482	7.352	7.627	7.197	7.3520
.250	.130	95.	7.561	7.431	7.707	7.277	7.4300
.250	.130	96.	7.641	7.511	7.787	7.357	7.5110
.250	.130	97.	7.720	7.590	7.866	7.436	7.5890
.250	.130	98.	7.800	7.670	7.946	7.516	7.6700
.250	.130	99.	7.879	7.749	8.026	7.596	7.7480
.250	.130	100.	7.959	7.829	8.105	7.675	7.8290
.250	.130	101.	8.039	7.909	8.185	7.755	7.9080
.250	.130	102.	8.118	7.988	8.264	7.834	7.9880
.250	.130	103.	8.198	8.068	8.344	7.914	8.0670
.250	.130	104.	8.277	8.147	8.424	7.994	8.1470
.250	.130	105.	8.357	8.227	8.503	8.073	8.2261



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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.250	.130	106.	8.436	8.306	8.583	8.153	8.3060
.250	.130	107.	8.516	8.386	8.662	8.232	8.3851
.250	.130	108.	8.596	8.466	8.742	8.312	8.4660
.250	.130	109.	8.675	8.545	8.822	8.392	8.5441
.250	.130	110.	8.755	8.625	8.901	8.471	8.6250
.250	.130	111.	8.834	8.704	8.981	8.551	8.7031
.250	.130	112.	8.914	8.784	9.060	8.630	8.7840
.250	.130	113.	8.993	8.863	9.140	8.710	8.8621
.250	.130	114.	9.073	8.943	9.220	8.790	8.9430
.250	.130	115.	9.153	9.023	9.299	8.869	9.0221
.250	.130	116.	9.232	9.102	9.379	8.949	9.1020
.250	.130	117.	9.312	9.182	9.458	9.028	9.1812
.250	.130	118.	9.391	9.261	9.538	9.108	9.2610
.250	.130	119.	9.471	9.341	9.618	9.188	9.3402
.250	.130	120.	9.550	9.420	9.697	9.267	9.4200
.250	.130	121.	9.630	9.500	9.777	9.347	9.4992
.250	.130	122.	9.710	9.580	9.856	9.426	9.5800
.250	.130	123.	9.789	9.659	9.936	9.506	9.6582
.250	.130	124.	9.869	9.739	10.015	9.585	9.7390
.250	.130	125.	9.948	9.818	10.095	9.665	9.8172
.250	.130	126.	10.028	9.898	10.175	9.745	9.8980
.250	.130	127.	10.107	9.977	10.254	9.824	9.9762
.250	.130	128.	10.187	10.057	10.334	9.904	10.0570
.250	.130	129.	10.267	10.137	10.413	9.983	10.1362
.250	.130	130.	10.346	10.216	10.493	10.063	10.2160
.250	.130	131.	10.426	10.296	10.573	10.143	10.2953
.250	.130	132.	10.505	10.375	10.652	10.222	10.3750
.250	.130	133.	10.585	10.455	10.732	10.302	10.4543
.250	.130	134.	10.664	10.534	10.811	10.381	10.5340
.250	.130	135.	10.744	10.614	10.891	10.461	10.6133
.250	.130	136.	10.823	10.693	10.971	10.541	10.6930
.250	.130	137.	10.903	10.773	11.050	10.620	10.7723
.250	.130	138.	10.983	10.853	11.130	10.700	10.8530

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.250	.130	139.	11.062	10.932	11.209	10.779	10.9313
.250	.130	140.	11.142	11.012	11.289	10.859	11.0120
.250	.130	141.	11.221	11.091	11.369	10.939	11.0903
.250	.130	142.	11.301	11.171	11.448	11.018	11.1710
.250	.130	143.	11.380	11.250	11.528	11.098	11.2493
.250	.130	144.	11.460	11.330	11.607	11.177	11.3300
.250	.130	145.	11.540	11.410	11.687	11.257	11.4093
.250	.130	146.	11.619	11.489	11.767	11.337	11.4890
.250	.130	147.	11.699	11.569	11.846	11.416	11.5683
.250	.130	148.	11.778	11.648	11.926	11.496	11.6480
.250	.130	149.	11.858	11.728	12.005	11.575	11.7273
.250	.130	150.	11.937	11.807	12.085	11.655	11.8070
.375	.200	8.	.980	.780	1.130	.500	.7800
.375	.200	9.	1.096	.896	1.255	.625	.8793
.375	.200	10.	1.214	1.014	1.379	.749	1.0140
.375	.200	11.	1.331	1.131	1.502	.872	1.1175
.375	.200	12.	1.449	1.249	1.625	.995	1.2490
.375	.200	13.	1.567	1.367	1.746	1.116	1.3556
.375	.200	14.	1.685	1.485	1.868	1.238	1.4850
.375	.200	15.	1.804	1.604	1.989	1.359	1.5941
.375	.200	16.	1.922	1.722	2.110	1.480	1.7220
.375	.200	17.	2.041	1.841	2.231	1.601	1.8323
.375	.200	18.	2.160	1.960	2.352	1.722	1.9600
.375	.200	19.	2.278	2.078	2.472	1.842	2.0702
.375	.200	20.	2.397	2.197	2.593	1.963	2.1970
.375	.200	21.	2.516	2.316	2.713	2.083	2.3090
.375	.200	22.	2.635	2.435	2.833	2.203	2.4350
.375	.200	23.	2.754	2.554	2.953	2.323	2.5476
.375	.200	24.	2.873	2.673	3.073	2.443	2.6730
.375	.200	25.	2.992	2.792	3.193	2.563	2.7861
.375	.200	26.	3.111	2.911	3.313	2.683	2.9110
.375	.200	27.	3.230	3.030	3.433	2.803	3.0245
.375	.200	28.	3.349	3.149	3.553	2.923	3.1490

TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.375	.200	29.	3.468	3.268	3.673	3.043	3.2629
.375	.200	30.	3.588	3.388	3.793	3.163	3.3880
.375	.200	31.	3.707	3.507	3.913	3.283	3.5022
.375	.200	32.	3.826	3.626	4.032	3.402	3.6260
.375	.200	33.	3.945	3.745	4.152	3.522	3.7405
.375	.200	34.	4.064	3.864	4.272	3.642	3.8640
.375	.200	35.	4.183	3.983	4.392	3.762	3.9788
.375	.200	36.	4.303	4.103	4.511	3.881	4.1030
.375	.200	37.	4.422	4.222	4.631	4.001	4.2180
.375	.200	38.	4.541	4.341	4.751	4.121	4.3410
.375	.200	39.	4.660	4.460	4.870	4.240	4.4562
.375	.200	40.	4.780	4.580	4.990	4.360	4.5800
.375	.200	41.	4.899	4.699	5.109	4.479	4.6954
.375	.200	42.	5.018	4.818	5.229	4.599	4.8180
.375	.200	43.	5.137	4.937	5.349	4.719	4.9336
.375	.200	44.	5.257	5.057	5.468	4.838	5.0570
.375	.200	45.	5.376	5.176	5.588	4.958	5.1727
.375	.200	46.	5.495	5.295	5.707	5.077	5.2950
.375	.200	47.	5.614	5.414	5.827	5.197	5.4109
.375	.200	48.	5.734	5.534	5.946	5.316	5.5340
.375	.200	49.	5.853	5.653	6.066	5.436	5.6500
.375	.200	50.	5.972	5.772	6.185	5.555	5.7720
.375	.200	51.	6.092	5.892	6.305	5.675	5.8891
.375	.200	52.	6.211	6.011	6.424	5.794	6.0110
.375	.200	53.	6.330	6.130	6.544	5.914	6.1272
.375	.200	54.	6.449	6.249	6.663	6.033	6.2490
.375	.200	55.	6.569	6.369	6.783	6.153	6.3663
.375	.200	56.	6.688	6.488	6.902	6.272	6.4880
.375	.200	57.	6.807	6.607	7.022	6.392	6.6044
.375	.200	58.	6.927	6.727	7.141	6.511	6.7270
.375	.200	59.	7.046	6.846	7.261	6.631	6.8435
.375	.200	60.	7.165	6.965	7.380	6.750	6.9650
.375	.200	61.	7.285	7.085	7.500	6.870	7.0826

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.375	.200	62.	7.404	7.204	7.619	6.989	7.2040
.375	.200	63.	7.523	7.323	7.739	7.109	7.3207
.375	.200	64.	7.643	7.443	7.858	7.228	7.4430
.375	.200	65.	7.762	7.562	7.978	7.348	7.5597
.375	.200	66.	7.881	7.681	8.097	7.467	7.6810
.375	.200	67.	8.000	7.800	8.217	7.587	7.7978
.375	.200	68.	8.120	7.920	8.336	7.706	7.9200
.375	.200	69.	8.239	8.039	8.456	7.826	8.0369
.375	.200	70.	8.358	8.158	8.575	7.945	8.1580
.375	.200	71.	8.478	8.278	8.694	8.064	8.2759
.375	.200	72.	8.597	8.397	8.814	8.184	8.3970
.375	.200	73.	8.716	8.516	8.933	8.303	8.5140
.375	.200	74.	8.836	8.636	9.053	8.423	8.6360
.375	.200	75.	8.955	8.755	9.172	8.542	8.7530
.375	.200	76.	9.074	8.874	9.292	8.662	8.8740
.375	.200	77.	9.194	8.994	9.411	8.781	8.9921
.375	.200	78.	9.313	9.113	9.531	8.901	9.1130
.375	.200	79.	9.432	9.232	9.650	9.020	9.2301
.375	.200	80.	9.552	9.352	9.769	9.139	9.3520
.375	.200	81.	9.671	9.471	9.889	9.259	9.4692
.375	.200	82.	9.790	9.590	10.008	9.378	9.5900
.375	.200	83.	9.910	9.710	10.128	9.498	9.7082
.375	.200	84.	10.029	9.829	10.247	9.617	9.8290
.375	.200	85.	10.148	9.948	10.367	9.737	9.9463
.375	.200	86.	10.268	10.068	10.486	9.856	10.0680
.375	.200	87.	10.387	10.187	10.605	9.975	10.1853
.375	.200	88.	10.506	10.306	10.725	10.095	10.3060
.375	.200	89.	10.626	10.426	10.844	10.214	10.4243
.375	.200	90.	10.745	10.545	10.964	10.334	10.5450
.375	.200	91.	10.864	10.664	11.083	10.453	10.6624
.375	.200	92.	10.984	10.784	11.202	10.572	10.7840
.375	.200	93.	11.103	10.903	11.322	10.692	10.9014
.375	.200	94.	11.223	11.023	11.441	10.811	11.0230

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.375	.200	95.	11.342	11.142	11.561	10.931	11.1404
.375	.200	96.	11.461	11.261	11.680	11.050	11.2610
.375	.200	97.	11.581	11.381	11.799	11.169	11.3795
.375	.200	98.	11.700	11.500	11.919	11.289	11.5000
.375	.200	99.	11.819	11.619	12.038	11.406	11.6175
.375	.200	100.	11.939	11.739	12.158	11.528	11.7390
.375	.200	101.	12.058	11.858	12.277	11.647	11.8565
.375	.200	102.	12.177	11.977	12.307	11.767	11.9770
.375	.200	103.	12.297	12.097	12.516	11.886	12.0956
.375	.200	104.	12.416	12.216	12.635	12.005	12.2160
.375	.200	105.	12.535	12.335	12.755	12.125	12.3336
.375	.200	106.	12.655	12.455	12.874	12.244	12.4550
.375	.200	107.	12.774	12.574	12.904	12.364	12.5726
.375	.200	108.	12.893	12.693	13.113	12.463	12.6930
.375	.200	109.	13.013	12.813	13.232	12.602	12.8116
.375	.200	110.	13.132	12.932	13.352	12.722	12.9320
.375	.200	111.	13.251	13.051	13.471	12.841	13.0497
.375	.200	112.	13.371	13.171	13.591	12.961	13.1710
.375	.200	113.	13.490	13.290	13.710	13.080	13.2887
.375	.200	114.	13.609	13.409	13.829	13.199	13.4090
.375	.200	115.	13.729	13.529	13.949	13.319	13.5277
.375	.200	116.	13.848	13.648	14.068	13.438	13.6480
.375	.200	117.	13.968	13.768	14.187	13.557	13.7667
.375	.200	118.	14.087	13.887	14.307	13.677	13.8870
.375	.200	119.	14.206	14.006	14.426	13.796	14.0048
.375	.200	120.	14.326	14.126	14.546	13.916	14.1260
.375	.200	121.	14.445	14.245	14.665	14.035	14.2438
.375	.200	122.	14.564	14.364	14.784	14.154	14.3640
.375	.200	123.	14.684	14.484	14.904	14.274	14.4828
.375	.200	124.	14.803	14.603	15.023	14.393	14.6030
.375	.200	125.	14.922	14.722	15.143	14.513	14.7208
.375	.200	126.	15.042	14.842	15.262	14.632	14.8420
.375	.200	127.	15.161	14.961	15.381	14.751	14.9598

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.375	.200	128.	15.280	15.080	15.501	14.871	15.0800
.375	.200	129.	15.400	15.200	15.620	14.990	15.1989
.375	.200	130.	15.519	15.319	15.740	15.110	15.3190
.375	.200	131.	15.638	15.438	15.859	15.229	15.4369
.375	.200	132.	15.758	15.558	15.978	15.348	15.5580
.375	.200	133.	15.877	15.677	16.098	15.468	15.6759
.375	.200	134.	15.997	15.797	16.217	15.587	15.7970
.375	.200	135.	16.116	15.916	16.337	15.707	15.9149
.375	.200	136.	16.235	16.035	16.456	15.826	16.0350
.375	.200	137.	16.355	16.155	16.575	15.945	16.1539
.375	.200	138.	16.474	16.274	16.695	16.065	16.2740
.375	.200	139.	16.593	16.393	16.814	16.184	16.3919
.375	.200	140.	16.713	16.513	16.933	16.303	16.5130
.375	.200	141.	16.832	16.632	17.053	16.423	16.6310
.375	.200	142.	16.951	16.751	17.172	16.542	16.7510
.375	.200	143.	17.071	16.871	17.292	16.662	16.8700
.375	.200	144.	17.190	16.990	17.411	16.781	16.9900
.375	.200	145.	17.309	17.109	17.530	16.900	17.1080
.375	.200	146.	17.429	17.229	17.650	17.020	17.2290
.375	.200	147.	17.548	17.348	17.769	17.139	17.3470
.375	.200	148.	17.668	17.468	17.889	17.259	17.4680
.375	.200	149.	17.787	17.587	18.008	17.378	17.5860
.375	.200	150.	17.906.	17.706	18.127	17.497	17.7060
.500	.312	8.	1.307	.995	1.507	.677	.9950
.500	.312	9.	1.462	1.150	1.674	.844	1.1278
.500	.312	10.	1.618	1.306	1.839	1.009	1.3060
.500	.312	11.	1.775	1.463	2.003	1.173	1.4449
.500	.312	12.	1.932	1.620	2.166	1.336	1.6200
.500	.312	13.	2.089	1.777	2.329	1.499	1.7618
.500	.312	14.	2.247	1.935	2.491	1.661	1.9350
.500	.312	15.	2.405	2.093	2.652	1.822	2.0798
.500	.312	16.	2.563	2.251	2.814	1.984	2.2510
.500	.312	17.	2.721	2.409	2.975	2.145	2.3974

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.500	.312	18.	2.879	2.567	3.136	2.306	2.5670
.500	.312	19.	3.038	2.726	3.296	2.466	2.7156
.500	.312	20.	3.196	2.884	3.457	2.627	2.8840
.500	.312	21.	3.355	3.043	3.617	2.787	3.0336
.500	.312	22.	3.513	3.201	3.778	2.948	3.2010
.500	.312	23.	3.672	3.360	3.938	3.108	3.3514
.500	.312	24.	3.831	3.519	4.098	3.268	3.5190
.500	.312	25.	3.989	3.677	4.258	3.428	3.6691
.500	.312	26.	4.148	3.836	4.418	3.588	3.8360
.500	.312	27.	4.307	3.995	4.578	3.748	3.9877
.500	.312	28.	4.466	4.154	4.738	3.908	4.1540
.500	.312	29.	4.625	4.313	4.897	4.067	4.3062
.500	.312	30.	4.783	4.471	5.057	4.227	4.4710
.500	.312	31.	4.942	4.630	5.217	4.387	4.6237
.500	.312	32.	5.101	4.789	5.377	4.547	4.7890
.500	.312	33.	5.260	4.948	5.536	4.706	4.9420
.500	.312	34.	5.419	5.107	5.696	4.866	5.1070
.500	.312	35.	5.578	5.266	5.855	5.025	5.2604
.500	.312	36.	5.737	5.425	6.015	5.185	5.4250
.500	.312	37.	5.896	5.584	6.175	5.345	5.5787
.500	.312	38.	6.055	5.743	6.334	5.504	5.7430
.500	.312	39.	6.214	5.902	6.494	5.664	5.8970
.500	.312	40.	6.373	6.061	6.653	5.823	6.0610
.500	.312	41.	6.532	6.220	6.813	5.983	6.2152
.500	.312	42.	6.691	6.379	6.972	6.142	6.3790
.500	.312	43.	6.850	6.538	7.131	6.301	6.5334
.500	.312	44.	7.009	6.697	7.291	6.461	6.6970
.500	.312	45.	7.168	6.856	7.450	6.620	6.8516
.500	.312	46.	7.327	7.015	7.610	6.780	7.0150
.500	.312	47.	7.486	7.174	7.769	6.939	7.1698
.500	.312	48.	7.645	7.333	7.929	7.099	7.3330
.500	.312	49.	7.804	7.492	8.088	7.258	7.4880
.500	.312	50.	7.963	7.651	8.247	7.417	7.6510

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.500	.312	51.	8.122	7.810	8.407	7.577	7.8061
.500	.312	52.	8.281	7.969	8.566	7.736	7.9690
.500	.312	53.	8.440	8.128	8.725	7.895	8.1243
.500	.312	54.	8.599	8.287	8.885	8.055	8.2870
.500	.312	55.	8.758	8.446	9.044	8.214	8.4424
.500	.312	56.	8.917	8.605	9.203	8.373	8.6050
.500	.312	57.	9.076	8.764	9.363	8.533	8.7606
.500	.312	58.	9.236	8.924	9.522	8.692	8.9240
.500	.312	59.	9.395	9.083	9.681	8.851	9.0797
.500	.312	60.	9.554	9.242	9.841	9.011	9.2420
.500	.312	61.	9.713	9.401	10.000	9.170	9.3978
.500	.312	62.	9.872	9.560	10.159	9.329	9.5600
.500	.312	63.	10.031	9.719	10.318	9.488	9.7159
.500	.312	64.	10.190	9.878	10.478	9.648	9.8780
.500	.312	65.	10.349	10.037	10.637	9.807	10.0340
.500	.312	66.	10.508	10.196	10.796	9.966	10.1960
.500	.312	67.	10.667	10.355	10.956	10.126	10.3521
.500	.312	68.	10.826	10.514	11.115	10.285	10.5140
.500	.312	69.	10.985	10.673	11.274	10.444	10.6702
.500	.312	70.	11.145	10.833	11.433	10.603	10.8330
.500	.312	71.	11.304	10.992	11.593	10.763	10.9892
.500	.312	72.	11.463	11.151	11.752	10.922	11.1510
.500	.312	73.	11.622	11.310	11.911	11.081	11.3073
.500	.312	74.	11.781	11.469	12.070	11.240	11.4690
.500	.312	75.	11.940	11.628	12.230	11.400	11.6254
.500	.312	76.	12.099	11.787	12.389	11.559	11.7870
.500	.312	77.	12.258	11.946	12.548	11.718	11.9434
.500	.312	78.	12.417	12.105	12.707	11.877	12.1050
.500	.312	79.	12.577	12.265	12.867	12.037	12.2625
.500	.312	80.	12.736	12.424	13.026	12.196	12.4240
.500	.312	81.	12.895	12.583	13.185	12.353	12.5806
.500	.312	82.	13.054	12.742	13.344	12.514	12.7420
.500	.312	83.	13.213	12.901	13.504	12.674	12.8986



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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.500	.312	84.	13.372	13.060	13.663	12.833	13.0600
.500	.312	85.	13.531	13.219	13.822	12.992	13.2167
.500	.312	86.	13.690	13.378	13.981	13.151	13.3780
.500	.312	87.	13.849	13.537	14.140	13.310	13.5347
.500	.312	88.	14.009	13.697	14.300	13.470	13.6970
.500	.312	89.	14.168	13.856	14.459	13.629	13.8538
.500	.312	90.	14.327	14.015	14.618	13.788	14.0150
.500	.312	91.	14.486	14.174	14.777	13.947	14.1718
.500	.312	92.	14.645	14.333	14.937	14.107	14.3330
.500	.312	93.	14.804	14.492	15.096	14.266	14.4899
.500	.312	94.	14.963	14.651	15.255	14.425	14.6510
.500	.312	95.	15.122	14.810	15.414	14.584	14.8079
.500	.312	96.	15.282	14.970	15.573	14.743	14.9700
.500	.312	97.	15.441	15.129	15.733	14.903	15.1270
.500	.312	98.	15.600	15.288	15.892	15.062	15.2880
.500	.312	99.	15.759	15.447	16.051	15.221	15.4450
.500	.312	100.	15.918	15.606	16.210	15.380	15.6060
.500	.312	101.	16.077	15.763	16.369	15.539	15.7631
.500	.312	102.	16.236	15.924	16.529	15.699	15.9240
.500	.312	103.	16.396	16.084	16.688	15.858	16.0821
.500	.312	104.	16.555	16.243	16.847	16.017	16.2430
.500	.312	105.	16.714	16.402	17.006	16.176	16.4001
.500	.312	106.	16.873	16.561	17.165	16.335	16.5610
.500	.312	107.	17.032	16.720	17.325	16.495	16.7182
.500	.312	108.	17.191	16.879	17.484	16.654	16.8790
.500	.312	109.	17.350	17.038	17.643	16.813	17.0362
.500	.312	110.	17.509	17.197	17.802	16.972	17.1970
.500	.312	111.	17.669	17.357	17.961	17.131	17.3552
.500	.312	112.	17.828	17.516	18.121	17.291	17.5160
.500	.312	113.	17.987	17.675	18.280	17.450	17.6733
.500	.312	114.	18.146	17.834	18.439	17.609	17.8340
.500	.312	115.	18.305	17.993	18.598	17.768	17.9913
.500	.312	116.	18.464	18.152	18.757	17.927	18.1520

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.500	.312	117.	18.623	18.311	18.917	18.087	18.3093
.500	.312	118.	18.783	18.471	19.076	18.246	18.4710
.500	.312	119.	18.942	18.630	19.235	18.405	18.6283
.500	.312	120.	19.101	18.789	19.394	18.564	18.7890
.500	.312	121.	19.260	18.948	19.553	18.723	18.9464
.500	.312	122.	19.419	19.107	19.713	18.883	19.1070
.500	.312	123.	19.578	19.266	19.872	19.042	19.2644
.500	.312	124.	19.737	19.425	20.031	19.201	19.4250
.500	.312	125.	19.896	19.584	20.190	19.360	19.5824
.500	.312	126.	20.056	19.744	20.349	19.519	19.7440
.500	.312	127.	20.215	19.903	20.509	19.679	19.9015
.500	.312	128.	20.374	20.062	20.668	19.838	20.0620
.500	.312	129.	20.533	20.221	20.827	19.997	20.2195
.500	.312	130.	20.692	20.380	20.986	20.156	20.3800
.500	.312	131.	20.851	20.539	21.145	20.315	20.5375
.500	.312	132.	21.010	20.698	21.304	20.474	20.6980
.500	.312	133.	21.170	20.858	21.464	20.634	20.8565
.500	.312	134.	21.329	21.017	21.623	20.793	21.0170
.500	.312	135.	21.486	21.176	21.782	20.952	21.1745
.500	.312	136.	21.647	21.335	21.941	21.111	21.3350
.500	.312	137.	21.806	21.494	22.100	21.270	21.4926
.500	.312	138.	21.965	21.653	22.260	21.430	21.6530
.500	.312	139.	22.124	21.812	22.419	21.589	21.8106
.500	.312	140.	22.284	21.972	22.578	21.748	21.9720
.500	.312	141.	22.443	22.131	22.737	21.907	22.1296
.500	.312	142.	22.602	22.290	22.896	22.066	22.2900
.500	.312	143.	22.761	22.449	23.055	22.225	22.4476
.500	.312	144.	22.920	22.608	23.215	22.385	22.6080
.500	.312	145.	23.079	22.767	23.374	22.544	22.7656
.500	.312	146.	23.238	22.926	23.533	22.703	22.9260
.500	.312	147.	23.398	23.086	23.692	22.862	23.0847
.500	.312	148.	23.557	23.245	23.851	23.021	23.2450
.500	.312	149.	23.716	23.404	24.011	23.181	23.4027

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.500	.312	150.	23.875	23.563	24.170	23.340	23.5630
.625	.400	8.	1.633	1.233	1.884	.854	1.2330
.625	.400	9.	1.827	1.427	2.092	1.062	1.3992
.625	.400	10.	2.023	1.623	2.299	1.269	1.6230
.625	.400	11.	2.218	1.818	2.504	1.474	1.7954
.625	.400	12.	2.415	2.015	2.708	1.678	2.0150
.625	.400	13.	2.612	2.212	2.911	1.881	2.1930
.625	.400	14.	2.809	2.409	3.113	2.083	2.4090
.625	.400	15.	3.006	2.606	3.315	2.285	2.5895
.625	.400	16.	3.204	2.804	3.517	2.487	2.8040
.625	.400	17.	3.401	3.001	3.718	2.688	2.9865
.625	.400	18.	3.599	3.199	3.920	2.890	3.1990
.625	.400	19.	3.797	3.397	4.120	3.090	3.3840
.625	.400	20.	3.995	3.595	4.321	3.291	3.5950
.625	.400	21.	4.193	3.793	4.522	3.492	3.7813
.625	.400	22.	4.392	3.992	4.722	3.692	3.9920
.625	.400	23.	4.590	4.190	4.922	3.892	4.1793
.625	.400	24.	4.788	4.388	5.122	4.092	4.3880
.625	.400	25.	4.987	4.587	5.322	4.292	4.5772
.625	.400	26.	5.185	4.785	5.522	4.492	4.7850
.625	.400	27.	5.384	4.984	5.722	4.692	4.9749
.625	.400	28.	5.582	5.182	5.922	4.892	5.1820
.625	.400	29.	5.761	5.381	6.122	5.092	5.3725
.625	.400	30.	5.979	5.579	6.321	5.291	5.5790
.625	.400	31.	6.178	5.778	6.521	5.491	5.7701
.625	.400	32.	6.376	5.976	6.721	5.691	5.9760
.625	.400	33.	6.575	6.175	6.920	5.890	6.1676
.625	.400	34.	6.774	6.374	7.120	6.090	6.3740
.625	.400	35.	6.972	6.572	7.319	6.289	6.5650
.625	.400	36.	7.171	6.771	7.519	6.489	6.7710
.625	.400	37.	7.370	6.970	7.718	6.688	6.9634
.625	.400	38.	7.568	7.168	7.918	6.888	7.1680
.625	.400	39.	7.767	7.367	8.117	7.087	7.3607

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.625	.400	40.	7.966	7.566	8.316	7.286	7.5660
.625	.400	41.	8.165	7.765	8.516	7.486	7.7590
.625	.400	42.	8.363	7.963	8.715	7.685	7.9630
.625	.400	43.	8.562	8.162	8.914	7.884	8.1563
.625	.400	44.	8.761	8.361	9.114	8.084	8.3610
.625	.400	45.	8.960	8.560	9.313	8.283	8.5545
.625	.400	46.	9.159	8.759	9.512	8.482	8.7590
.625	.400	47.	9.357	8.957	9.711	8.681	8.9518
.625	.400	48.	9.556	9.156	9.911	8.881	9.1560
.625	.400	49.	9.755	9.355	10.110	9.080	9.3500
.625	.400	50.	9.954	9.554	10.309	9.279	9.5540
.625	.400	51.	10.153	9.753	10.508	9.478	9.7482
.625	.400	52.	10.351	9.951	10.707	9.677	9.9510
.625	.400	53.	10.550	10.150	10.907	9.877	10.1454
.625	.400	54.	10.749	10.349	11.106	10.076	10.3490
.625	.400	55.	10.948	10.548	11.305	10.275	10.5435
.625	.400	56.	11.147	10.747	11.504	10.474	10.7470
.625	.400	57.	11.346	10.946	11.703	10.673	10.9417
.625	.400	58.	11.544	11.144	11.902	10.872	11.1440
.625	.400	59.	11.743	11.343	12.102	11.072	11.3388
.625	.400	60.	11.942	11.542	12.301	11.271	11.5420
.625	.400	61.	12.141	11.741	12.500	11.470	11.7370
.625	.400	62.	12.340	11.940	12.699	11.669	11.9400
.625	.400	63.	12.539	12.139	12.899	11.868	12.1351
.625	.400	64.	12.738	12.338	13.097	12.067	12.3380
.625	.400	65.	12.936	12.536	13.296	12.266	12.5322
.625	.400	66.	13.135	12.735	13.495	12.465	12.7350
.625	.400	67.	13.334	12.934	13.694	12.664	12.9303
.625	.400	68.	13.533	13.133	13.894	12.864	13.1330
.625	.400	69.	13.732	13.332	14.093	13.063	13.3284
.625	.400	70.	13.931	13.531	14.292	13.262	13.5310
.625	.400	71.	14.130	13.730	14.491	13.461	13.7265
.625	.400	72.	14.328	13.928	14.690	13.660	13.9280

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.625	.400	73.	14.527	14.127	14.889	13.859	14.1236
.625	.400	74.	14.726	14.326	15.088	14.058	14.3260
.625	.400	75.	14.925	14.525	15.287	14.257	14.5217
.625	.400	76.	15.124	14.724	15.486	14.456	14.7240
.625	.400	77.	15.323	14.923	15.685	14.655	14.9196
.625	.400	78.	15.522	15.122	15.884	14.854	15.1220
.625	.400	79.	15.721	15.321	16.083	15.053	15.3179
.625	.400	80.	15.920	15.520	16.282	15.252	15.5200
.625	.400	81.	16.118	15.718	16.481	15.451	15.7150
.625	.400	82.	16.317	15.917	16.680	15.650	15.9170
.625	.400	83.	16.516	16.116	16.879	15.849	16.1130
.625	.400	84.	16.715	16.315	17.078	16.048	16.3150
.625	.400	85.	16.914	16.514	17.278	16.248	16.5111
.625	.400	86.	17.113	16.713	17.477	16.447	16.7130
.625	.400	87.	17.312	16.912	17.676	16.646	16.9092
.625	.400	88.	17.511	17.111	17.875	16.845	17.1110
.625	.400	89.	17.710	17.310	18.074	17.044	17.3072
.625	.400	90.	17.909	17.509	18.273	17.243	17.5090
.625	.400	91.	18.107	17.707	18.472	17.442	17.7043
.625	.400	92.	18.306	17.906	18.671	17.641	17.9060
.625	.400	93.	18.505	18.105	18.870	17.840	18.1024
.625	.400	94.	18.704	18.304	19.069	18.039	18.3040
.625	.400	95.	18.903	18.503	19.268	18.238	18.5004
.625	.400	96.	19.102	18.702	19.467	18.437	18.7020
.625	.400	97.	19.301	18.901	19.666	18.636	18.8985
.625	.400	98.	19.500	19.100	19.865	18.835	19.1000
.625	.400	99.	19.699	19.299	20.064	19.034	19.2965
.625	.400	100.	19.898	19.498	20.263	19.233	19.4980
.625	.400	101.	20.097	19.697	20.462	19.432	19.6946
.625	.400	102.	20.295	19.895	20.661	19.631	19.8950
.625	.400	103.	20.494	20.094	20.860	19.830	20.0916
.625	.400	104.	20.693	20.293	21.059	20.029	20.2930
.625	.400	105.	20.892	20.492	21.258	20.228	20.4897

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.625	.400	106.	21.091	20.291	21.457	20.427	20.6910
.625	.400	107.	21.290	20.890	21.656	20.626	20.8877
.625	.400	108.	21.489	21.089	21.855	20.825	21.0890
.625	.400	109.	21.688	21.288	22.054	21.024	21.2857
.625	.400	110.	21.887	21.487	22.253	21.223	21.4870
.625	.400	111.	22.086	21.686	22.452	21.422	21.6838
.625	.400	112.	22.285	21.885	22.651	21.621	21.8850
.625	.400	113.	22.484	22.084	22.850	21.820	22.0818
.625	.400	114.	22.682	22.282	23.049	22.019	22.2820
.625	.400	115.	22.881	22.481	23.248	22.218	22.4789
.625	.400	116.	23.080	22.680	23.447	22.417	22.6800
.625	.400	117.	23.279	22.879	23.646	22.616	22.8769
.625	.400	118.	23.478	23.078	23.845	22.815	23.0780
.625	.400	119.	23.677	23.277	24.044	23.014	23.2749
.625	.400	120.	23.876	23.476	24.243	23.213	23.4760
.625	.400	121.	24.075	23.675	24.442	23.412	23.6730
.625	.400	122.	24.274	23.874	24.641	23.611	23.8740
.625	.400	123.	24.473	24.073	24.840	23.810	24.0710
.625	.400	124.	24.672	24.272	25.039	24.009	24.2720
.625	.400	125.	24.871	24.471	25.238	24.208	24.4690
.625	.400	126.	25.070	24.670	25.437	24.407	24.6700
.625	.400	127.	25.268	24.868	25.636	24.606	24.8661
.625	.400	128.	25.467	25.067	25.835	24.805	25.0670
.625	.400	129.	25.666	25.266	26.034	25.004	25.2641
.625	.400	130.	25.865	25.465	26.233	25.203	25.4650
.625	.400	131.	26.064	25.664	26.432	25.402	25.6621
.625	.400	132.	26.263	25.863	26.631	25.601	25.8630
.625	.400	133.	26.462	26.062	26.830	25.800	26.0602
.625	.400	134.	26.661	26.261	27.029	25.999	26.2610
.625	.400	135.	26.860	26.460	27.228	26.198	26.4582
.625	.400	136.	27.059	26.659	27.427	26.397	26.6590
.625	.400	137.	27.258	26.858	27.626	26.596	26.8562
.625	.400	138.	27.457	27.057	27.824	26.794	27.0570

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.625	.400	139.	27.656	27.256	28.023	26.993	27.2542
.625	.400	140.	27.854	27.454	28.222	27.192	27.4540
.625	.400	141.	28.053	27.653	28.421	27.391	27.6513
.625	.400	142.	28.252	27.852	28.620	27.590	27.8520
.625	.400	143.	28.451	28.051	28.819	27.789	28.0493
.625	.400	144.	28.650	28.250	29.018	27.988	28.2500
.625	.400	145.	28.849	28.449	29.217	28.187	28.4473
.625	.400	146.	29.048	28.648	29.416	28.386	28.6480
.625	.400	147.	29.247	28.847	29.615	28.585	28.8453
.625	.400	148.	29.446	29.046	29.814	28.784	29.0460
.625	.400	149.	29.645	29.245	30.013	28.983	29.2434
.625	.400	150.	29.844	29.444	30.212	29.182	29.4440
.750	.469	8.	1.960	1.491	2.261	1.031	1.4910
.750	.469	9.	2.193	1.724	2.511	1.281	1.6907
.750	.469	10.	2.427	1.958	2.758	1.528	1.9580
.750	.469	11.	2.662	2.193	3.004	1.774	2.1659
.750	.469	12.	2.898	2.429	3.249	2.019	2.4290
.750	.469	13.	3.134	2.665	3.493	2.263	2.6421
.750	.469	14.	3.370	2.901	3.736	2.506	2.9010
.750	.469	15.	3.607	3.138	3.978	2.748	3.1182
.750	.469	16.	3.844	3.375	4.220	2.990	3.3750
.750	.469	17.	4.082	3.613	4.462	3.232	3.5956
.750	.469	18.	4.319	3.850	4.703	3.473	3.8500
.750	.469	19.	4.557	4.088	4.945	3.715	4.0724
.750	.469	20.	4.794	4.325	5.185	3.955	4.3250
.750	.469	21.	5.032	4.563	5.426	4.196	4.5489
.750	.469	22.	5.270	4.801	5.666	4.436	4.8010
.750	.469	23.	5.508	5.039	5.907	4.677	5.0262
.750	.469	24.	5.746	5.277	6.147	4.917	5.2770
.750	.469	25.	5.984	5.515	6.387	5.157	5.5032
.750	.469	26.	6.222	5.753	6.627	5.397	5.7530
.750	.469	27.	6.450	5.991	6.867	5.637	5.9801
.750	.469	28.	6.699	6.230	7.106	5.876	6.2300

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.750	.469	29.	6.937	6.468	7.346	6.116	6.4578
.750	.469	30.	7.175	6.706	7.586	6.356	6.7060
.750	.469	31.	7.413	6.944	7.825	6.595	6.9345
.750	.469	32.	7.652	7.183	8.065	6.835	7.1830
.750	.469	33.	7.890	7.421	8.304	7.074	7.4121
.750	.469	34.	8.128	7.659	8.544	7.314	7.6590
.750	.469	35.	8.367	7.898	8.783	7.553	7.8896
.750	.469	36.	8.605	8.136	9.023	7.793	8.1360
.750	.469	37.	8.844	8.375	9.262	8.032	8.3670
.750	.469	38.	9.082	8.613	9.501	8.271	8.6130
.750	.469	39.	9.321	8.852	9.740	8.510	8.8444
.750	.469	40.	9.559	9.090	9.980	8.750	9.0900
.750	.469	41.	9.798	9.329	10.219	8.989	9.3218
.750	.469	42.	10.036	9.567	10.458	9.228	9.5670
.750	.469	43.	10.275	9.806	10.697	9.467	9.7991
.750	.469	44.	10.513	10.044	10.936	9.706	10.0440
.750	.469	45.	10.752	10.283	11.175	9.945	10.2765
.750	.469	46.	10.990	10.521	11.415	10.185	10.5210
.750	.469	47.	11.229	10.760	11.654	10.424	10.7537
.750	.469	48.	11.467	10.998	11.893	10.663	10.9980
.750	.469	49.	11.706	11.237	12.132	10.902	11.2310
.750	.469	50.	11.944	11.475	12.371	11.141	11.4750
.750	.469	51.	12.183	11.714	12.610	11.380	11.7082
.750	.469	52.	12.422	11.953	12.849	11.619	11.9530
.750	.469	53.	12.660	12.191	13.088	11.858	12.1854
.750	.469	54.	12.899	12.430	13.327	12.097	12.4300
.750	.469	55.	13.137	12.668	13.566	12.336	12.6626
.750	.469	56.	13.376	12.907	13.805	12.575	12.9070
.750	.469	57.	13.615	13.146	14.044	12.814	13.1408
.750	.469	58.	13.853	13.384	14.283	13.053	13.3840
.750	.469	59.	14.092	13.623	14.522	13.292	13.6180
.750	.469	60.	14.330	13.861	14.761	13.531	13.8610
.750	.469	61.	14.569	14.100	15.000	13.770	14.0952



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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.750	.469	62.	14.808	14.339	15.239	14.009	14.3390
.750	.469	63.	15.046	14.577	15.478	14.248	14.5723
.750	.469	64.	15.285	14.816	15.717	14.487	14.8160
.750	.469	65.	15.524	15.055	15.956	14.726	15.0505
.750	.469	66.	15.762	15.293	16.194	14.964	15.2930
.750	.469	67.	16.001	15.532	16.433	15.203	15.5276
.750	.469	68.	16.240	15.771	16.672	15.442	15.7710
.750	.469	69.	16.478	16.009	16.911	15.681	16.0047
.750	.469	70.	16.717	16.248	17.150	15.920	16.2480
.750	.469	71.	16.956	16.487	17.389	16.159	16.4829
.750	.469	72.	17.194	16.725	17.628	16.398	16.7250
.750	.469	73.	17.433	16.964	17.867	16.637	16.9600
.750	.469	74.	17.672	17.203	18.106	16.876	17.2030
.750	.469	75.	17.910	17.441	18.344	17.114	17.4371
.750	.469	76.	18.149	17.680	18.583	17.353	17.6800
.750	.469	77.	18.387	17.918	18.822	17.592	17.9142
.750	.469	78.	18.626	18.157	19.061	17.831	18.1570
.750	.469	79.	18.865	18.396	19.300	18.070	18.3923
.750	.469	80.	19.104	18.635	19.539	18.309	18.6350
.750	.469	81.	19.342	18.873	19.778	18.548	18.8694
.750	.469	82.	19.581	19.112	20.016	18.786	19.1120
.750	.469	83.	19.820	19.351	20.255	19.025	19.3475
.750	.469	84.	20.058	19.589	20.494	19.254	19.5890
.750	.469	85.	20.297	19.828	20.733	19.503	19.8245
.750	.469	86.	20.536	20.067	20.972	19.742	20.0670
.750	.469	87.	20.774	20.305	21.211	19.981	20.3016
.750	.469	88.	21.013	20.544	21.450	20.220	20.5440
.750	.469	89.	21.252	20.783	21.688	20.458	20.7797
.750	.469	90.	21.490	21.021	21.927	20.697	21.0210
.750	.469	91.	21.729	21.260	22.166	20.936	21.2568
.750	.469	92.	21.968	21.499	22.405	21.175	21.4990
.750	.469	93.	22.206	21.737	22.644	21.414	21.7338
.750	.469	94.	22.445	21.976	22.882	21.652	21.9760

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.750	.469	95.	22.684	22.215	23.121	21.891	22.2119
.750	.469	96.	22.922	22.453	23.360	22.130	22.4530
.750	.469	97.	23.161	22.692	23.599	22.369	22.6890
.750	.469	98.	23.400	22.931	23.838	22.608	22.9310
.750	.469	99.	23.638	23.169	24.077	22.847	23.1660
.750	.469	100.	23.877	23.408	24.315	23.085	23.4080
.750	.469	101.	24.116	23.647	24.554	23.324	23.6441
.750	.469	102.	24.355	23.886	24.793	23.563	23.8860
.750	.469	103.	24.593	24.124	25.032	23.802	24.1211
.750	.469	104.	24.832	24.363	25.271	24.041	24.3630
.750	.469	105.	25.071	24.602	25.509	24.279	24.5992
.750	.469	106.	25.309	24.840	25.748	24.518	24.8400
.750	.469	107.	25.548	25.079	25.987	24.757	25.0762
.750	.469	108.	25.787	25.318	26.226	24.996	25.3180
.750	.469	109.	26.025	25.556	26.465	25.235	25.5533
.750	.469	110.	26.264	25.795	26.703	25.473	25.7950
.750	.469	111.	26.503	26.034	26.942	25.712	26.0313
.750	.469	112.	26.742	26.273	27.181	25.951	26.2730
.750	.469	113.	26.980	26.511	27.420	26.190	26.5084
.750	.469	114.	27.219	26.750	27.659	26.429	26.7500
.750	.469	115.	27.458	26.989	27.897	26.667	26.9864
.750	.469	116.	27.696	27.227	28.136	26.906	27.2270
.750	.469	117.	27.935	27.466	28.375	27.145	27.4635
.750	.469	118.	28.174	27.705	28.614	27.384	27.7050
.750	.469	119.	28.412	27.943	28.853	27.623	27.9405
.750	.469	120.	28.651	28.182	29.091	27.861	28.1820
.750	.469	121.	28.890	28.421	29.330	28.100	28.4186
.750	.469	122.	29.129	28.660	29.569	28.339	28.6600
.750	.469	123.	29.367	28.898	29.808	28.578	28.8956
.750	.469	124.	29.606	29.137	30.046	28.816	29.1370
.750	.469	125.	29.845	29.376	30.285	29.055	29.3736
.750	.469	126.	30.083	29.614	30.524	29.294	29.6140
.750	.469	127.	30.322	29.853	30.763	29.533	29.8507

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
.750	.469	128.	30.561	30.092	31.002	29.772	30.0920
.750	.469	129.	30.800	30.331	31.240	30.010	30.3287
.750	.469	130.	31.038	30.569	31.479	30.249	30.5690
.750	.469	131.	31.277	30.808	31.718	30.488	30.8058
.750	.469	132.	31.516	31.047	31.957	30.727	31.0470
.750	.469	133.	31.754	31.285	32.196	30.966	31.2828
.750	.469	134.	31.993	31.524	32.434	31.204	31.5240
.750	.469	135.	32.232	31.763	32.673	31.443	31.7608
.750	.469	136.	32.470	32.001	32.912	31.682	32.0010
.750	.469	137.	32.709	32.240	33.151	31.921	32.2379
.750	.469	138.	32.948	32.479	33.389	32.159	32.4790
.750	.469	139.	33.187	32.718	33.628	32.398	32.7159
.750	.469	140.	33.425	32.956	33.867	32.637	32.9560
.750	.469	141.	33.664	33.195	34.106	32.876	33.1929
.750	.469	142.	33.903	33.434	34.344	33.114	33.4340
.750	.469	143.	34.141	33.672	34.583	33.353	33.6699
.750	.469	144.	34.380	33.911	34.822	33.592	33.9110
.750	.469	145.	34.619	34.150	35.061	33.831	34.1480
.750	.469	146.	34.858	34.389	35.300	34.070	34.3890
.750	.469	147.	35.096	34.627	35.538	34.308	34.6250
.750	.469	148.	35.335	34.866	35.777	34.547	34.8660
.750	.469	149.	35.574	35.105	36.016	34.786	35.1030
.750	.469	150.	35.812	35.343	36.255	35.025	35.3430
1.000	.625	8.	2.613	1.988	3.014	1.384	1.9880
1.000	.625	9.	2.924	2.299	3.347	1.717	2.2546
1.000	.625	10.	3.236	2.611	3.678	2.048	2.6110
1.000	.625	11.	3.549	2.924	4.006	2.376	2.8879
1.000	.625	12.	3.864	3.239	4.332	2.702	3.2390
1.000	.625	13.	4.179	3.554	4.657	3.027	3.5235
1.000	.625	14.	4.494	3.869	4.981	3.351	3.8690
1.000	.625	15.	4.810	4.185	5.305	3.675	4.1587
1.000	.625	16.	5.126	4.501	5.627	3.997	4.5010
1.000	.625	17.	5.442	4.817	5.950	4.320	4.7938

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	18.	5.759	5.134	6.271	4.641	5.1340
1.000	.625	19.	6.076	5.451	6.593	4.963	5.4302
1.000	.625	20.	6.392	5.767	6.914	5.284	5.7670
1.000	.625	21.	6.710	6.085	7.235	5.605	6.0662
1.000	.625	22.	7.027	6.402	7.555	5.925	6.4020
1.000	.625	23.	7.344	6.719	7.876	6.246	6.7019
1.000	.625	24.	7.661	7.036	8.196	6.566	7.0360
1.000	.625	25.	7.979	7.354	8.516	6.886	7.3383
1.000	.625	26.	8.296	7.671	8.836	7.206	7.6710
1.000	.625	27.	8.614	7.989	9.156	7.526	7.9744
1.000	.625	28.	8.931	8.306	9.475	7.845	8.3060
1.000	.625	29.	9.249	8.624	9.795	8.165	8.6104
1.000	.625	30.	9.567	8.942	10.114	8.484	8.9420
1.000	.625	31.	9.885	9.260	10.434	8.804	9.2473
1.000	.625	32.	10.202	9.577	10.753	9.123	9.5770
1.000	.625	33.	10.520	9.895	11.072	9.442	9.8831
1.000	.625	34.	10.838	10.213	11.392	9.762	10.2130
1.000	.625	35.	11.156	10.531	11.711	10.081	10.5198
1.000	.625	36.	11.474	10.849	12.030	10.400	10.8490
1.000	.625	37.	11.792	11.167	12.349	10.719	11.1564
1.000	.625	38.	12.110	11.485	12.668	11.038	11.4850
1.000	.625	39.	12.428	11.803	12.987	11.357	11.7929
1.000	.625	40.	12.745	12.120	13.306	11.676	12.1200
1.000	.625	41.	13.063	12.438	13.625	11.995	12.4284
1.000	.625	42.	13.381	12.756	13.944	12.314	12.7560
1.000	.625	43.	13.700	13.075	14.263	12.633	13.0659
1.000	.625	44.	14.018	13.393	14.582	12.952	13.3930
1.000	.625	45.	14.336	13.711	14.901	13.271	13.7023
1.000	.625	46.	14.654	14.029	15.219	13.589	14.0290
1.000	.625	47.	14.972	14.347	15.538	13.908	14.3386
1.000	.625	48.	15.290	14.665	15.857	14.227	14.6650
1.000	.625	49.	15.608	14.983	16.176	14.546	14.9750
1.000	.625	50.	15.926	15.301	16.495	14.865	15.3010

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	51.	16.244	15.619	16.813	15.183	15.6113
1.000	.625	52.	16.562	15.937	17.132	15.502	15.9370
1.000	.625	53.	16.880	16.255	17.451	15.821	16.2476
1.000	.625	54.	17.198	16.573	17.769	16.139	16.5730
1.000	.625	55.	17.517	16.892	18.088	16.458	16.8849
1.000	.625	56.	17.835	17.210	18.407	16.777	17.2100
1.000	.625	57.	18.153	17.528	18.725	17.095	17.5211
1.000	.625	58.	18.471	17.846	19.044	17.414	17.8460
1.000	.625	59.	18.789	18.164	19.363	17.733	18.1573
1.000	.625	60.	19.107	18.482	19.681	18.051	18.4820
1.000	.625	61.	19.425	18.800	20.000	18.370	18.7936
1.000	.625	62.	19.744	19.119	20.318	18.688	19.1190
1.000	.625	63.	20.062	19.437	20.637	19.007	19.4308
1.000	.625	64.	20.380	19.755	20.955	19.325	19.7550
1.000	.625	65.	20.698	20.073	21.274	19.644	20.0670
1.000	.625	66.	21.016	20.391	21.593	19.963	20.3910
1.000	.625	67.	21.335	20.710	21.911	20.281	20.7041
1.000	.625	68.	21.653	21.028	22.230	20.600	21.0280
1.000	.625	69.	21.971	21.346	22.548	20.918	21.3403
1.000	.625	70.	22.289	21.664	22.867	21.237	21.6640
1.000	.625	71.	22.607	21.982	23.185	21.555	21.9765
1.000	.625	72.	22.926	22.301	23.504	21.874	22.3010
1.000	.625	73.	23.244	22.619	23.822	22.192	22.6136
1.000	.625	74.	23.562	22.937	24.141	22.511	22.9370
1.000	.625	75.	23.880	23.255	24.459	22.829	23.2498
1.000	.625	76.	24.198	23.573	24.778	23.148	23.5730
1.000	.625	77.	24.517	23.892	25.096	23.466	23.8869
1.000	.625	78.	24.835	24.210	25.415	23.785	24.2100
1.000	.625	79.	25.153	24.528	25.733	24.103	24.5230
1.000	.625	80.	25.471	24.846	26.052	24.422	24.8460
1.000	.625	81.	25.790	25.165	26.370	24.740	25.1602
1.000	.625	82.	26.108	25.483	26.689	25.059	25.4830
1.000	.625	83.	26.426	25.801	27.007	25.377	25.7963

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	84.	26.744	26.119	27.326	25.696	26.1190
1.000	.625	85.	27.063	26.438	27.644	26.014	26.4334
1.000	.625	86.	27.381	26.756	27.962	26.332	26.7560
1.000	.625	87.	27.699	27.074	28.281	26.651	27.0695
1.000	.625	88.	28.017	27.392	28.599	26.969	27.3920
1.000	.625	89.	28.335	27.710	28.918	27.288	27.7056
1.000	.625	90.	28.654	28.029	29.236	27.606	28.0290
1.000	.625	91.	28.972	28.347	29.555	27.925	28.3427
1.000	.625	92.	29.290	28.665	29.873	28.243	28.6650
1.000	.625	93.	29.608	28.983	30.192	28.562	28.9788
1.000	.625	94.	29.927	29.302	30.510	28.880	29.3020
1.000	.625	95.	30.245	29.620	30.828	29.198	29.6159
1.000	.625	96.	30.563	29.938	31.147	29.517	29.9380
1.000	.625	97.	30.881	30.256	31.465	29.835	30.2520
1.000	.625	98.	31.200	30.575	31.784	30.154	30.5750
1.000	.625	99.	31.518	30.893	32.102	30.472	30.8890
1.000	.625	100.	31.836	31.211	32.421	30.791	31.2110
1.000	.625	101.	32.154	31.529	32.739	31.109	31.5251
1.000	.625	102.	32.473	31.848	33.057	31.427	31.8480
1.000	.625	103.	32.791	32.166	33.376	31.746	32.1622
1.000	.625	104.	33.109	32.484	33.694	32.064	32.4840
1.000	.625	105.	33.428	32.803	34.013	32.383	32.7993
1.000	.625	106.	33.746	33.121	34.331	32.701	33.1210
1.000	.625	107.	34.064	33.439	34.649	33.019	33.4353
1.000	.625	108.	34.382	33.757	34.968	33.338	33.7570
1.000	.625	109.	34.701	34.076	35.286	33.656	34.0724
1.000	.625	110.	35.019	34.394	35.605	33.975	34.3940
1.000	.625	111.	35.337	34.712	35.923	34.293	34.7085
1.000	.625	112.	35.655	35.030	36.241	34.611	35.0300
1.000	.625	113.	35.974	35.349	36.560	34.930	35.3455
1.000	.625	114.	36.292	35.667	36.878	35.248	35.6670
1.000	.625	115.	36.610	35.985	37.197	35.567	35.9816
1.000	.625	116.	36.928	36.303	37.515	35.885	36.3030

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	117.	37.247	36.622	37.833	36.203	36.6186
1.000	.625	118.	37.565	36.940	38.152	36.522	36.9400
1.000	.625	119.	37.883	37.258	38.470	36.840	37.2547
1.000	.625	120.	38.202	37.577	38.788	37.158	37.5770
1.000	.625	121.	38.520	37.895	39.107	37.477	37.8918
1.000	.625	122.	38.838	38.213	39.425	37.795	38.2130
1.000	.625	123.	39.156	38.531	39.744	38.114	38.5278
1.000	.625	124.	39.475	38.850	40.062	38.432	38.8500
1.000	.625	125.	39.793	39.168	40.380	38.750	39.1649
1.000	.625	126.	40.111	39.486	40.699	39.069	39.4860
1.000	.625	127.	40.429	39.804	41.017	39.387	39.8009
1.000	.625	128.	40.748	40.123	41.335	39.705	40.1230
1.000	.625	129.	41.066	40.441	41.654	40.024	40.4380
1.000	.625	130.	41.384	40.759	41.972	40.342	40.7590
1.000	.625	131.	41.703	41.078	42.291	40.661	41.0750
1.000	.625	132.	42.021	41.396	42.609	40.979	41.3960
1.000	.625	133.	42.339	41.714	42.927	41.297	41.7110
1.000	.625	134.	42.657	42.032	43.246	41.616	42.0320
1.000	.625	135.	42.976	42.351	43.564	41.934	42.3481
1.000	.625	136.	43.294	42.669	43.882	42.252	42.6690
1.000	.625	137.	43.612	42.987	44.201	42.571	42.9841
1.000	.625	138.	43.931	43.306	44.519	42.889	43.3060
1.000	.625	139.	44.249	43.624	44.838	43.208	43.6212
1.000	.625	140.	44.567	43.942	45.156	43.526	43.9420
1.000	.625	141.	44.885	44.260	45.474	43.844	44.2572
1.000	.625	142.	45.204	44.579	45.793	44.163	44.5790
1.000	.625	143.	45.522	44.897	46.111	44.481	44.8943
1.000	.625	144.	45.840	45.215	46.429	44.799	45.2150
1.000	.625	145.	46.159	45.534	46.748	45.118	45.5313
1.000	.625	146.	46.477	45.852	47.066	45.436	45.8520
1.000	.625	147.	46.795	46.170	47.384	45.754	45.1673
1.000	.625	148.	47.113	46.488	47.703	46.073	46.4880
1.000	.625	149.	47.432	46.807	48.021	46.391	46.8044

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	150.	47.750	47.125	48.340	46.710	47.1250
1.250	.750	8.	3.266	2.516	3.768	1.738	2.5160
1.250	.750	9.	3.655	2.905	4.184	2.154	2.8495
1.250	.750	10.	4.045	3.295	4.597	2.567	3.2950
1.250	.750	11.	4.437	3.687	5.007	2.977	3.6418
1.250	.750	12.	4.830	4.080	5.415	3.385	4.0800
1.250	.750	13.	5.223	4.473	5.821	3.791	4.4349
1.250	.750	14.	5.617	4.867	6.227	4.197	4.8670
1.250	.750	15.	6.012	5.262	6.631	4.601	5.2291
1.250	.750	16.	6.407	5.657	7.034	5.004	5.6570
1.250	.750	17.	6.803	6.053	7.437	5.407	6.0240
1.250	.750	18.	7.198	6.448	7.839	5.809	6.4480
1.250	.750	19.	7.594	6.844	8.241	6.211	6.8181
1.250	.750	20.	7.991	7.241	8.642	6.612	7.2410
1.250	.750	21.	8.387	7.637	9.043	7.013	7.6135
1.250	.750	22.	8.783	8.033	9.444	7.414	8.0330
1.250	.750	23.	9.180	8.430	9.844	7.814	8.4086
1.250	.750	24.	9.577	8.827	10.245	8.215	8.8270
1.250	.750	25.	9.973	9.223	10.645	8.615	9.2033
1.250	.750	26.	10.370	9.620	11.045	9.015	9.6200
1.250	.750	27.	10.767	10.017	11.444	9.414	9.9988
1.250	.750	28.	11.164	10.414	11.844	9.814	10.4140
1.250	.750	29.	11.561	10.811	12.244	10.214	10.7940
1.250	.750	30.	11.958	11.208	12.643	10.613	11.2080
1.250	.750	31.	12.356	11.606	13.042	11.012	11.5901
1.250	.750	32.	12.753	12.003	13.441	11.411	12.0030
1.250	.750	33.	13.150	12.400	13.841	11.811	12.3851
1.250	.750	34.	13.547	12.797	14.240	12.210	12.7970
1.250	.750	35.	13.945	13.195	14.639	12.609	13.1810
1.250	.750	36.	14.342	13.592	15.038	13.008	13.5920
1.250	.750	37.	14.740	13.990	15.436	13.406	13.9767
1.250	.750	38.	15.137	14.387	15.835	13.805	14.3870
1.250	.750	39.	15.534	14.784	16.234	14.204	14.7714



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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.250	.750	40.	15.932	15.182	16.633	14.603	15.1820
1.250	.750	41.	16.329	15.579	17.031	15.001	15.5670
1.250	.750	42.	16.727	15.977	17.430	15.400	15.9770
1.250	.750	43.	17.124	16.374	17.829	15.799	16.3626
1.250	.750	44.	17.522	16.772	18.227	16.197	16.7720
1.250	.750	45.	17.919	17.169	18.626	16.596	17.1581
1.250	.750	46.	18.317	17.567	19.024	16.994	17.5670
1.250	.750	47.	18.715	17.965	19.423	17.393	17.9545
1.250	.750	48.	19.112	18.362	19.821	17.791	18.3620
1.250	.750	49.	19.510	18.760	20.220	18.190	18.7500
1.250	.750	50.	19.907	19.157	20.618	18.588	19.1570
1.250	.750	51.	20.305	19.555	21.017	18.987	19.5454
1.250	.750	52.	20.703	19.953	21.415	19.385	19.9530
1.250	.750	53.	21.100	20.350	21.813	19.783	20.3407
1.250	.750	54.	21.498	20.748	22.212	20.182	20.7480
1.250	.750	55.	21.896	21.146	22.610	20.580	21.1371
1.250	.750	56.	22.293	21.543	23.008	20.978	21.5430
1.250	.750	57.	22.691	21.941	23.407	21.377	21.9324
1.250	.750	58.	23.089	22.339	23.805	21.775	22.3390
1.250	.750	59.	23.486	22.736	24.203	22.173	22.7277
1.250	.750	60.	23.884	23.134	24.601	22.571	23.1340
1.250	.750	61.	24.282	23.532	25.000	22.970	23.5239
1.250	.750	62.	24.680	23.930	25.398	23.368	23.9300
1.250	.750	63.	25.077	24.327	25.796	23.766	24.3192
1.250	.750	64.	25.475	24.725	26.194	24.164	24.7250
1.250	.750	65.	25.873	25.123	26.593	24.563	25.1154
1.250	.750	66.	26.270	25.520	26.991	24.961	25.5200
1.250	.750	67.	26.668	25.918	27.389	25.359	25.9107
1.250	.750	68.	27.066	26.316	27.787	25.757	26.3160
1.250	.750	69.	27.464	26.714	28.185	26.155	26.7069
1.250	.750	70.	27.861	27.111	28.583	26.553	27.1110
1.250	.750	71.	28.259	27.509	28.982	26.952	27.5021
1.250	.750	72.	28.657	27.907	29.380	27.350	27.9070

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.250	.750	73.	29.055	28.305	29.778	27.748	28.2983
1.250	.750	74.	29.453	28.703	30.176	28.146	28.7030
1.250	.750	75.	29.850	29.100	30.574	28.544	29.0935
1.250	.750	76.	30.248	29.498	30.972	28.942	29.4980
1.250	.750	77.	30.646	29.896	31.370	29.340	29.8896
1.250	.750	78.	31.044	30.294	31.768	29.738	30.2940
1.250	.750	79.	31.441	30.691	32.167	30.137	30.6848
1.250	.750	80.	31.839	31.089	32.565	30.535	31.0890
1.250	.750	81.	32.237	31.487	32.963	30.933	31.4809
1.250	.750	82.	32.635	31.885	33.361	31.331	31.8850
1.250	.750	83.	33.033	32.283	33.759	31.729	32.2771
1.250	.750	84.	33.430	32.680	34.157	32.127	32.6800
1.250	.750	85.	33.828	33.078	34.555	32.525	33.0722
1.250	.750	86.	34.226	33.476	34.953	32.923	33.4760
1.250	.750	87.	34.624	33.874	35.351	33.321	33.8684
1.250	.750	88.	35.022	34.272	35.749	33.719	34.2720
1.250	.750	89.	35.419	34.669	36.147	34.117	34.6635
1.250	.750	90.	35.817	65.067	36.545	34.515	35.0670
1.250	.750	91.	36.215	35.465	36.943	34.913	35.4596
1.250	.750	92.	36.613	35.863	37.341	35.311	35.8630
1.250	.750	93.	37.011	36.261	37.739	35.709	36.2557
1.250	.750	94.	37.408	36.658	38.137	36.107	36.6580
1.250	.750	95.	37.806	37.056	36.536	36.506	37.0508
1.250	.750	96.	38.204	37.454	38.934	36.904	37.4540
1.250	.750	97.	38.602	37.852	39.332	37.302	37.8469
1.250	.750	98.	39.000	38.250	39.730	37.700	38.2500
1.250	.750	99.	39.397	38.647	40.128	38.098	38.6420
1.250	.750	100.	39.795	39.045	40.526	38.496	39.0450
1.250	.750	101.	40.193	39.443	40.924	38.894	39.4381
1.250	.750	102.	40.591	39.841	41.322	39.292	39.8410
1.250	.750	103.	40.989	40.239	41.720	39.690	40.2342
1.250	.750	104.	41.387	40.637	42.118	40.088	40.6370
1.250	.750	105.	41.784	41.034	42.516	40.486	41.0293

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.250	.750	106.	42.182	41.432	42.914	40.884	41.4320
1.250	.750	107.	42.580	41.830	43.312	41.282	41.8254
1.250	.750	108.	42.978	42.228	43.710	41.680	42.2280
1.250	.750	109.	43.376	42.626	44.108	42.078	42.6215
1.250	.750	110.	43.774	43.024	44.506	42.476	43.0240
1.250	.750	111.	44.171	43.421	44.904	42.874	43.4166
1.250	.750	112.	44.569	43.819	45.302	43.272	43.8190
1.250	.750	113.	44.967	44.217	45.700	43.670	44.2127
1.250	.750	114.	45.365	44.615	46.098	44.068	44.6150
1.250	.750	115.	45.763	45.013	46.496	44.466	45.0087
1.250	.750	116.	46.161	45.411	46.894	44.864	45.4110
1.250	.750	117.	46.558	45.808	47.292	45.262	45.8038
1.250	.750	118.	46.956	46.206	47.690	45.660	46.2060
1.250	.750	119.	47.354	46.604	48.088	46.058	46.5999
1.250	.750	120.	47.752	47.002	48.486	46.456	47.0020
1.250	.750	121.	48.150	47.400	48.884	46.854	47.3959
1.250	.750	122.	48.548	47.798	49.282	47.252	47.7980
1.250	.750	123.	48.945	48.195	49.680	47.650	48.1910
1.250	.750	124.	49.343	48.593	50.077	48.047	48.5930
1.250	.750	125.	49.741	48.991	50.475	48.445	48.9871
1.250	.750	126.	50.139	49.389	50.873	48.843	49.3890
1.250	.750	127.	50.537	49.787	51.271	49.241	49.7831
1.250	.750	128.	50.935	50.185	51.669	49.639	50.1850
1.250	.750	129.	51.333	50.583	52.067	50.037	50.5792
1.250	.750	130.	51.730	50.980	52.465	50.435	50.9800
1.250	.750	131.	52.128	51.378	52.863	50.833	51.3743
1.250	.750	132.	52.526	51.776	53.261	51.231	51.7760
1.250	.750	133.	52.924	52.174	53.659	51.629	52.1703
1.250	.750	134.	53.322	52.572	54.057	52.027	52.5720
1.250	.750	135.	53.720	52.970	54.455	52.425	52.9664
1.250	.750	136.	54.117	53.367	54.853	52.823	53.3670
1.250	.750	137.	54.515	53.765	55.251	53.221	53.7614
1.250	.750	138.	54.913	54.163	55.649	53.619	54.1630

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.250	.750	139.	55.311	54.561	56.047	54.017	54.5575
1.250	.750	140.	55.709	54.959	56.445	54.415	54.9590
1.250	.750	141.	56.107	55.357	56.843	54.813	55.3535
1.250	.750	142.	56.505	55.755	57.241	55.211	55.7550
1.250	.750	143.	56.902	56.152	57.639	55.609	56.1486
1.250	.750	144.	57.300	56.550	58.037	56.007	56.5500
1.250	.750	145.	57.698	56.948	58.435	56.405	56.9446
1.250	.750	146.	58.096	57.346	58.833	56.803	57.3460
1.250	.750	147.	58.494	57.744	59.231	57.201	57.7407
1.250	.750	148.	58.892	58.142	59.628	57.598	58.1420
1.250	.750	149.	49.290	58.540	60.026	57.996	58.5367
1.250	.750	150.	59.687	58.937	60.424	58.394	58.9370
1.500	.875	8.	3.920	3.045	4.521	2.091	3.0450
1.500	.875	9.	4.386	3.511	5.021	2.591	3.4444
1.500	.875	10.	4.854	3.979	5.517	3.087	3.9790
1.500	.875	11.	5.324	4.449	6.009	3.579	4.3948
1.500	.875	12.	5.796	4.921	6.498	4.068	4.9210
1.500	.875	13.	6.268	5.393	6.986	4.556	5.3473
1.500	.875	14.	6.741	5.866	7.472	5.042	5.8660
1.500	.875	15.	7.215	6.340	7.957	5.527	6.3005
1.500	.875	16.	7.689	6.814	8.441	6.011	6.8140
1.500	.875	17.	8.163	7.288	8.924	6.494	7.2532
1.500	.875	18.	8.638	7.763	9.407	6.977	7.7630
1.500	.875	19.	9.113	8.238	9.889	7.459	8.2069
1.500	.875	20.	9.589	8.714	10.371	7.941	8.7140
1.500	.875	21.	10.064	9.189	10.852	8.422	9.1609
1.500	.875	22.	10.540	9.665	11.333	8.903	9.6650
1.500	.875	23.	11.016	10.141	11.813	9.383	10.1153
1.500	.875	24.	11.492	10.617	12.294	9.864	10.6170
1.500	.875	25.	11.968	11.093	12.774	10.344	11.0694
1.500	.875	26.	12.444	11.569	13.254	10.824	11.5690
1.500	.875	27.	12.921	12.046	13.733	11.303	12.0241
1.500	.875	28.	13.397	12.522	14.213	11.783	12.5220

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	29.	13.874	12.999	14.692	12.262	12.9787
1.500	.875	30.	14.350	13.475	15.172	12.742	13.4750
1.500	.875	31.	14.827	13.952	15.651	13.221	13.9330
1.500	.875	32.	15.303	14.428	16.130	13.700	14.4280
1.500	.875	33.	15.780	14.905	16.609	14.179	14.8871
1.500	.875	34.	16.257	15.382	17.088	14.658	15.3820
1.500	.875	35.	16.734	15.859	17.566	15.136	15.8421
1.500	.875	36.	17.211	16.336	18.045	15.615	16.3360
1.500	.875	37.	17.687	16.812	18.524	16.094	16.7961
1.500	.875	38.	18.164	17.289	19.002	16.572	17.2890
1.500	.875	39.	18.641	17.766	19.481	17.051	17.7509
1.500	.875	40.	19.118	18.243	19.959	17.529	18.2430
1.500	.875	41.	19.595	18.720	20.438	18.008	18.7056
1.500	.875	42.	20.072	19.197	20.916	18.486	19.1970
1.500	.875	43.	20.549	19.674	21.394	18.964	19.6603
1.500	.875	44.	21.026	20.151	21.873	19.443	20.1510
1.500	.875	45.	21.503	20.628	22.351	19.921	20.6149
1.500	.875	46.	21.980	21.105	22.829	20.399	21.1050
1.500	.875	47.	22.458	21.583	23.307	20.877	21.5705
1.500	.875	48.	22.935	22.060	23.786	21.356	22.0600
1.500	.875	49.	23.412	22.537	24.264	21.834	22.5250
1.500	.875	50.	23.889	23.014	24.742	22.312	23.0140
1.500	.875	51.	24.366	23.491	25.220	22.790	23.4794
1.500	.875	52.	24.843	23.968	25.698	23.268	23.9680
1.500	.875	53.	25.320	24.445	26.176	23.746	24.4339
1.500	.875	54.	25.798	24.923	26.654	24.224	24.9230
1.500	.875	55.	26.275	25.400	27.132	24.702	25.3893
1.500	.875	56.	26.752	25.877	27.610	25.180	25.8770
1.500	.875	57.	27.229	26.354	28.088	25.658	26.3437
1.500	.875	58.	27.707	26.832	28.566	26.136	26.8320
1.500	.875	59.	28.184	27.309	29.044	26.614	27.2990
1.500	.875	60.	28.661	27.786	29.522	27.092	27.7860
1.500	.875	61.	29.138	28.263	30.000	27.570	28.2533

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	62.	29.615	28.740	30.477	28.047	28.7400
1.500	.875	63.	30.093	29.218	30.955	28.525	29.2086
1.500	.875	64.	30.570	29.695	31.433	29.003	29.6950
1.500	.875	65.	31.047	30.172	31.911	29.481	30.1629
1.500	.875	66.	31.525	30.650	32.389	29.959	30.6500
1.500	.875	67.	32.002	31.127	32.867	30.437	31.1182
1.500	.875	68.	32.479	31.604	33.345	30.915	31.6040
1.500	.875	69.	32.956	32.081	33.822	31.392	32.0725
1.500	.875	70.	33.434	32.559	34.300	31.870	32.5590
1.500	.875	71.	33.911	33.036	34.778	32.348	33.0277
1.500	.875	72.	34.388	33.513	35.256	32.826	33.5130
1.500	.875	73.	34.866	33.991	35.733	33.303	33.9829
1.500	.875	74.	35.343	34.468	36.211	33.781	34.4680
1.500	.875	75.	35.820	34.945	36.689	34.259	34.9371
1.500	.875	76.	36.298	35.423	37.167	34.737	35.4230
1.500	.875	77.	36.775	35.900	37.644	35.214	35.8923
1.500	.875	78.	37.252	36.377	38.122	35.692	36.3770
1.500	.875	79.	37.730	36.855	38.600	36.170	36.8475
1.500	.875	80.	38.207	37.332	39.078	36.648	37.3320
1.500	.875	81.	38.684	37.809	39.555	37.125	37.8017
1.500	.875	82.	39.162	38.287	40.033	37.603	38.2870
1.500	.875	83.	39.639	38.764	40.511	38.081	38.7569
1.500	.875	84.	40.116	39.241	40.988	38.558	39.2410
1.500	.875	85.	40.594	39.719	41.466	39.036	39.7121
1.500	.875	86.	41.071	40.196	41.944	39.514	40.1960
1.500	.875	87.	41.548	40.673	42.421	39.991	40.6662
1.500	.875	88.	42.026	41.151	42.899	40.469	41.1510
1.500	.875	89.	42.503	41.628	43.377	40.947	41.6214
1.500	.875	90.	42.981	42.106	43.854	41.424	42.1060
1.500	.875	91.	43.458	42.583	44.332	41.902	42.5765
1.500	.875	92.	43.935	43.060	44.810	42.380	43.0600
1.500	.875	93.	44.413	43.538	45.287	42.857	43.5317
1.500	.875	94.	44.890	44.015	45.765	43.335	44.0150

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	95.	45.367	44.492	46.243	43.813	44.4858
1.500	.875	96.	45.845	44.970	46.720	44.290	44.9700
1.500	.875	97.	46.322	45.447	47.198	44.768	45.4409
1.500	.875	98.	46.800	45.925	47.676	45.246	45.9250
1.500	.875	99.	47.277	46.402	48.153	45.723	46.3960
1.500	.875	100.	47.754	46.879	48.631	46.201	46.8790
1.500	.875	101.	48.232	47.357	49.108	46.678	47.3512
1.500	.875	102.	48.709	47.834	49.586	47.156	47.8340
1.500	.875	103.	49.187	48.312	50.064	47.634	48.3063
1.500	.875	104.	49.664	48.789	50.541	48.111	48.7890
1.500	.875	105.	50.141	49.266	51.019	48.589	49.2604
1.500	.875	106.	50.619	49.744	51.496	49.066	49.7440
1.500	.875	107.	51.096	50.221	51.974	49.544	50.2155
1.500	.875	108.	51.573	50.698	52.452	50.022	50.6980
1.500	.875	109.	52.051	51.176	52.929	50.499	51.1706
1.500	.875	110.	52.528	51.653	53.407	50.977	51.6530
1.500	.875	111.	53.006	52.131	53.884	51.454	52.1257
1.500	.875	112.	53.483	52.608	54.362	51.932	52.6080
1.500	.875	113.	53.960	53.085	54.840	52.410	53.0798
1.500	.875	114.	54.438	53.563	55.317	52.887	53.5630
1.500	.875	115.	54.915	54.040	55.795	53.365	54.0349
1.500	.875	116.	55.393	54.518	56.272	53.842	54.5180
1.500	.875	117.	55.870	54.995	56.750	54.320	54.9900
1.500	.875	118.	56.348	55.473	57.228	54.798	55.4730
1.500	.875	119.	56.825	55.950	57.705	55.275	55.9450
1.500	.875	120.	57.302	56.427	58.183	55.753	56.4270
1.500	.875	121.	57.780	56.905	58.660	56.230	56.9001
1.500	.875	122.	58.257	57.382	59.138	56.708	57.3820
1.500	.875	123.	58.735	57.860	59.615	57.185	57.8552
1.500	.875	124.	59.212	58.337	60.093	57.665	58.3370
1.500	.875	125.	59.689	58.814	60.571	58.141	58.8093
1.500	.875	126.	60.167	59.292	61.048	58.618	59.2920
1.500	.875	127.	60.644	59.769	61.526	59.096	59.7644

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	128.	61.122	60.247	62.003	59.573	60.2470
1.500	.875	129.	61.599	60.724	62.481	60.051	60.7194
1.500	.875	130.	62.076	61.201	62.958	60.528	61.2010
1.500	.875	131.	62.554	61.679	63.436	61.006	61.6745
1.500	.875	132.	63.031	62.136	63.913	61.483	62.1560
1.500	.875	133.	63.509	62.634	64.391	61.961	62.6296
1.500	.875	134.	63.986	63.111	64.869	62.439	63.1110
1.500	.875	135.	64.464	63.589	65.346	62.916	63.5846
1.500	.875	136.	64.941	64.066	65.824	63.394	64.0660
1.500	.875	137.	65.418	64.543	66.301	63.871	64.5387
1.500	.875	138.	65.856	65.021	66.779	64.349	65.0210
1.500	.875	139.	66.373	65.498	67.256	64.826	65.4938
1.500	.875	140.	66.851	65.976	67.734	65.304	65.9760
1.500	.875	141.	67.328	66.453	68.211	65.781	66.4488
1.500	.875	142.	67.806	66.931	68.689	66.259	66.9310
1.500	.875	143.	68.263	67.408	69.166	66.736	67.4039
1.500	.875	144.	68.760	67.885	69.644	67.214	67.8850
1.500	.875	145.	69.238	68.363	70.122	67.692	68.3589
1.500	.875	146.	69.715	68.840	70.599	68.169	68.8400
1.500	.875	147.	70.093	69.818	71.077	68.647	69.3140
1.500	.875	148.	70.673	69.705	71.554	69.124	69.7950
1.500	.875	149.	71.148	70.273	72.032	69.602	70.2690
1.500	.875	150.	71.625	70.750	72.509	70.079	70.7500
1.750	1.000	8.	4.573	3.573	5.275	2.445	3.5730
1.750	1.000	9.	5.117	4.117	5.858	3.028	4.0393
1.750	1.000	10.	5.663	4.663	6.436	3.606	4.6630
1.750	1.000	11.	6.212	5.212	7.010	4.180	5.1488
1.750	1.000	12.	6.761	5.761	7.581	4.751	5.7610
1.750	1.000	13.	7.313	6.313	8.150	5.320	6.2597
1.750	1.000	14.	7.864	6.864	8.717	5.887	6.8640
1.750	1.000	15.	8.417	7.417	9.283	6.453	7.3709
1.750	1.000	16.	8.970	7.970	9.848	7.018	7.9700
1.750	1.000	17.	9.524	8.524	10.412	7.582	8.4834



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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.750	1.000	18.	10.078	9.078	10.975	8.145	9.0780
1.750	1.000	19.	10.632	9.632	11.537	8.707	9.5957
1.750	1.000	20.	11.187	10.187	12.099	9.269	10.1870
1.750	1.000	21.	11.742	10.742	12.660	9.830	10.7092
1.750	1.000	22.	12.297	11.297	13.222	10.392	11.2970
1.750	1.000	23.	12.852	11.852	13.782	10.952	11.8220
1.750	1.000	24.	13.407	12.407	14.343	11.513	12.4070
1.750	1.000	25.	13.963	12.963	14.903	12.073	12.9354
1.750	1.000	26.	14.518	13.518	15.463	12.633	13.5180
1.750	1.000	27.	15.074	14.074	16.022	13.192	14.0485
1.750	1.000	28.	15.630	14.630	16.582	13.752	14.6300
1.750	1.000	29.	16.186	15.186	17.141	14.311	15.1623
1.750	1.000	30.	16.742	15.742	17.700	14.870	15.7420
1.750	1.000	31.	17.298	16.298	18.259	15.429	16.2758
1.750	1.000	32.	17.854	16.854	18.818	15.988	16.8540
1.750	1.000	33.	18.410	17.410	19.377	16.547	17.3891
1.750	1.000	34.	18.966	17.966	19.935	17.105	17.9660
1.750	1.000	35.	19.523	18.523	20.494	17.664	18.5033
1.750	1.000	36.	20.079	19.079	21.053	18.223	19.0790
1.750	1.000	37.	20.635	19.635	21.611	18.781	19.6164
1.750	1.000	38.	21.192	20.192	22.169	19.339	20.1920
1.750	1.000	39.	21.748	20.748	22.728	19.898	20.7304
1.750	1.000	40.	22.305	21.305	23.286	20.456	21.3050
1.750	1.000	41.	22.861	21.861	23.844	21.014	21.8442
1.750	1.000	42.	23.418	22.418	24.402	21.572	22.4180
1.750	1.000	43.	23.974	22.974	24.960	22.130	22.9580
1.750	1.000	44.	24.531	23.531	25.518	22.688	23.5310
1.750	1.000	45.	25.087	24.087	26.076	23.246	24.0717
1.750	1.000	46.	25.644	24.644	26.634	23.804	24.6440
1.750	1.000	47.	26.200	25.200	27.192	24.362	25.1854
1.750	1.000	48.	26.757	25.757	27.750	24.920	25.7570
1.750	1.000	49.	27.314	26.314	28.308	25.478	26.3000
1.750	1.000	50.	27.870	26.870	28.865	26.035	26.8700

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.750	1.000	51.	28.427	27.427	29.423	26.593	27.4135
1.750	1.000	52.	28.984	27.984	29.981	27.151	27.9840
1.750	1.000	53.	29.541	28.541	30.539	27.709	28.5280
1.750	1.000	54.	30.097	29.097	31.096	28.266	29.0970
1.750	1.000	55.	30.654	29.654	31.654	28.824	29.6415
1.750	1.000	56.	31.211	30.211	32.212	29.382	30.2110
1.750	1.000	57.	31.767	30.767	32.769	29.939	30.7549
1.750	1.000	58.	32.324	31.324	33.327	30.497	31.3240
1.750	1.000	59.	32.881	31.881	33.884	31.054	31.8693
1.750	1.000	60.	33.438	32.438	34.442	31.612	32.4380
1.750	1.000	61.	33.995	32.995	35.000	32.170	32.9837
1.750	1.000	62.	34.551	33.551	35.557	32.727	33.5510
1.750	1.000	63.	35.108	34.108	36.115	33.285	34.0971
1.750	1.000	64.	35.665	34.665	36.672	33.842	34.6650
1.750	1.000	65.	36.222	35.222	37.230	34.400	35.2114
1.750	1.000	66.	36.779	35.779	37.787	34.957	35.7790
1.750	1.000	67.	37.336	36.336	38.344	35.514	36.3257
1.750	1.000	68.	37.892	36.892	38.902	36.072	36.8920
1.750	1.000	69.	38.449	37.449	39.459	36.629	37.4390
1.750	1.000	70.	39.006	38.006	40.017	37.187	38.0060
1.750	1.000	71.	39.563	38.563	40.574	37.744	38.5533
1.750	1.000	72.	40.120	39.120	41.132	38.302	39.1200
1.750	1.000	73.	40.677	39.677	41.689	38.859	39.6676
1.750	1.000	74.	41.234	40.234	42.246	39.416	40.2340
1.750	1.000	75.	41.790	40.790	42.804	39.974	40.7808
1.750	1.000	76.	42.347	41.347	43.361	40.531	41.3470
1.750	1.000	77.	42.904	41.904	43.918	41.088	41.8951
1.750	1.000	78.	43.461	42.461	44.476	41.646	42.4610
1.750	1.000	79.	44.018	43.018	45.033	42.203	43.0093
1.750	1.000	80.	44.575	43.575	45.590	42.760	43.5750
1.750	1.000	81.	45.132	44.132	46.148	43.318	44.1235
1.750	1.000	82.	45.689	44.689	46.705	43.875	44.6890
1.750	1.000	83.	46.246	45.246	47.262	44.432	45.2377

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
1.750	1.000	84.	46.802	45.802	47.820	44.990	45.8020
1.750	1.000	85.	47.359	46.359	48.377	45.547	46.3509
1.750	1.000	86.	47.916	46.916	48.934	46.104	46.9160
1.750	1.000	87.	48.473	47.473	49.492	46.662	47.4651
1.750	1.000	88.	49.030	48.030	50.049	47.219	48.0300
1.750	1.000	89.	49.587	48.587	50.606	47.776	48.5793
1.750	1.000	90.	50.144	49.144	51.163	48.333	49.1440
1.750	1.000	91.	50.701	49.701	51.721	48.891	49.6934
1.750	1.000	92.	51.258	50.258	52.278	49.448	50.2580
1.750	1.000	93.	51.815	50.815	52.835	50.005	50.8076
1.750	1.000	94.	52.372	51.372	53.392	50.562	51.3720
1.750	1.000	95.	52.929	51.929	53.950	51.120	51.9218
1.750	1.000	96.	53.486	52.486	54.507	51.677	52.4860
1.750	1.000	97.	54.043	53.043	55.064	52.234	53.0359
1.750	1.000	98.	54.600	53.600	55.621	52.791	53.6000
1.750	1.000	99.	55.156	54.156	56.179	53.349	54.1491
1.750	1.000	100.	55.713	54.713	56.736	53.906	54.7130
2.000	1.125	8.	5.226	4.101	6.028	2.798	4.1010
2.000	1.125	9.	5.848	4.723	6.695	3.465	4.6342
2.000	1.125	10.	6.472	5.347	7.355	4.125	5.3470
2.000	1.125	11.	7.099	5.974	8.011	4.781	5.9017
2.000	1.125	12.	7.727	6.602	8.664	5.434	6.6020
2.000	1.125	13.	8.357	7.232	9.314	6.084	7.1711
2.000	1.125	14.	8.988	7.863	9.963	6.733	7.8630
2.000	1.125	15.	9.619	8.494	10.609	7.379	8.4413
2.000	1.125	16.	10.252	9.127	11.255	8.025	9.1270
2.000	1.125	17.	10.884	9.759	11.899	8.669	9.7126
2.000	1.125	18.	11.518	10.393	12.543	9.313	10.3930
2.000	1.125	19.	12.151	11.026	13.185	9.955	10.9845
2.000	1.125	20.	12.785	11.660	13.828	10.598	11.6600
2.000	1.125	21.	13.419	12.294	14.469	11.239	12.2565
2.000	1.125	22.	14.053	12.928	15.110	11.880	12.9280
2.000	1.125	23.	14.688	13.563	15.751	12.521	13.5288

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	24.	15.323	14.198	16.392	13.162	14.1980
2.000	1.125	25.	15.957	14.832	17.032	13.802	14.8005
2.000	1.125	26.	16.592	15.467	17.671	14.441	15.4670
2.000	1.125	27.	17.228	16.103	18.311	15.081	16.0739
2.000	1.125	28.	17.863	16.738	18.950	15.720	16.7380
2.000	1.125	29.	18.498	17.373	19.590	16.360	17.3459
2.000	1.125	30.	19.134	18.009	20.229	16.999	18.0090
2.000	1.125	31.	19.769	18.644	20.868	17.638	18.6186
2.000	1.125	32.	20.405	19.280	21.506	18.276	19.2800
2.000	1.125	33.	21.040	19.915	22.145	18.915	19.8912
2.000	1.125	34.	21.676	20.551	22.783	19.553	20.5510
2.000	1.125	35.	22.312	21.187	23.422	20.192	21.1645
2.000	1.125	36.	22.947	21.822	24.060	20.830	21.8220
2.000	1.125	37.	23.583	22.458	24.698	21.468	22.4368
2.000	1.125	38.	24.219	23.094	25.336	22.106	23.0940
2.000	1.125	39.	24.855	23.730	25.974	22.744	23.7098
2.000	1.125	40.	25.491	24.366	26.612	23.382	24.3660
2.000	1.125	41.	26.127	25.002	27.250	24.020	24.9828
2.000	1.125	42.	26.763	25.638	27.888	24.658	25.6380
2.000	1.125	43.	27.399	26.274	28.526	25.296	26.2557
2.000	1.125	44.	28.035	26.910	29.164	25.934	26.9100
2.000	1.125	45.	28.671	27.546	29.801	26.571	27.5285
2.000	1.125	46.	29.307	28.182	30.439	27.209	28.1820
2.000	1.125	47.	29.943	28.818	31.077	27.847	28.8013
2.000	1.125	48.	30.580	29.455	31.714	28.484	29.4550
2.000	1.125	49.	31.216	30.091	32.352	29.122	30.0750
2.000	1.125	50.	31.852	30.727	32.989	29.759	30.7270
2.000	1.125	51.	32.488	31.363	33.627	30.397	31.3476
2.000	1.125	52.	33.124	31.999	34.264	31.034	31.9990
2.000	1.125	53.	33.761	32.636	34.901	31.671	32.6212
2.000	1.125	54.	34.397	33.272	35.539	32.309	33.2720
2.000	1.125	55.	35.033	33.908	36.176	32.946	33.8937
2.000	1.125	56.	35.669	34.544	36.813	33.583	34.5440

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	57.	36.306	35.181	37.451	34.221	35.1672
2.000	1.125	58.	36.942	35.817	38.088	34.858	35.8170
2.000	1.125	59.	37.578	36.453	38.725	35.495	36.4397
2.000	1.125	60.	38.215	37.090	39.362	36.132	37.0900
2.000	1.125	61.	38.851	37.726	39.999	36.769	37.7131
2.000	1.125	62.	39.487	38.362	40.637	37.407	38.3620
2.000	1.125	63.	40.124	38.999	41.274	38.044	38.9865
2.000	1.125	64.	40.760	39.635	41.911	38.681	39.6350
2.000	1.125	65.	41.396	40.271	42.548	39.318	40.2589
2.000	1.125	66.	42.033	40.908	43.185	39.955	40.9080
2.000	1.125	67.	42.669	41.544	43.822	40.592	41.5323
2.000	1.125	68.	43.306	42.181	44.459	41.229	42.1810
2.000	1.125	69.	43.942	42.817	45.096	41.866	42.8056
2.000	1.125	70.	44.578	43.453	45.733	42.503	43.4530
2.000	1.125	71.	45.215	44.090	46.371	43.141	44.0789
2.000	1.125	72.	45.851	44.726	47.008	43.778	44.7260
2.000	1.125	73.	46.488	45.363	47.645	44.415	45.3522
2.000	1.125	74.	47.124	45.999	48.282	45.052	45.9990
2.000	1.125	75.	47.760	46.635	48.919	45.689	46.6245
2.000	1.125	76.	48.397	47.272	49.556	46.326	47.2720
2.000	1.125	77.	49.033	47.908	50.193	46.963	47.8978
2.000	1.125	78.	49.670	48.545	50.829	47.599	48.5450
2.000	1.125	79.	50.306	49.181	51.466	48.236	49.1711
2.000	1.125	80.	50.943	49.818	52.103	48.873	49.8180
2.000	1.125	81.	51.579	50.454	52.740	49.510	50.4443
2.000	1.125	82.	52.216	51.091	53.377	50.147	51.0910
2.000	1.125	83.	52.852	51.727	54.014	50.784	51.7175
2.000	1.125	84.	53.489	52.364	54.651	51.421	52.3640
2.000	1.125	85.	54.125	53.000	55.288	52.058	52.9908
2.000	1.125	86.	54.761	53.636	55.925	52.695	53.6360
2.000	1.125	87.	55.398	54.273	56.562	53.332	54.2640
2.000	1.125	88.	56.034	54.909	57.199	53.969	54.9090
2.000	1.125	89.	56.671	55.546	57.836	54.606	55.5372

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	90.	57.307	56.182	58.473	55.243	56.1820
2.000	1.125	91.	57.944	56.819	59.109	55.879	56.8104
2.000	1.125	92.	58.580	57.455	59.746	56.516	57.4550
2.000	1.125	93.	59.217	58.092	60.383	57.153	58.0836
2.000	1.125	94.	59.853	58.728	61.020	57.790	58.7280
2.000	1.125	95.	60.490	59.365	61.657	58.427	59.3567
2.000	1.125	96.	61.126	60.001	62.294	59.064	60.0010
2.000	1.125	97.	61.763	60.638	62.931	59.701	60.6299
2.000	1.125	98.	62.399	61.274	63.567	60.337	61.2740
2.000	1.125	99.	63.036	61.911	64.204	60.974	61.9031
2.000	1.125	100.	63.672	62.547	64.841	61.611	62.5470
2.250	1.406	8.	5.880	4.474	6.782	3.152	4.4740
2.250	1.406	9.	6.579	5.173	7.532	3.902	5.0731
2.250	1.406	10.	7.281	5.875	8.275	4.645	5.8750
2.250	1.406	11.	7.986	6.580	9.013	5.383	6.4987
2.250	1.406	12.	8.693	7.287	9.747	6.117	7.2870
2.250	1.406	13.	9.402	7.996	10.479	6.849	7.9274
2.250	1.406	14.	10.111	8.705	11.208	7.578	8.7050
2.250	1.406	15.	10.822	9.416	11.935	8.305	9.3567
2.250	1.406	16.	11.533	10.127	12.661	9.031	10.1270
2.250	1.406	17.	12.245	10.839	13.386	9.756	10.7868
2.250	1.406	18.	12.957	11.551	14.110	10.480	11.5510
2.250	1.406	19.	13.670	12.264	14.834	11.204	12.2173
2.250	1.406	20.	14.383	12.977	15.556	11.926	12.9770
2.250	1.406	21.	15.096	13.690	16.278	12.648	13.6478
2.250	1.406	22.	15.810	14.404	16.999	13.369	14.4040
2.250	1.406	23.	16.524	15.118	17.720	14.090	15.0795
2.250	1.406	24.	17.238	15.832	18.440	14.810	15.8320
2.250	1.406	25.	17.952	16.546	19.161	15.531	16.5106
2.250	1.406	26.	18.667	17.261	19.880	16.250	17.2610
2.250	1.406	27.	19.381	17.975	20.600	16.970	17.9422
2.250	1.406	28.	20.096	18.690	21.319	17.689	18.6900
2.250	1.406	29.	20.810	19.404	22.038	18.408	19.3735

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.250	1.406	30.	21.525	20.119	22.757	19.127	20.1190
2.250	1.406	31.	22.240	20.834	23.476	19.846	20.8055
2.250	1.406	32.	22.955	21.549	24.195	20.565	21.5490
2.250	1.406	33.	23.670	22.264	24.913	21.283	22.2372
2.250	1.406	34.	24.385	22.979	25.631	22.001	22.9790
2.250	1.406	35.	25.101	23.695	26.350	22.720	23.6697
2.250	1.406	36.	25.816	24.410	27.068	23.438	24.4100
2.250	1.406	37.	26.531	25.125	27.786	24.156	25.1011
2.250	1.406	38.	27.247	25.841	28.503	24.873	25.8410
2.250	1.406	39.	27.962	26.556	29.221	25.591	26.5333
2.250	1.406	40.	28.677	27.271	29.939	26.309	27.2710
2.250	1.406	41.	29.393	27.987	30.657	27.027	27.9654
2.250	1.406	42.	30.108	28.702	31.374	27.744	28.7020
2.250	1.406	43.	30.824	29.418	32.092	28.462	29.3974
2.250	1.406	44.	31.539	30.133	32.809	29.179	30.1330
2.250	1.406	45.	32.255	30.849	33.526	29.896	30.8294
2.250	1.406	46.	32.971	31.565	34.244	30.614	31.5650
2.250	1.406	47.	33.686	32.280	34.961	31.331	32.2612
2.250	1.406	48.	34.402	32.996	35.678	32.048	32.9960
2.250	1.406	49.	35.118	33.712	36.396	32.766	33.6940
2.250	1.406	50.	35.833	34.427	37.113	33.483	34.4270
2.250	1.406	51.	36.549	35.143	37.830	34.200	35.1257
2.250	1.406	52.	37.265	35.859	38.547	34.917	35.8590
2.250	1.406	53.	37.981	36.575	39.264	35.634	36.5583
2.250	1.406	54.	38.696	37.290	39.981	36.351	37.2900
2.250	1.406	55.	39.412	38.006	40.698	37.068	37.9899
2.250	1.406	56.	40.128	38.722	41.415	37.785	38.7220
2.250	1.406	57.	40.844	39.438	42.132	38.502	39.4225
2.250	1.406	58.	41.560	40.154	42.849	39.219	40.1540
2.250	1.406	59.	42.276	40.870	43.566	39.936	40.8550
2.250	1.406	60.	42.991	41.585	44.283	40.653	41.5850
2.250	1.406	61.	43.707	42.301	44.999	41.369	42.2865
2.250	1.406	62.	44.423	43.017	45.716	42.086	43.0170

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.250	1.406	63.	45.139	43.733	46.433	42.803	43.7190
2.250	1.406	64.	45.855	44.449	47.150	43.520	44.4490
2.250	1.406	65.	46.571	45.165	47.867	44.237	45.1514
2.250	1.406	66.	47.287	45.881	48.583	44.953	45.8810
2.250	1.406	67.	48.003	46.597	49.300	45.670	46.5838
2.250	1.406	68.	48.719	47.313	50.017	46.387	47.3130
2.250	1.406	69.	49.435	48.029	50.733	47.103	48.0162
2.250	1.406	70.	50.151	48.745	51.450	47.820	48.7450
2.250	1.406	71.	50.867	49.461	52.167	48.537	49.4486
2.250	1.406	72.	51.583	50.177	52.883	49.253	50.1770
2.250	1.406	73.	52.299	50.893	53.600	49.970	50.8809
2.250	1.406	74.	53.015	51.609	54.317	50.687	51.6090
2.250	1.406	75.	53.731	52.325	55.033	51.403	52.3132
2.250	1.406	76.	54.446	53.040	55.750	52.120	53.0400
2.250	1.406	77.	55.162	53.756	56.467	52.837	53.7445
2.250	1.406	78.	55.878	54.472	57.183	53.553	54.4720
2.250	1.406	79.	56.595	55.189	57.900	54.270	55.1778
2.250	1.406	80.	57.311	55.905	58.616	54.986	55.9050
2.250	1.406	81.	58.027	56.621	59.333	55.703	56.6101
2.250	1.406	82.	58.743	57.337	60.049	56.419	57.3370
2.250	1.406	83.	59.459	58.053	60.766	57.136	58.0424
2.250	1.406	84.	60.175	58.769	61.483	57.853	58.7690
2.250	1.406	85.	60.891	59.485	62.199	58.569	59.4746
2.250	1.406	86.	61.607	60.201	62.916	59.286	60.2010
2.250	1.406	87.	62.323	60.917	63.632	60.002	60.9068
2.250	1.406	88.	63.039	61.633	64.349	60.719	61.6330
2.250	1.406	89.	63.755	62.349	65.065	61.435	62.3391
2.250	1.406	90.	64.471	63.065	65.782	62.152	63.0650
2.250	1.406	91.	65.187	63.781	66.498	62.868	63.7713
2.250	1.406	92.	65.903	64.497	67.215	63.585	64.4970
2.250	1.406	93.	66.619	65.213	67.931	64.301	65.2035
2.250	1.406	94.	67.335	65.929	68.647	65.017	65.9290
2.250	1.406	95.	68.051	66.645	69.364	65.734	66.6357



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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.250	1.406	96.	68.767	67.361	70.080	66.450	67.3610
2.250	1.406	97.	69.483	68.077	70.797	67.137	68.0679
2.250	1.406	98.	70.199	68.793	71.513	67.883	68.7930
2.250	1.406	99.	70.915	69.509	72.230	68.600	69.5001
2.250	1.406	100.	71.632	70.226	72.946	69.316	70.2260
2.500	1.562	8.	6.533	4.971	7.536	3.506	4.9710
2.500	1.562	9.	7.310	5.748	8.369	4.339	5.6369
2.500	1.562	10.	8.090	6.528	9.194	5.164	6.5280
2.500	1.562	11.	8.874	7.312	10.014	5.984	7.2217
2.500	1.562	12.	9.659	8.097	10.830	6.800	8.0970
2.500	1.562	13.	10.446	8.884	11.643	7.613	8.8078
2.500	1.562	14.	11.235	9.673	12.453	8.423	9.6730
2.500	1.562	15.	12.024	10.462	13.262	9.232	10.3961
2.500	1.562	16.	12.815	11.253	14.068	10.038	11.2530
2.500	1.562	17.	13.605	12.043	14.874	10.844	11.9850
2.500	1.562	18.	14.397	12.835	15.678	11.648	12.8350
2.500	1.562	19.	15.189	13.627	16.482	12.452	13.5751
2.500	1.562	20.	15.981	14.419	17.284	13.254	14.4190
2.500	1.562	21.	16.774	15.212	18.086	14.056	15.1651
2.500	1.562	22.	17.567	16.005	18.888	14.858	16.0050
2.500	1.562	23.	18.360	16.798	19.689	15.659	16.7552
2.500	1.562	24.	19.153	17.591	20.489	16.459	17.5910
2.500	1.562	25.	19.947	18.385	21.290	17.260	18.3456
2.500	1.562	26.	20.741	19.179	22.089	18.059	19.1790
2.500	1.562	27.	21.534	19.972	22.889	18.859	19.9356
2.500	1.562	28.	22.329	20.767	23.688	19.658	20.7670
2.500	1.562	29.	23.123	21.561	24.487	20.457	21.5271
2.500	1.562	30.	23.917	22.355	25.286	21.256	22.3550
2.500	1.562	31.	24.711	23.149	26.085	22.055	23.1173
2.500	1.562	32.	25.506	23.944	26.883	22.853	23.9440
2.500	1.562	33.	26.300	24.738	27.681	23.651	24.7082
2.500	1.562	34.	27.095	25.533	28.479	24.449	25.5330
2.500	1.562	35.	27.890	26.328	29.277	25.247	26.2999

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.562	36.	28.684	27.122	30.075	26.045	27.1220
2.500	1.562	37.	29.479	27.917	30.873	26.843	27.8904
2.500	1.562	38.	30.274	28.712	31.671	27.641	28.7120
2.500	1.562	39.	31.069	29.507	32.468	28.438	29.4818
2.500	1.562	40.	31.864	30.302	33.266	29.236	30.3020
2.500	1.562	41.	32.659	31.097	34.063	30.033	31.0730
2.500	1.562	42.	33.454	31.892	34.860	30.830	31.8920
2.500	1.562	43.	34.249	32.687	35.657	31.627	32.6642
2.500	1.562	44.	35.044	33.482	36.455	32.425	33.4820
2.500	1.562	45.	35.839	34.277	37.252	33.222	34.2552
2.500	1.562	46.	36.634	35.072	38.049	34.019	35.0720
2.500	1.562	47.	37.429	35.867	38.846	34.816	35.8461
2.500	1.562	48.	38.224	36.662	39.643	35.613	36.6620
2.500	1.562	49.	39.020	37.458	40.440	36.410	37.4380
2.500	1.562	50.	39.815	38.253	41.236	37.206	38.2530
2.500	1.562	51.	40.610	39.048	42.033	38.003	39.0287
2.500	1.562	52.	41.405	39.843	42.830	38.800	39.8430
2.500	1.562	53.	42.201	40.639	43.627	39.597	40.6205
2.500	1.562	54.	42.996	41.434	44.423	40.393	41.4340
2.500	1.562	55.	43.791	42.229	45.220	41.190	42.2111
2.500	1.562	56.	44.587	43.025	46.017	41.987	43.0250
2.500	1.562	57.	45.382	43.820	46.813	42.783	43.8028
2.500	1.562	58.	46.178	44.616	47.610	43.580	44.6160
2.500	1.562	59.	46.973	45.411	48.406	44.376	45.3944
2.500	1.562	60.	47.768	46.206	49.203	45.173	46.2060
2.500	1.562	61.	48.564	47.002	49.999	45.969	46.9859
2.500	1.562	62.	49.359	47.797	50.796	46.766	47.7970
2.500	1.562	63.	50.155	48.593	51.592	47.562	48.5774
2.500	1.562	64.	50.950	49.388	52.389	48.359	49.3880
2.500	1.562	65.	51.746	50.184	53.185	49.155	50.1689
2.500	1.562	66.	52.541	50.979	53.981	49.951	50.9790
2.500	1.562	67.	53.336	51.774	54.778	50.748	51.7593
2.500	1.562	68.	54.132	52.570	55.574	51.544	52.5700

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.562	69.	54.927	53.365	56.371	52.341	53.3508
2.500	1.562	70.	55.723	54.161	57.167	53.137	54.1610
2.500	1.562	71.	56.518	54.956	57.963	53.933	54.9422
2.500	1.562	72.	57.314	55.752	58.759	54.729	55.7520
2.500	1.562	73.	58.109	56.547	59.556	55.526	56.5335
2.500	1.562	74.	58.905	57.343	60.352	56.322	57.3430
2.500	1.562	75.	59.701	58.139	61.148	57.118	58.1259
2.500	1.562	76.	60.496	58.934	61.944	57.914	58.9340
2.500	1.562	77.	61.292	59.730	62.741	58.711	59.7172
2.500	1.562	78.	62.087	60.525	63.537	59.507	60.5250
2.500	1.562	79.	62.883	61.321	64.333	60.303	61.3086
2.500	1.562	80.	63.678	62.116	65.129	61.099	62.1160
2.500	1.562	81.	64.474	62.912	65.925	61.895	62.8999
2.500	1.562	82.	65.269	63.707	66.722	62.692	63.7070
2.500	1.562	83.	66.065	64.503	67.518	63.488	64.4912
2.500	1.562	84.	66.861	65.299	68.314	64.284	65.2990
2.500	1.562	85.	67.656	66.094	69.110	65.080	66.0824
2.500	1.562	86.	68.452	66.890	69.906	65.876	66.8900
2.500	1.562	87.	69.247	67.685	70.702	66.672	67.6737
2.500	1.562	88.	70.043	68.481	71.498	67.468	68.4810
2.500	1.562	89.	70.839	69.277	72.295	68.265	69.2660
2.500	1.562	90.	71.634	70.072	73.091	69.061	70.0720
2.500	1.562	91.	72.430	70.868	73.887	69.857	70.8572
2.500	1.562	92.	73.226	71.664	74.683	70.653	71.6640
2.500	1.562	93.	74.021	72.459	75.479	71.449	72.4484
2.500	1.562	94.	74.817	73.255	76.275	72.245	73.2550
2.500	1.562	95.	75.612	74.050	77.071	73.041	74.0397
2.500	1.562	96.	76.408	74.846	77.867	73.837	74.8460
2.500	1.562	97.	77.204	75.642	78.663	74.633	75.6319
2.500	1.562	98.	77.999	76.437	79.459	75.429	76.4370
2.500	1.562	99.	78.795	77.233	80.255	76.255	77.2231
2.500	1.562	100.	79.591	78.029	81.051	77.021	78.0290
3.000	1.875	8.	7.839	5.964	9.043	4.213	5.9640

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
3.000	1.875	9.	8.771	6.896	10.042	5.212	6.7627
3.000	1.875	10.	9.708	7.833	11.033	6.203	7.8330
3.000	1.875	11.	10.648	8.773	12.017	7.187	8.6646
3.000	1.875	12.	11.591	9.716	12.996	8.166	9.7160
3.000	1.875	13.	12.536	10.661	13.971	9.141	10.5696
3.000	1.875	14.	13.482	11.607	14.944	10.114	11.6070
3.000	1.875	15.	14.429	12.554	15.914	11.084	12.4750
3.000	1.875	16.	15.377	13.502	16.882	12.052	13.5020
3.000	1.875	17.	16.327	14.452	17.849	13.019	14.3824
3.000	1.875	18.	17.276	15.401	18.814	13.984	15.4010
3.000	1.875	19.	18.227	16.352	19.778	14.948	16.2897
3.000	1.875	20.	19.177	17.302	20.741	15.911	17.3020
3.000	1.875	21.	20.129	18.254	21.704	16.874	18.1977
3.000	1.875	22.	21.080	19.205	22.665	17.835	19.2050
3.000	1.875	23.	22.032	20.157	23.627	18.797	20.1056
3.000	1.875	24.	22.984	21.109	24.587	19.757	21.1090
3.000	1.875	25.	23.936	22.061	25.547	20.717	22.0138
3.000	1.875	26.	24.889	23.014	26.507	21.677	23.0140
3.000	1.875	27.	25.841	23.966	27.467	22.637	23.9223
3.000	1.875	28.	26.794	24.919	28.426	23.596	24.9190
3.000	1.875	29.	27.747	25.872	29.385	24.555	25.8313
3.000	1.875	30.	28.700	26.825	30.343	25.513	26.8250
3.000	1.875	31.	29.654	27.779	31.301	26.471	27.7409
3.000	1.875	32.	30.607	28.732	32.260	27.430	28.7320
3.000	1.875	33.	31.560	29.685	33.217	28.387	29.6493
3.000	1.875	34.	32.514	30.639	34.175	29.345	30.6390
3.000	1.875	35.	33.467	31.592	35.133	30.303	31.5583
3.000	1.875	36.	34.421	32.546	36.090	31.260	32.5460
3.000	1.875	37.	35.375	33.500	37.047	32.217	33.4681
3.000	1.875	38.	36.329	34.454	38.005	33.175	34.4540
3.000	1.875	39.	37.283	35.408	38.962	34.132	35.3778
3.000	1.875	40.	38.236	36.361	39.919	35.089	36.3610
3.000	1.875	41.	39.190	37.315	40.875	36.045	37.2862

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
3.000	1.875	42.	40.144	38.269	41.832	37.002	38.2690
3.000	1.875	43.	41.099	39.224	42.789	37.959	39.1966
3.000	1.875	44.	42.053	40.178	43.745	38.915	40.1780
3.000	1.875	45.	43.077	41.132	44.702	39.872	41.1058
3.000	1.875	46.	43.961	42.086	45.658	40.828	42.0860
3.000	1.875	47.	44.915	43.040	46.615	41.785	43.0149
3.000	1.875	48.	45.869	43.994	47.571	42.741	43.9940
3.000	1.875	49.	46.824	44.949	48.527	43.697	44.9249
3.000	1.875	50.	47.778	45.903	49.484	44.654	45.9030
3.000	1.875	51.	48.732	46.857	50.440	45.610	46.8339
3.000	1.875	52.	49.687	47.812	51.396	46.566	47.8120
3.000	1.875	53.	50.641	48.766	52.352	47.522	48.7438
3.000	1.875	54.	51.595	49.720	53.308	48.478	49.7200
3.000	1.875	55.	52.550	50.675	54.264	49.434	50.6536
3.000	1.875	56.	53.504	51.629	55.220	50.390	51.6290
3.000	1.875	57.	54.459	52.584	56.176	51.346	52.5633
3.000	1.875	58.	55.413	53.538	57.132	52.302	53.5380
3.000	1.875	59.	56.367	54.492	58.088	53.258	54.4720
3.000	1.875	60.	57.322	55.447	59.043	54.213	55.4470
3.000	1.875	61.	58.276	56.401	59.999	55.169	56.3817
3.000	1.875	62.	59.231	57.356	60.955	56.125	57.3560
3.000	1.875	63.	60.186	58.311	61.911	57.081	58.2923
3.000	1.875	64.	61.140	59.265	62.866	58.036	59.2650
3.000	1.875	65.	62.095	60.220	63.822	58.992	60.2019
3.000	1.875	66.	63.049	61.174	64.778	59.948	61.1740
3.000	1.875	67.	64.004	62.129	65.733	60.903	62.1114
3.000	1.875	68.	64.958	63.083	66.689	61.859	63.0830
3.000	1.875	69.	65.913	64.038	67.645	62.815	64.0209
3.000	1.875	70.	66.868	64.993	68.600	63.770	64.9930
3.000	1.875	71.	67.822	65.947	69.556	64.726	65.9304
3.000	1.875	72.	68.777	66.902	70.511	65.681	66.9020
3.000	1.875	73.	69.731	67.856	71.467	66.637	67.8399
3.000	1.875	74.	70.686	68.811	72.422	67.592	68.8110

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TABLE VI. Technical characteristics for sprocket wheels for roller chains.

P	D	N	PD	BD	OD	MHD	CD
3.000	1.875	75.	71.641	69.766	73.378	68.548	69.7503
3.000	1.875	76.	72.595	70.720	74.333	69.503	70.7200
3.000	1.875	77.	73.550	71.675	75.289	70.459	71.6597
3.000	1.875	78.	74.505	72.630	76.244	71.414	72.6300
3.000	1.875	79.	75.459	73.584	77.200	72.370	73.5691
3.000	1.875	80.	76.414	74.539	78.155	73.325	74.5390
3.000	1.875	81.	77.369	75.494	79.111	74.281	75.4795
3.000	1.875	82.	78.323	76.448	80.066	75.236	76.4480
3.000	1.875	83.	79.278	77.403	81.021	76.191	77.3888
3.000	1.875	84.	80.233	78.358	81.877	77.147	78.3580
3.000	1.875	85.	81.188	79.313	82.932	78.102	79.2991
3.000	1.875	86.	82.142	80.267	83.887	79.057	80.2670
3.000	1.875	87.	83.097	81.222	84.843	80.013	81.2085
3.000	1.875	88.	84.052	82.177	85.798	80.968	82.1770
3.000	1.875	89.	85.006	83.131	86.753	81.923	83.1178
3.000	1.875	90.	85.961	84.086	87.709	82.879	84.0860
3.000	1.875	91.	86.916	85.041	88.664	83.834	85.0281
3.000	1.875	92.	87.871	85.996	89.619	84.789	85.9960
3.000	1.875	93.	88.825	86.950	90.575	85.745	86.9373
3.000	1.875	94.	89.780	87.905	91.530	86.700	87.9050
3.000	1.875	95.	90.735	88.860	92.485	87.655	88.8476
3.000	1.875	96.	91.690	89.815	93.441	88.611	89.8150
3.000	1.875	97.	92.644	90.769	94.396	89.566	90.7569
3.000	1.875	98.	93.599	91.724	95.351	90.521	91.7240
3.000	1.875	99.	94.554	92.679	96.306	91.476	92.6671
3.000	1.875	100.	95.509	93.634	97.262	92.432	93.6340

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5.4.1. Sprocket wheels for roller chains standard roller series (ANSI B29.4) MIL-STD-423.

Sprockets for double-pitch chains may have one or two sets of effective teeth i.e., teeth which engage chain rollers in one revolution of the sprocket. A sprocket having two sets of effective teeth is illustrated in Figure 17. Such a sprocket is known as a double-out. Tooth spaces for the second set of teeth are located midway between those of the first set and are represented by dotted lines in Figure 19.

A sprocket is single-cut if it has only one set of effective teeth (see Figure 18).

Double-cut sprockets with an odd number of actual teeth, such as 21, and therefore, with half as many effective teeth (10.50), provide automatic hunting, each actual tooth engaging a chain roller once during two revolutions of such a sprocket.

Double-cut sprockets with an even number of actual teeth have an integral number of effective teeth and cannot provide automatic "hunting" because only one set of effective teeth can engage chain rollers; however, many revolutions of the sprockets may be made. Manual shifting of the chain by a half effective tooth is necessary to provide distribution of wear to a previously inactive set of teeth.

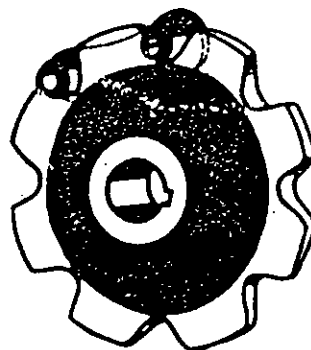
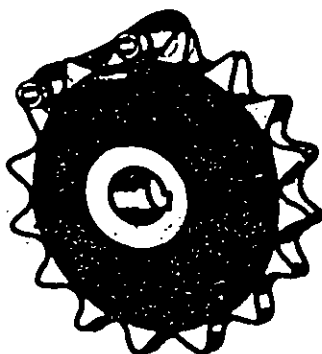
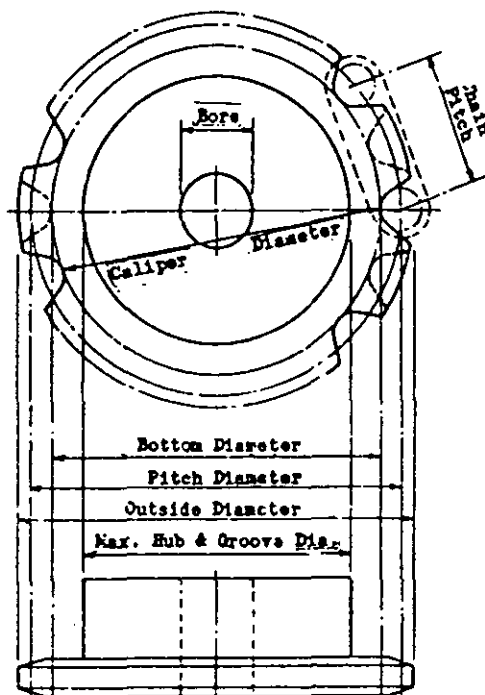


FIGURE 17. Double-cut sprocket.

Figure 18. Single-cut sprocket.

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FIGURE 19. Diameters.

## LEGEND

P	=	Chain Pitch
PD	=	Pitch Diameter
BD	=	Bottom Diameter
CD	=	Caliper Diameter
D	=	Roller Diameter
BD	=	PD - D

$$PD = \frac{P}{\sin \frac{180^\circ}{NE}}$$

N = Total number of teeth on double-cut sprockets.

NE = Number of effective teeth

$$NE = \frac{N}{2}$$

NE = Total number of teeth on single-cut sprockets for double-pitch chains



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## A. DIAMETER

- \* CD, single-cut, if NE is an odd number =  $PD \left( \cos \frac{90^\circ}{N} \right) - D$
- \*\* CD, single-cut, if NE is an even number =  $PD - D = BD$
- \* CD, double-cut, if NE is a fractional number =  $PD \left( \cos \frac{45^\circ}{N} \right) - D$
- \*\* CD, double-cut whether NE is an odd or even number =  $PD - D = BD$

Tolerances on bottom or caliper diameter of sprockets:

Plus tolerance 0.000

Minus tolerance  $0.001 P \sqrt{N + 0.003}$

Approximate Outside Diameter of Sprocket =  $PD + \frac{P}{2} \left( 0.6 - \tan \frac{90^\circ}{NE} \right)$

Maximum Hub Diameter (MHD) of Sprockets =  $P \left( \cot \frac{180^\circ}{NE} - 0.5 \right) - .030$

- \* These caliper diameters are measured across any two tooth spaces that are most nearly diametrically opposite to each other.
- \*\* These caliper diameters are measured across any two tooth spaces that are exactly diametrically opposite to each other.

The section profile shows the recommended chamfering of sprocket teeth.

W = Chain Width  
 MHD = Maximum Hub Diameter  
 $t = 0.93W - 0.006$  (Maximum)

Tolerance on t when machined = Plus zero,  
 minus  $(.01W + .006)$ .

$h = .25 P$  = Depth of chamfer  
 $g = .0625 P$  approximately (not to exceed  $\frac{W}{3}$ )

$R_c \text{ min.} = .532 P$  (approximately tangent to side) = Chamfer radius.

$r_f \text{ max.} = .02 P$  for maximum hub diameter (but not to exceed .040) = Fillet radius.

\*\*\* Flange chamfer may be radial, straight, or anything in between.

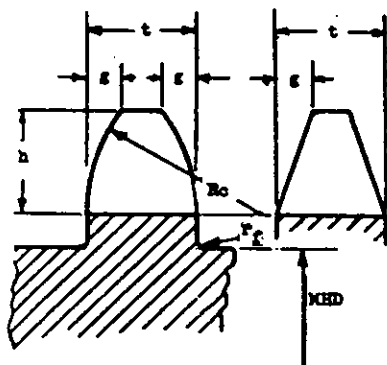


FIGURE 20. Tooth profile.

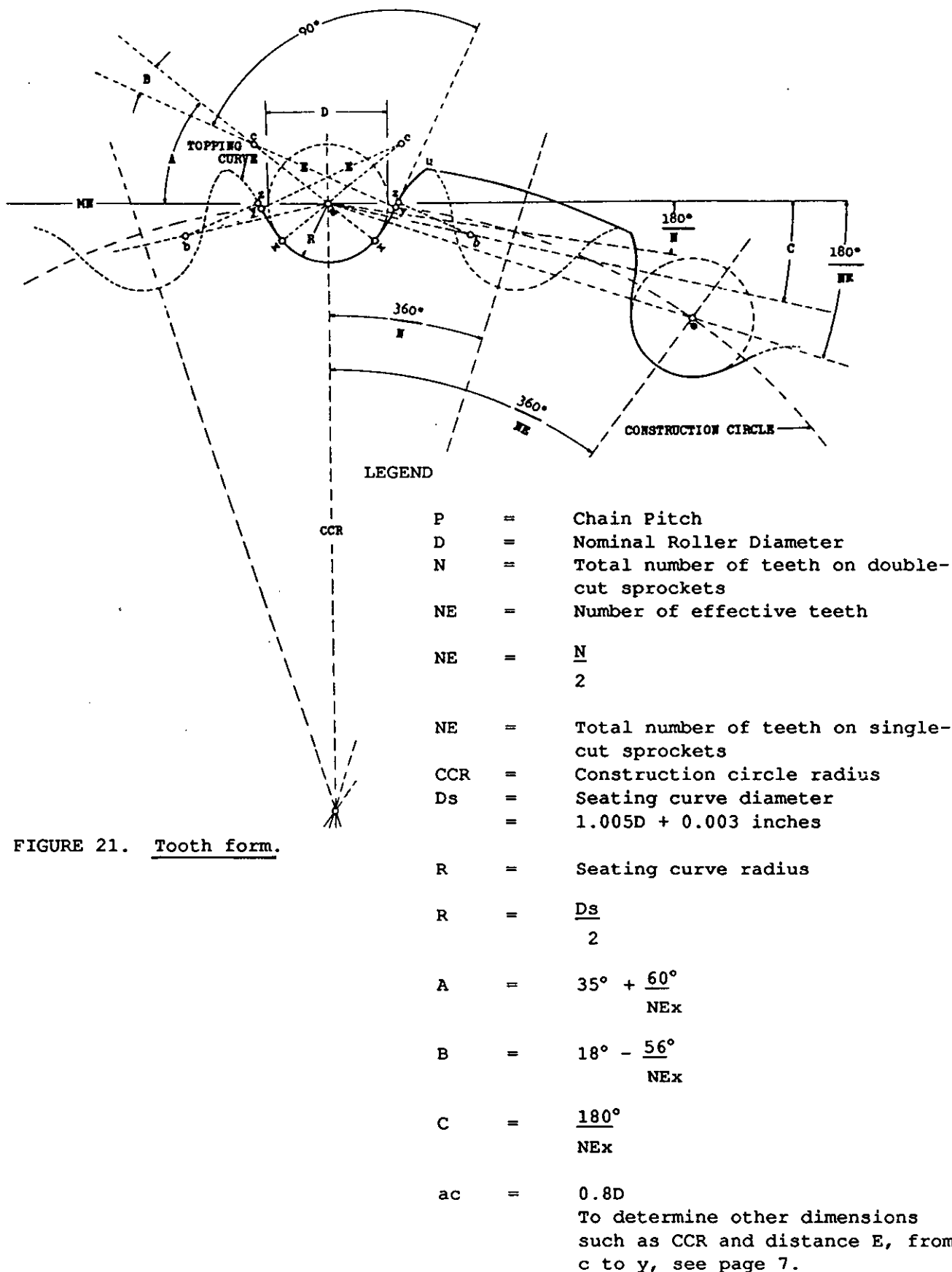
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TABLE VII. Sprocket tooth section profile dimensions (in inches).

ASA chain No.	Pitch (P)	Width of chain (W)	Maximum sprocket thickness (t)	*Minus tolerance on (t)	Depth of chamfer (h)	Width of chamfer (g)	Minimum radius (R <sub>C</sub> )
2040 C-2040	1.000	.3125	.284	.009	.250	.0625	0.531
2050 C-2050	1.25	.375	.343	.010	.3125	.078	0.664
2060 C-2060	1.50	.500	.459	.011	.375	.093	0.796
2080 C-2080	2.000	.625	.575	.012	.500	.125	1.062
2100 C-2100	2.50	.750	.692	.014	.625	.156	1.327
2120 C-2120	3.000	1.000	.924	.016	.750	.087	1.593
C-2160	4.000	1.250	1.156	.019	1.000	.250	2.124

\* When machined

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FIGURE 21. Tooth form.

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**DOUBLE-PITCH POWER TRANSMISSION ROLLER CHAIN SPROCKET CUTTER SELECTION:**  
 The tooth space form for Double-Pitch Chain sprockets is basically the same as that for the respective base chain series, i.e. ANSI Chains B29.1. Therefore, the same cutters and hobs are used for cutting the tooth form for both the single-pitch and the double-pitch chains.

When cutting Double-Pitch sprockets with a tooth space cutter, it is necessary to use the space cutter for the base chain series but having the next higher range of teeth that the number of teeth to be cut.

Example: 15 Teeth No. 2080 -- A No. 80 space cutter having a range of 18-34 teeth should be used instead of the 12-17 tooth range.

When cutting Double-Pitch sprockets with a base chain hob or Fellows outter, it is necessary to cut an extra set or a double number of teeth resulting in two "sets" of teeth. The chain will engage with only one set of teeth. In this regard, see explanation at top of page 25.

The determination of angle C, above and the layout of this angle depends on how the tooth form is to be cut with a standard space cutter or with a standard hob. If the tooth form is to be cut with a standard space cutter, angle C equals  $180^\circ$  divided by a factor NEx shown in Table 8.

If the tooth form is to be cut with a standard hob, angle C equals  $180^\circ$  divided by  $2 \times NE$  or  $N$ . The tooth form drawn based on this angle presumes a pitch diameter for a standard single pitch sprocket of N number of teeth, while the hob will actually cut a pitch diameter specified slightly-larger for a double pitch sprocket. Therefore, the theoretical and actual tooth forms will differ slightly.

Draw line MN. Locate a convenient point a on the line MN. With a as a center, a radius ax equal to  $1/2D$ , draw a circular arc for the "seating curve" xx.

Draw line yz perpendicular to line cy. Draw line ab making angle ci with MN, and locate point b so that  $ab = 1.4D$ . Draw line bz parallel to line cy. With b as a center and a radius bz, draw the "topping curve" arc us tangent to line ys.

A similar construction for the other half will complete the tooth outline.

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TABLE VIII. Sprocket tooth factors.

TABLE 8		
N	NE	NEx
10	5.00	7.47
11	5.50	7.47
12	6.00	7.47
13	6.50	7.47
14	7.00	9.9
15	7.50	9.9
16	8.00	9.9
17	8.50	9.9
18	9.00	14.07
19	9.50	14.07
20	10.00	14.07
21	10.50	14.07
22	11.00	14.07
23	11.50	14.07
24	12.00	23.54
25	12.50	23.54
26	13.00	23.54
27	13.50	23.54
28	14.00	23.54
29	14.50	23.54
30	15.00	23.54
31	15.50	23.54
32	16.00	23.54
33	16.50	23.54
34	17.00	23.54
35	17.50	23.54
36 and over	18 and over	56

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4).

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	5.0	1.701	1.389	1.839	0.846	1.3057	1.3890
1.000	0.312	5.5	1.850	1.538	2.003	1.026		1.5192
1.000	0.312	6.0	2.000	1.688	2.166	1.202	1.6880	1.6880
1.000	0.312	6.5	2.152	1.840	2.329	1.375		1.8243
1.000	0.312	7.0	2.305	1.993	2.491	1.547	1.9352	1.9930
1.000	0.312	7.5	2.459	2.147	2.653	1.716		2.1335
1.000	0.312	8.0	2.613	2.301	2.814	1.884	2.3010	2.3010
1.000	0.312	8.5	2.768	2.456	2.975	2.051		2.4442
1.000	0.312	9.0	2.924	2.612	3.136	2.217	2.5676	2.6120
1.000	0.312	9.5	3.080	2.768	3.297	2.383		2.7575
1.000	0.312	10.0	3.236	2.924	3.457	2.548	2.9240	2.9240
1.000	0.312	10.5	3.393	3.081	3.618	2.712		3.0715
1.000	0.312	11.0	3.549	3.237	3.777	2.876	3.2009	3.2370
1.000	0.312	11.5	3.706	3.394	3.937	3.039		3.3854
1.000	0.312	12.0	3.864	3.552	4.098	3.202	3.5520	3.5520
1.000	0.312	12.5	4.021	3.709	4.258	3.365		3.7011
1.000	0.312	13.0	4.179	3.867	4.418	3.527	3.8365	3.8670
1.000	0.312	13.5	4.336	4.024	4.578	3.689		4.0167
1.000	0.312	14.0	4.494	4.182	4.738	3.851	4.1820	4.1820
1.000	0.312	14.5	4.652	4.340	4.898	4.013		4.3332
1.000	0.312	15.0	4.810	4.498	5.057	4.175	4.4717	4.4980
1.000	0.312	15.5	4.968	4.656	5.217	4.336		4.6496
1.000	0.312	16.0	5.126	4.814	5.377	4.497	4.8140	4.8140
1.000	0.312	16.5	5.284	4.972	5.536	4.658		4.9660
1.000	0.312	17.0	5.442	5.130	5.696	4.820	5.1068	5.1300
1.000	0.312	17.5	5.600	5.288	5.855	4.980		5.2824
1.000	0.312	18.0	5.759	5.447	6.015	5.141	5.4470	5.4470

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	18.5	5.917	5.605	6.174	5.302		5.5997
1.000	0.312	19.0	6.076	5.764	6.335	5.463	5.7432	5.7640
1.000	0.312	19.5	6.234	5.922	6.494	5.623		5.9169
1.000	0.312	20.0	6.392	6.080	6.653	5.784	6.0800	6.0800
1.000	0.312	20.5	6.551	6.239	6.813	5.944		6.2342
1.000	0.312	21.0	6.710	6.398	6.973	6.105	6.3792	6.3980
1.000	0.312	21.5	6.868	6.556	7.131	6.265		6.5514
1.000	0.312	22.0	7.027	6.715	7.291	6.425	6.7150	6.7150
1.000	0.312	22.5	7.185	6.873	7.450	6.585		6.8686
1.000	0.312	23.0	7.344	7.032	7.610	6.746	7.0149	7.0320
1.000	0.312	23.5	7.503	7.191	7.770	6.906		7.1868
1.000	0.312	24.0	7.661	7.349	7.928	7.066	7.3490	7.3490
1.000	0.312	24.5	7.820	7.508	8.088	7.226		7.5040
1.000	0.312	25.0	7.979	7.667	8.248	7.386	7.6513	7.6670
1.000	0.312	25.5	8.137	7.825	8.406	7.546		7.8211
1.000	0.312	26.0	8.296	7.984	8.566	7.706	7.9840	7.9840
1.000	0.312	26.5	8.455	8.143	8.725	7.866		8.1393
1.000	0.312	27.0	8.614	8.302	8.885	8.026	8.2874	8.3020
1.000	0.312	27.5	8.773	8.461	9.044	8.185		8.4574
1.000	0.312	28.0	8.931	8.619	9.203	8.345	8.6190	8.6190
1.000	0.312	28.5	9.090	8.778	9.362	8.505		8.7745
1.000	0.312	29.0	9.249	8.937	9.522	8.665	8.9234	8.9370
1.000	0.312	29.5	9.408	9.096	9.681	8.825		9.0927
1.000	0.312	30.0	9.567	9.255	9.841	8.984	9.2550	9.2550
1.000	0.312	30.5	9.726	9.414	10.000	9.144		9.4108
1.000	0.312	31.0	9.885	9.573	10.160	9.304	9.5603	9.5730
1.000	0.312	31.5	10.043	9.731	10.318	9.463		9.7279

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	32.0	10.202	9.890	10.477	9.623	9.8900	9.8900
1.000	0.312	32.5	10.361	10.049	10.637	9.783		10.0460
1.000	0.312	33.0	10.520	10.208	10.796	9.942	10.1961	10.2080
1.000	0.312	33.5	10.679	10.367	10.956	10.102		10.3641
1.000	0.312	34.0	10.838	10.526	11.115	10.262	10.5260	10.5260
1.000	0.312	34.5	10.997	10.685	11.274	10.421		10.6822
1.000	0.312	35.0	11.156	10.844	11.434	10.581	10.8328	10.8440
1.000	0.312	35.5	11.315	11.003	11.593	10.740		11.0002
1.000	0.312	36.0	11.474	11.162	11.752	10.900	11.1620	11.1620
1.000	0.312	36.5	11.633	11.321	11.911	11.060		11.3183
1.000	0.312	37.0	11.792	11.480	12.071	11.219	11.4694	11.4800
1.000	0.312	37.5	11.951	11.639	12.230	11.379		11.6364
1.000	0.312	38.0	12.110	11.798	12.389	11.538	11.7980	11.7980
1.000	0.312	38.5	12.269	11.957	12.549	11.698		11.9544
1.000	0.312	39.0	12.428	12.116	12.708	11.857	12.1059	12.1160
1.000	0.312	39.5	12.587	12.275	12.867	12.017		12.2725
1.000	0.312	40.0	12.745	12.433	13.025	12.176	12.4330	12.4330
1.000	0.312	40.5	12.904	12.592	13.185	12.336		12.5896
1.000	0.312	41.0	13.063	12.751	13.344	12.495	12.7414	12.7510
1.000	0.312	41.5	13.222	12.910	13.503	12.655		12.9076
1.000	0.312	42.0	13.381	13.069	13.662	12.814	13.0690	13.0690
1.000	0.312	42.5	13.540	13.228	13.822	12.974		13.2257
1.000	0.312	43.0	13.700	13.388	13.982	13.133	13.3789	13.3880
1.000	0.312	43.5	13.859	13.547	14.141	13.292		13.5447
1.000	0.312	44.0	14.018	13.706	14.300	13.452	13.7060	13.7060
1.000	0.312	44.5	14.177	13.865	14.459	13.611		13.8628
1.000	0.312	45.0	14.336	14.024	14.619	13.771	14.0153	14.0240



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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	45.5	14.495	14.183	14.778	13.930		14.1608
1.000	0.312	46.0	14.654	14.342	14.937	14.089	14.3420	14.3420
1.000	0.312	46.5	14.813	14.501	15.096	14.249		14.4989
1.000	0.312	47.0	14.972	14.660	15.255	14.408	14.6516	14.5600
1.000	0.312	47.5	15.131	14.819	15.414	14.568		14.8169
1.000	0.312	48.0	15.290	14.978	15.574	14.727	14.9780	14.9780
1.000	0.312	48.5	15.449	15.137	15.733	14.886		15.1350
1.000	0.312	49.0	15.608	15.296	15.892	15.046	15.2880	15.2960
1.000	0.312	49.5	15.767	15.455	16.051	15.205		15.4530
1.000	0.312	50.0	15.926	15.614	16.210	15.365	15.6140	15.6140
1.000	0.312	50.5	16.085	15.773	16.369	15.524		15.7711
1.000	0.312	51.0	16.244	15.932	16.529	15.683	15.9243	15.9320
1.000	0.312	51.5	16.403	16.091	16.688	15.843		16.9891
1.000	0.312	52.0	16.562	16.250	16.847	16.002	16.2500	16.2500
1.000	0.312	52.5	16.721	16.409	17.006	16.161		16.4071
1.000	0.312	53.0	16.880	16.568	17.165	16.321	16.0606	16.5680
1.000	0.312	53.5	17.039	16.727	17.324	16.480		16.7252
1.000	0.312	54.0	17.198	16.886	17.483	16.639	16.8860	16.8860
1.000	0.312	54.5	17.356	17.046	17.644	16.799		17.0442
1.000	0.312	55.0	17.517	17.205	17.803	16.958	17.1979	17.2050
1.000	0.312	55.5	17.676	17.364	17.962	17.117		17.3622
1.000	0.312	56.0	17.835	17.523	18.121	17.277	17.5230	17.5230
1.000	0.312	56.5	17.994	17.682	18.280	17.436		17.6803
1.000	0.312	57.0	18.153	17.841	18.439	17.595	17.8341	17.8410
1.000	0.312	57.5	18.312	18.000	18.598	17.755		17.9983
1.000	0.312	58.0	18.471	18.159	18.757	17.914	18.1590	18.1590
1.000	0.312	58.5	18.630	18.318	18.917	18.073		18.3163

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	59.0	18.789	18.477	19.076	18.233	18.4703	18.4770
1.000	0.312	59.5	18.946	18.636	19.235	18.392		18.6343
1.000	0.312	60.0	19.107	18.795	19.394	18.551	18.7950	18.7950
1.000	0.312	60.5	19.266	18.954	19.353	18.710		18.9524
1.000	0.312	61.0	19.425	19.113	19.712	18.870	19.1066	19.1130
1.000	0.312	61.5	19.585	19.273	19.872	19.029		19.2714
1.000	0.312	62.0	19.744	19.432	20.031	19.188	19.4320	19.4320
1.000	0.312	62.5	19.903	19.591	20.190	19.348		19.5894
1.000	0.312	63.0	20.062	19.750	20.350	19.507	19.7438	19.7500
1.000	0.312	63.5	20.221	19.909	20.509	19.666		19.9075
1.000	0.312	64.0	20.380	20.068	20.668	19.825	20.0680	20.0680
1.000	0.312	64.5	20.539	20.227	20.827	19.985		20.2255
1.000	0.312	65.0	20.698	20.386	20.986	20.144	20.3800	20.3860
1.000	0.312	65.5	20.857	20.545	21.145	20.303		20.5435
1.000	0.312	66.0	21.016	20.704	21.304	20.463	20.7040	20.7040
1.000	0.312	66.5	21.175	20.863	21.463	20.622		20.8615
1.000	0.312	67.0	21.335	21.023	21.263	20.781	21.0171	21.0230
1.000	0.312	67.5	21.494	21.182	21.782	20.940		21.1805
1.000	0.312	68.0	21.653	21.341	21.941	21.100	21.3410	21.3410
1.000	0.312	68.5	21.812	21.500	22.101	21.259		21.4986
1.000	0.312	69.0	21.971	21.659	22.260	21.418	21.6533	21.6590
1.000	0.312	69.5	22.130	21.818	22.419	21.577		21.8166
1.000	0.312	70.0	22.289	21.977	22.578	21.737	21.9770	21.9770
1.000	0.312	70.5	22.448	22.136	22.737	21.896		22.1346
1.000	0.312	71.0	22.607	22.295	22.896	22.055	22.2895	22.2950
1.000	0.312	71.5	22.766	22.454	23.055	22.215		22.4526
1.000	0.312	72.0	22.926	22.614	23.215	22.374	22.6140	22.6140

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	FD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	72.5	23.085	22.773	23.374	22.533		22.7716
1.000	0.312	73.0	23.244	22.932	23.533	22.692	22.9266	22.9320
1.000	0.312	73.5	23.403	23.091	23.692	22.852		23.0897
1.000	0.312	74.0	23.562	23.250	23.851	23.011	23.2500	23.2500
1.000	0.312	74.5	23.721	23.409	24.010	23.170		23.4077
1.000	0.312	75.0	23.880	23.568	24.170	23.329	23.5628	23.5680
1.000	0.312	75.5	24.039	23.727	24.329	23.489		23.7257
1.000	0.312	76.0	24.198	23.886	24.488	23.648	23.8860	23.8860
1.000	0.312	76.5	24.358	24.046	24.648	23.807		24.0447
1.000	0.312	77.0	24.517	24.205	24.807	23.966	24.1999	24.2050
1.000	0.312	77.5	24.676	24.364	24.966	24.126		24.3627
1.000	0.312	78.0	24.835	24.523	25.125	24.285	24.5230	24.5230
1.000	0.312	78.5	24.994	24.682	25.284	24.444		24.6807
1.000	0.312	79.0	25.153	24.841	25.443	24.603	24.8360	24.8410
1.000	0.312	79.5	25.312	25.000	25.602	24.762		24.9988
1.000	0.312	80.0	25.471	25.159	25.761	24.922	25.1590	25.1590
1.000	0.312	80.5	25.630	25.318	25.920	25.081		25.3168
1.000	0.312	81.0	25.790	25.478	26.080	25.240	25.4732	25.4780
1.000	0.312	81.5	25.949	25.637	26.239	25.399		25.6358
1.000	0.312	82.0	26.108	25.796	26.398	25.559	25.7960	25.7960
1.000	0.312	82.5	26.267	25.955	26.557	25.718		25.9538
1.000	0.312	83.0	26.426	26.114	26.717	25.877	26.1093	26.1140
1.000	0.312	83.5	26.585	26.273	26.876	26.036		26.2718
1.000	0.312	84.0	26.744	26.432	27.035	26.196	26.4320	26.4320
1.000	0.312	84.5	26.903	26.591	27.194	26.355		26.5898
1.000	0.312	85.0	27.063	26.751	27.354	26.514	26.7464	26.7510
1.000	0.312	85.5	27.222	26.910	27.513	26.673		26.9089

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	86.0	27.381	27.069	27.672	26.832	27.0690	27.0690
1.000	0.312	86.5	27.540	27.228	27.831	26.992		27.2269
1.000	0.312	87.0	27.699	27.387	27.990	27.151	27.3825	27.3870
1.000	0.312	87.5	27.585	27.546	28.149	27.310		27.5449
1.000	0.312	88.0	28.017	27.705	28.308	27.469	27.7050	27.7050
1.000	0.312	88.5	28.176	27.864	28.467	27.629		27.8629
1.000	0.312	89.0	28.335	28.023	28.626	27.788	28.0186	28.0230
1.000	0.312	89.5	28.495	28.183	28.786	27.947		28.1819
1.000	0.312	90.0	28.654	28.342	28.945	28.106	28.3420	28.3420
1.000	0.312	90.5	28.813	28.501	29.104	28.265		28.4999
1.000	0.312	91.0	28.972	28.660	29.263	28.425	28.6557	28.6600
1.000	0.312	91.5	29.131	28.819	29.422	28.584		28.8179
1.000	0.312	92.0	29.290	28.978	29.581	28.743	28.9780	28.9780
1.000	0.312	92.5	29.449	29.137	29.741	28.902		29.1359
1.000	0.312	93.0	29.608	29.296	29.900	29.062	29.2918	29.2960
1.000	0.312	93.5	29.768	29.456	30.060	29.221		29.4549
1.000	0.312	94.0	29.927	29.615	30.219	29.380	29.6150	29.6150
1.000	0.312	94.5	30.086	29.774	30.378	29.539		29.7730
1.000	0.312	95.0	30.245	29.933	30.537	29.698	29.9289	29.9330
1.000	0.312	95.5	30.404	30.092	30.696	29.858		30.0910
1.000	0.312	96.0	30.563	30.251	30.855	30.017	30.2510	30.2510
1.000	0.312	96.5	30.722	30.410	31.014	30.176		30.4090
1.000	0.312	97.0	30.881	30.569	31.173	30.335	30.5650	30.5690
1.000	0.312	97.5	31.041	30.729	31.333	30.494		30.7280
1.000	0.312	98.0	31.200	30.888	31.492	30.654	30.8880	30.8880
1.000	0.312	98.5	31.359	31.047	31.651	30.813		31.0460
1.000	0.312	99.0	31.518	31.206	31.810	30.972	31.2020	31.2060

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.000	0.312	99.5	31.677	31.365	31.969	31.131		31.3640
1.000	0.312	100.0	31.836	31.524	32.128	31.291	31.5240	31.5240
1.250	0.400	5.0	2.127	1.727	2.299	1.065	1.6229	1.7270
1.250	0.400	5.5	2.312	1.912	2.503	1.290		1.8885
1.250	0.400	6.0	2.500	2.100	2.708	1.510	2.1000	2.1000
1.250	0.400	6.5	2.690	2.290	2.911	1.727		2.2704
1.250	0.400	7.0	2.881	2.481	3.113	1.941	2.4088	2.4810
1.250	0.400	7.5	3.073	2.763	3.315	2.153		2.6562
1.250	0.400	8.0	3.266	2.866	3.517	2.363	2.8660	2.8660
1.250	0.400	8.5	3.460	3.060	3.718	2.572		3.0452
1.250	0.400	9.0	3.655	3.255	3.920	2.779	3.1995	3.2550
1.250	0.400	9.5	3.850	3.450	4.121	2.986		3.4369
1.250	0.400	10.0	4.045	3.645	4.321	3.192	3.6450	3.6450
1.250	0.400	10.5	4.241	3.841	4.522	3.397		3.8291
1.250	0.400	11.0	4.437	4.037	4.722	3.602	3.9918	4.0370
1.250	0.400	11.5	4.633	4.233	4.922	3.806		4.2222
1.250	0.400	12.0	4.830	4.430	5.123	4.010	4.4300	4.4300
1.250	0.400	12.5	5.026	4.626	5.322	4.213		4.6161
1.250	0.400	13.0	5.223	4.823	5.522	4.416	4.7849	4.8230
1.250	0.400	13.5	5.420	5.020	5.722	4.619		5.0108
1.250	0.400	14.0	5.617	5.217	5.922	4.822	5.2170	5.2170
1.250	0.400	14.5	5.815	5.415	6.122	5.024		5.4065
1.250	0.400	15.0	6.012	5.612	6.321	5.226	5.5791	5.6120
1.250	0.400	15.5	6.210	5.810	6.521	5.428		5.8020
1.250	0.400	16.0	6.407	6.007	6.720	5.629	6.0070	6.0070
1.250	0.400	16.5	6.605	6.205	6.920	5.831		6.1975
1.250	0.400	17.0	6.803	6.403	7.120	6.032	6.3740	6.4030

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	17.5	7.001	6.601	7.320	6.233		6.5940
1.250	0.400	18.0	7.198	6.798	7.518	6.434	6.7980	6.7980
1.250	0.400	18.5	7.396	6.996	7.718	6.635		6.9893
1.250	0.400	19.0	7.594	7.194	7.917	6.836	7.1681	7.1940
1.250	0.400	19.5	7.792	7.392	8.117	7.037		7.3857
1.250	0.400	20.0	7.991	7.591	8.317	7.237	7.5910	7.5910
1.250	0.400	20.5	8.189	7.789	8.516	7.438		7.9870
1.250	0.400	21.0	8.387	7.987	8.715	7.638	7.9635	7.7830
1.250	0.400	21.5	8.585	8.185	8.914	7.839		8.1793
1.250	0.400	22.0	8.783	8.383	9.113	8.039	8.3830	8.3830
1.250	0.400	22.5	8.982	8.582	9.313	8.239		8.5765
1.250	0.400	23.0	9.180	8.780	9.512	8.439	8.7586	8.7800
1.250	0.400	23.5	9.378	8.978	9.711	8.640		8.9728
1.250	0.400	24.0	9.577	9.177	9.911	8.840	9.1770	9.1770
1.250	0.400	24.5	9.775	9.375	10.110	9.040		9.3700
1.250	0.400	25.0	9.973	9.573	10.309	9.240	9.5533	9.5730
1.250	0.400	25.5	10.172	9.772	10.508	9.440		9.7672
1.250	0.400	26.0	10.370	9.970	10.707	9.640	9.9700	9.9700
1.250	0.400	26.5	10.569	10.169	10.907	9.840		10.1644
1.250	0.400	27.0	10.767	10.367	11.106	10.039	10.3488	10.3670
1.250	0.400	27.5	10.966	10.566	11.305	10.239		10.5615
1.250	0.400	28.0	11.164	10.764	11.504	10.439	10.7640	10.7640
1.250	0.400	28.5	11.363	10.963	11.704	10.639		10.9587
1.250	0.400	29.0	11.561	11.161	11.902	10.839	11.1440	11.1610
1.250	0.400	29.5	11.760	11.360	12.102	11.038		11.3558
1.250	0.400	30.0	11.958	11.558	12.300	11.238	11.5580	11.5580
1.250	0.400	30.5	12.157	11.757	12.500	11.438		11.7530

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	31.0	12.356	11.956	12.699	11.637	11.9401	11.9560
1.250	0.400	31.5	12.554	12.154	12.898	11.837		12.1501
1.250	0.400	32.0	12.753	12.353	13.097	12.036	12.3530	12.3530
1.250	0.400	32.5	12.952	12.552	13.297	12.236		12.5482
1.250	0.400	33.0	13.150	12.750	13.495	12.436	12.7351	12.7500
1.250	0.400	33.5	13.349	12.949	13.695	12.635		12.9453
1.250	0.400	34.0	13.547	13.147	13.893	12.835	13.1470	13.1470
1.250	0.400	34.5	13.746	13.346	14.093	13.034		13.3424
1.250	0.400	35.0	13.945	13.545	14.292	13.234	13.5310	13.5450
1.250	0.400	35.5	14.143	13.743	14.490	13.433		13.7395
1.250	0.400	36.0	14.342	13.942	14.690	13.633	13.9420	13.9420
1.250	0.400	36.5	13.541	14.141	14.889	13.832		14.1376
1.250	0.400	37.0	14.740	13.340	15.088	14.031	14.3267	14.3400
1.250	0.400	37.5	14.938	14.538	15.287	14.231		14.5347
1.250	0.400	38.0	15.137	14.737	15.486	14.430	14.7370	14.7370
1.250	0.400	38.5	15.336	14.936	15.685	14.630		14.9328
1.250	0.400	39.0	15.534	15.134	15.884	14.829	15.1214	15.1340
1.250	0.400	39.5	15.733	15.333	16.083	15.028		15.3299
1.250	0.400	40.0	15.932	15.532	16.282	15.228	15.5320	15.5320
1.250	0.400	40.5	16.131	15.731	16.482	15.427		15.7280
1.250	0.400	41.0	16.329	15.929	16.680	15.626	15.9170	15.9290
1.250	0.400	41.5	16.528	16.128	16.879	15.826		16.1250
1.250	0.400	42.0	16.727	16.327	17.079	16.025	16.3270	16.3270
1.250	0.408	42.5	16.926	16.526	17.278	16.224		16.5231
1.250	0.400	43.0	17.124	16.724	17.476	16.424	16.7126	16.7240
1.250	0.400	43.5	17.323	16.923	17.675	16.623		16.9202
1.250	0.400	44.0	17.522	17.122	17.875	16.822	17.1220	17.1220

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	44.5	17.721	17.321	18.074	17.022		17.3182
1.250	0.400	45.0	17.919	17.519	18.272	17.221	17.5081	17.5190
1.250	0.400	45.5	18.118	17.718	18.471	17.420		17.7153
1.250	0.400	46.0	18.317	17.917	18.671	17.619	17.9170	17.9170
1.250	0.400	46.5	18.516	18.116	18.870	17.819		18.1134
1.250	0.400	47.0	18.715	18.315	19.069	18.018	18.3045	18.3150
1.250	0.400	47.5	18.913	18.513	19.267	18.217		18.5104
1.250	0.400	48.0	19.112	18.712	19.467	18.416	18.7120	18.7120
1.250	0.400	48.5	19.311	18.911	19.666	18.616		18.9085
1.250	0.400	49.0	19.510	19.110	19.865	18.815	19.1000	19.1100
1.250	0.400	49.5	19.709	19.309	20.064	19.014		19.3065
1.250	0.400	50.0	19.907	19.507	20.262	19.213	19.5070	19.5070
1.250	0.400	50.5	20.106	19.706	20.462	19.412		19.7036
1.250	0.400	51.0	20.305	19.905	20.661	19.612	19.8954	19.9050
1.250	0.400	51.5	20.504	20.104	20.860	19.811		20.1016
1.250	0.400	52.0	20.703	20.303	21.059	20.010	20.3030	20.3030
1.250	0.400	52.5	20.902	20.502	21.258	20.209		20.4997
1.250	0.400	53.0	21.100	20.700	21.456	20.408	20.6907	20.7000
1.250	0.400	53.5	21.299	20.899	21.656	20.608		20.8967
1.250	0.400	54.0	21.498	21.098	21.855	20.807	21.0980	21.0980
1.250	0.400	54.5	21.697	21.297	22.054	21.006		21.2947
1.250	0.400	55.0	21.896	21.496	22.253	21.205	21.4871	21.4960
1.250	0.400	55.5	22.095	21.695	22.452	21.404		21.6928
1.250	0.400	56.0	22.293	21.893	22.650	21.603	21.8930	21.8930
1.250	0.400	56.5	22.492	22.092	22.850	21.802		22.0898
1.250	0.400	57.0	22.691	22.291	23.049	22.002	22.2824	22.2910
1.250	0.400	57.5	22.890	22.490	23.248	22.201		22.4879



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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	58.0	23.089	22.689	23.447	22.400	22.6890	22.6890
1.250	0.400	58.5	23.288	22.888	23.646	22.599		22.8859
1.250	0.400	59.0	23.486	23.086	23.844	22.798	23.0777	23.0860
1.250	0.400	59.5	23.685	23.285	24.044	22.997		23.2829
1.250	0.400	60.0	23.884	23.484	24.243	23.196	23.4840	23.4840
1.250	0.400	60.5	24.083	23.683	24.442	23.396		23.6810
1.250	0.400	61.0	24.282	23.882	24.641	23.595	23.8739	23.8820
1.250	0.400	61.5	24.481	24.081	24.840	23.794		24.0790
1.250	0.400	62.0	24.680	24.280	25.039	23.993	24.2800	24.2800
1.250	0.400	62.5	24.878	24.478	25.237	24.192		24.4760
1.250	0.400	63.0	25.077	24.677	25.436	24.391	24.6692	24.6770
1.250	0.400	63.5	25.276	24.876	25.636	24.590		24.8741
1.250	0.400	64.0	25.475	25.075	25.835	24.789	25.0750	25.0750
1.250	0.400	64.5	25.674	25.274	26.034	24.988		25.2721
1.250	0.400	65.0	25.873	25.473	26.233	25.188	25.4654	25.4730
1.250	0.400	65.5	26.072	25.672	26.432	25.387		25.6701
1.250	0.400	66.0	26.270	25.870	26.630	25.586	25.8700	25.8700
1.250	0.400	66.5	26.469	26.069	26.829	25.785		26.0672
1.250	0.400	67.0	26.668	26.268	27.028	25.984	26.2607	26.2680
1.250	0.400	67.5	26.867	26.467	27.227	26.183		26.4652
1.250	0.400	68.0	27.066	26.666	27.427	26.382	26.6660	26.6660
1.250	0.400	68.5	27.265	26.865	27.626	26.581		26.8632
1.250	0.400	69.0	27.464	27.064	27.825	26.780	27.0569	27.0640
1.250	0.400	69.5	27.663	27.263	28.024	26.979		27.2612
1.250	0.400	70.0	27.861	27.461	28.222	27.178	27.4610	27.4610
1.250	0.400	70.5	28.060	27.660	28.421	27.377		27.6583
1.250	0.400	71.0	28.259	27.859	28.620	27.577	27.8521	27.8590

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	71.5	28.458	28.058	28.819	27.776		28.0563
1.250	0.400	72.0	28.657	28.257	29.018	27.975	28.2570	28.2570
1.250	0.400	72.5	28.856	28.456	29.217	28.174		28.4543
1.250	0.400	73.0	29.055	28.655	29.417	28.373	28.6483	28.6550
1.250	0.400	73.5	29.254	28.854	29.616	28.572		28.8523
1.250	0.400	74.0	29.453	29.053	29.815	28.771	29.0530	29.0530
1.250	0.400	74.5	29.651	29.251	30.013	28.970		29.2494
1.250	0.400	75.0	29.850	29.450	30.212	29.169	29.4435	29.4500
1.250	0.400	75.5	30.049	29.649	30.411	29.368		29.6474
1.250	0.400	76.0	30.248	29.848	30.610	29.567	29.8480	29.8480
1.250	0.400	76.5	30.447	30.047	30.809	29.766		30.0454
1.250	0.400	77.0	30.646	30.246	31.008	29.965	30.2396	30.2460
1.250	0.400	77.5	30.845	30.445	31.207	30.164		30.4434
1.250	0.400	78.0	31.044	30.644	31.406	30.363	30.6440	30.6440
1.250	0.400	78.5	31.243	30.843	31.605	30.562		30.8414
1.250	0.400	79.0	31.441	31.041	31.804	30.762	31.0346	31.0410
1.250	0.400	79.5	31.640	31.240	32.003	30.961		31.2385
1.250	0.400	80.0	31.839	31.439	32.202	31.160	31.4390	31.4390
1.250	0.400	80.5	32.038	31.638	32.401	31.359		31.6365
1.250	0.400	81.0	32.237	31.837	32.600	31.558	31.8309	31.8370
1.250	0.400	81.5	32.436	32.036	32.799	31.757		32.0345
1.250	0.400	82.0	32.635	32.235	32.998	31.956	32.2350	32.2350
1.250	0.400	82.5	32.834	32.434	33.197	32.155		32.4325
1.250	0.400	83.0	33.033	32.633	33.396	32.354	32.6271	32.6330
1.250	0.400	83.5	33.231	32.831	33.594	32.553		32.8295
1.250	0.400	84.0	33.430	33.030	33.793	32.752	33.0300	33.0300
1.250	0.400	84.5	33.629	33.229	33.992	32.951		33.2275

TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	85.0	33.828	33.428	34.191	33.150	33.4222	33.4280
1.250	0.400	85.5	34.027	33.627	34.391	33.349		33.6256
1.250	0.400	86.0	34.226	33.826	34.590	33.548	33.8260	33.8260
1.250	0.400	86.5	34.425	34.025	34.789	33.747		34.0236
1.250	0.400	87.0	34.624	34.224	34.988	33.946	34.2184	34.2240
1.250	0.400	87.5	34.823	34.423	35.187	34.145		34.4216
1.250	0.400	88.0	35.022	34.622	35.386	34.344	34.6220	34.6220
1.250	0.400	88.5	35.220	34.820	35.584	34.543		34.8186
1.250	0.400	89.0	35.419	35.019	35.783	34.742	35.0135	35.0190
1.250	0.400	89.5	35.618	35.218	35.982	34.941		35.2166
1.250	0.400	90.0	35.817	35.417	36.181	35.140	35.4170	35.4170
1.250	0.400	90.5	36.016	35.616	36.380	35.339		35.6146
1.250	0.400	91.0	36.215	35.815	36.579	35.538	35.8096	35.8150
1.250	0.400	91.5	36.414	36.014	36.778	35.737		36.0127
1.250	0.400	92.0	36.613	36.213	36.977	35.936	36.2130	36.2130
1.250	0.400	92.5	36.812	36.412	37.176	36.135		36.4107
1.250	0.400	93.0	37.011	36.611	37.375	36.334	36.6057	36.6110
1.250	0.400	93.5	37.209	26.809	37.574	36.533		36.8077
1.250	0.400	94.0	37.408	37.008	37.773	36.732	37.0080	37.0080
1.250	0.400	94.5	37.607	37.207	37.972	36.932		37.2057
1.250	0.400	95.0	37.806	37.406	38.171	37.131	37.4008	37.4060
1.250	0.400	95.5	38.005	37.605	38.370	37.330		37.6037
1.250	0.400	96.0	38.204	37.804	38.569	37.529	37.8040	37.8040
1.250	0.400	96.5	38.403	38.003	38.768	37.728		38.0017
1.250	0.400	97.0	38.602	38.202	38.967	37.927	38.1969	38.2020
1.250	0.400	97.5	38.801	38.401	39.166	38.126		38.3997
1.250	0.400	98.0	39.000	38.600	39.365	38.325	38.6000	38.6000

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.250	0.400	98.5	39.199	38.799	39.564	38.524		38.7978
1.250	0.400	99.0	39.397	38.997	39.762	38.723	38.9920	38.9970
1.250	0.400	99.5	39.596	39.196	39.961	38.922		39.1948
1.250	0.400	100.0	39.795	39.395	40.160	39.121	39.3950	39.3950
1.500	0.469	5.0	2.552	2.083	2.758	1.285	1.9581	2.0830
1.500	0.469	5.5	2.774	2.305	3.004	1.554		2.2768
1.500	0.469	6.0	3.000	2.531	3.249	1.818	2.5310	2.5310
1.500	0.469	6.5	3.228	2.759	3.493	2.078		2.7355
1.500	0.469	7.0	3.457	2.988	3.736	2.335	2.9013	2.9880
1.500	0.469	7.5	3.688	3.219	3.979	2.589		3.1988
1.500	0.469	8.0	3.920	3.451	4.221	2.841	3.4510	3.4510
1.500	0.469	8.5	4.152	3.683	4.462	3.092		3.6653
1.500	0.469	9.0	4.386	3.917	4.704	3.341	3.8504	3.9170
1.500	0.469	9.5	4.620	4.151	4.945	3.589		4.1352
1.500	0.469	10.0	4.854	4.385	5.185	3.837	4.3850	4.3850
1.500	0.469	10.5	5.089	4.620	5.426	4.083		4.6058
1.500	0.469	11.0	5.324	4.855	5.666	4.329	4.8008	4.8550
1.500	0.469	11.5	5.560	5.091	5.907	4.574		5.0780
1.500	0.469	12.0	5.796	5.327	6.147	4.818	5.3270	5.3270
1.500	0.469	12.5	6.032	5.563	6.387	5.062		5.5511
1.500	0.469	13.0	6.268	5.799	6.627	5.306	5.75.33	5.7990
1.500	0.469	13.5	6.504	6.035	6.866	5.549		6.0240
1.500	0.469	14.0	6.741	6.272	7.106	5.792	6.2720	6.2720
1.500	0.469	14.5	6.978	6.509	7.346	6.035		6.4988
1.500	0.469	15.0	7.215	6.746	7.586	6.277	6.7065	6.7460
1.500	0.469	15.5	7.452	6.983	7.826	6.519		6.9734
1.500	0.469	16.0	7.689	7.220	8.065	6.761	7.2200	7.2200

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	16.5	7.926	7.457	8.304	7.003		7.4480
1.500	0.469	17.0	8.163	7.694	8.544	7.244	7.6592	7.6940
1.500	0.469	17.5	8.401	7.932	8.784	7.486		7.9235
1.500	0.469	18.0	8.638	8.169	9.022	7.727	8.1690	8.1690
1.500	0.469	18.5	8.876	8.407	9.262	7.968		8.3990
1.500	0.469	19.0	9.113	8.644	9.501	8.209	8.6129	8.6440
1.500	0.469	19.5	9.351	8.882	9.740	8.450		8.8744
1.500	0.469	20.0	9.589	9.120	9.980	8.691	9.1200	9.1200
1.500	0.469	20.5	9.826	9.357	10.218	8.931		9.3498
1.500	0.469	21.0	10.064	9.595	10.458	9.172	9.5669	9.5950
1.500	0.469	21.5	10.302	9.833	10.697	9.412		9.8261
1.500	0.469	22.0	10.540	10.071	10.936	9.653	10.0710	10.0710
1.500	0.469	22.5	10.778	10.309	11.176	9.893		10.3024
1.500	0.469	23.0	11.016	10.547	11.415	10.133	10.5213	10.5470
1.500	0.469	23.5	11.254	10.785	11.654	10.373		10.7787
1.500	0.469	24.0	11.492	11.023	11.893	10.614	11.0230	11.0230
1.500	0.469	24.5	11.730	11.261	12.132	10.854		11.2550
1.500	0.469	25.0	11.968	11.499	12.371	11.094	11.4754	11.4990
1.500	0.469	25.5	12.206	11.737	12.610	11.334		11.7312
1.500	0.469	26.0	12.444	11.975	12.849	11.574	11.9750	11.9750
1.500	0.469	26.5	12.683	12.214	13.088	11.813		12.2084
1.500	0.469	27.0	12.921	12.452	13.327	12.053	12.4301	12.4520
1.500	0.469	27.5	13.159	12.690	13.566	12.293		12.6846
1.500	0.469	28.0	13.397	12.928	13.805	12.533	12.9280	12.9280
1.500	0.469	28.5	13.635	13.166	14.044	12.773		13.1608
1.500	0.469	29.0	13.874	13.405	14.283	13.012	13.3847	13.4050
1.500	0.469	29.5	14.112	13.643	14.522	13.252		13.6380

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	30.0	14.350	13.881	14.761	13.492	13.8810	13.8810
1.500	0.469	30.5	14.588	14.119	14.999	13.731		14.1142
1.500	0.469	31.0	14.827	14.358	15.239	13.971	14.3390	14.3580
1.500	0.469	31.5	15.065	14.596	15.478	14.210		14.5913
1.500	0.469	32.0	15.303	14.834	15.716	14.450	14.8340	14.8340
1.500	0.469	32.5	15.542	15.073	15.956	14.689		15.0685
1.500	0.469	33.0	15.780	15.311	16.194	14.929	15.2931	15.3110
1.500	0.469	33.5	16.019	15.550	16.434	15.168		15.5456
1.500	0.469	34.0	16.257	15.788	16.672	15.408	15.7880	15.7880
1.500	0.469	34.5	16.495	16.026	16.911	15.647		16.0217
1.500	0.469	35.0	16.734	16.265	17.150	15.886	16.2481	16.2650
1.500	0.469	35.5	16.972	16.503	17.389	16.126		16.4988
1.500	0.469	36.0	17.211	16.742	17.628	16.365	16.7420	16.7420
1.500	0.469	36.5	17.449	16.980	17.867	16.604		16.9760
1.500	0.469	37.0	17.687	17.218	18.105	16.844	17.2021	17.2180
1.500	0.469	37.5	17.926	17.457	18.345	17.083		17.4531
1.500	0.469	38.0	18.164	17.695	18.583	17.322	17.6950	17.6950
1.500	0.469	38.5	18.403	17.934	18.822	17.562		17.9302
1.500	0.469	39.0	18.641	18.172	19.061	17.801	18.1569	18.1720
1.500	0.469	39.5	18.880	18.411	19.300	18.040		18.4073
1.500	0.469	40.0	19.118	18.649	19.539	18.279	18.6490	18.6490
1.500	0.469	40.5	19.357	18.888	19.778	18.519		18.8844
1.500	0.469	41.0	19.595	19.126	20.016	18.758	19.1116	19.1260
1.500	0.469	41.5	19.834	19.365	20.256	18.997		19.3614
1.500	0.469	42.0	20.072	19.603	20.494	19.236	19.6030	19.6030
1.500	0.469	42.5	20.311	19.842	20.733	19.475		19.8385
1.500	0.469	43.0	20.549	20.080	20.972	19.714	20.0663	20.0800

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	43.5	20.788	20.319	21.211	19.954		20.3156
1.500	0.469	44.0	21.026	20.557	21.449	20.193	20.5570	20.5570
1.500	0.469	44.5	21.265	20.796	21.689	20.432		20.7927
1.500	0.469	45.0	21.503	21.034	21.927	20.671	21.0209	21.0340
1.500	0.469	45.5	21.742	21.273	22.166	20.910		21.2698
1.500	0.469	46.0	21.980	21.511	22.404	21.149	21.5110	21.5110
1.500	0.469	46.5	22.219	21.750	22.644	21.388		21.7468
1.500	0.469	47.0	22.458	21.989	22.883	21.627	21.9765	21.9890
1.500	0.469	47.5	22.696	22.227	23.121	21.866		22.2239
1.500	0.469	48.0	22.935	22.466	23.360	22.106	22.4660	22.4660
1.500	0.469	48.5	23.173	22.704	23.599	22.345		22.7010
1.500	0.469	49.0	23.412	22.943	23.838	22.584	22.9310	22.9430
1.500	0.469	49.5	23.650	23.181	24.076	22.823		23.1780
1.500	0.469	50.0	23.889	23.420	24.315	23.062	23.4200	23.4200
1.500	0.469	50.5	24.128	23.659	24.555	23.301		23.6561
1.500	0.469	51.0	24.366	23.897	24.793	23.540	23.8854	23.8970
1.500	0.469	51.5	24.605	24.136	25.032	23.779		24.1331
1.500	0.469	52.0	24.843	24.374	25.270	24.018	24.3740	24.3740
1.500	0.469	52.5	25.082	24.613	25.510	24.257		24.6102
1.500	0.469	53.0	25.320	24.851	25.748	24.496	24.8399	24.8510
1.500	0.469	53.5	25.559	25.090	25.987	24.735		25.0872
1.500	0.469	54.0	25.798	25.329	26.226	24.974	25.3290	25.3290
1.500	0.469	54.5	26.036	25.567	26.464	25.213		25.5643
1.500	0.469	55.0	26.275	25.806	26.704	25.452	25.7953	25.8060
1.500	0.469	55.5	26.513	26.044	26.942	25.691		26.0413
1.500	0.469	56.0	26.752	26.283	27.181	25.930	26.2830	26.2830
1.500	0.469	56.5	26.991	26.522	27.420	26.169		26.5194

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	57.0	27.229	26.760	27.658	26.408	26.7497	26.7600
1.500	0.469	57.5	27.468	26.999	27.898	26.647		26.9964
1.500	0.469	58.0	27.707	27.238	28.137	26.886	27.2380	27.2380
1.500	0.469	58.5	27.945	27.476	28.375	27.125		27.4735
1.500	0.469	59.0	28.184	27.715	28.614	27.364	27.7050	27.7150
1.500	0.469	59.5	28.422	27.953	28.852	27.603		27.9505
1.500	0.469	60.0	28.661	28.192	29.091	27.842	28.1920	28.1920
1.500	0.469	60.5	28.900	28.431	29.331	28.081		28.4286
1.500	0.469	61.0	29.138	28.669	29.569	28.320	28.6593	28.6690
1.500	0.469	61.5	29.377	28.908	29.808	28.559		28.9056
1.500	0.469	62.0	29.615	29.146	30.046	28.797	29.1460	29.1460
1.500	0.469	62.5	29.854	29.385	30.285	29.036		29.3826
1.500	0.469	63.0	30.093	29.624	30.524	29.275	29.6146	29.6240
1.500	0.469	63.5	30.331	29.862	30.762	29.514		29.8597
1.500	0.469	64.0	30.570	30.101	31.002	29.753	30.1010	30.1010
1.500	0.469	64.5	30.809	30.340	31.241	29.992		30.3377
1.500	0.469	65.0	31.047	30.578	31.479	30.231	30.5689	30.5780
1.500	0.469	65.5	31.286	30.817	31.718	30.470		30.8148
1.500	0.469	66.0	31.525	31.056	31.957	30.709	31.0560	31.0560
1.500	0.469	66.5	31.763	31.294	32.195	30.948		31.2918
1.500	0.469	67.0	32.002	31.533	32.434	31.187	31.5242	31.5330
1.500	0.469	67.5	32.241	31.772	32.674	31.426		31.7698
1.500	0.469	68.0	32.479	32.010	32.912	31.665	32.0100	32.0100
1.500	0.469	68.5	32.718	32.249	33.151	31.903		32.2468
1.500	0.469	69.0	32.956	32.487	33.389	32.142	32.4785	32.4870
1.500	0.469	69.5	33.195	32.726	33.628	32.381		32.7239
1.500	0.469	70.0	33.434	32.965	33.867	32.620	32.9650	32.9650



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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	70.5	33.672	33.203	34.105	32.859		33.2009
1.500	0.469	71.0	33.911	33.442	34.344	33.098	33.4337	33.4420
1.500	0.469	71.5	34.150	33.681	34.584	33.337		33.6789
1.500	0.469	72.0	34.388	33.919	34.822	33.576	33.9190	33.9190
1.500	0.469	72.5	34.627	34.158	35.061	33.815		34.1560
1.500	0.469	73.0	34.866	34.397	35.300	34.053	34.3889	34.3970
1.500	0.469	73.5	35.104	34.635	35.538	34.292		34.6330
1.500	0.469	74.0	35.343	34.874	35.777	34.531	34.8740	34.8740
1.500	0.469	74.5	35.582	35.113	36.016	34.770		35.1110
1.500	0.469	75.0	35.820	35.351	36.254	35.009	35.3431	35.3510
1.500	0.469	75.5	36.059	35.590	36.493	35.248		35.5880
1.500	0.469	76.0	36.298	35.829	36.732	35.487	35.8290	35.8290
1.500	0.469	76.5	36.536	36.067	36.971	35.726		36.0651
1.500	0.469	77.0	36.775	36.306	37.210	35.964	36.2983	36.3060
1.500	0.469	77.5	37.014	36.545	37.449	36.203		36.5431
1.500	0.469	78.0	37.252	36.783	37.687	36.442	36.7830	36.7830
1.500	0.469	78.5	37.491	37.022	37.926	36.681		37.0201
1.500	0.469	79.0	37.730	37.261	38.165	36.920	37.2535	37.2610
1.500	0.469	79.5	37.968	37.499	38.403	37.159		37.4971
1.500	0.469	80.0	38.207	37.738	38.642	37.398	37.7380	37.7380
1.500	0.469	80.5	38.446	37.977	38.881	37.636		37.9752
1.500	0.469	81.0	38.684	38.215	39.119	37.875	38.2077	38.2150
1.500	0.469	81.5	38.923	38.454	39.359	38.114		38.4522
1.500	0.469	82.0	39.162	38.693	39.598	38.353	38.6930	38.6930
1.500	0.469	82.5	39.400	38.931	39.836	38.592		38.9292
1.500	0.469	83.0	39.639	39.170	40.075	38.831	39.1629	39.1700
1.500	0.469	83.5	39.878	39.409	40.314	39.069		39.4072

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	84.0	40.116	39.647	40.552	39.308	39.6470	39.6470
1.500	0.469	84.5	40.355	39.886	40.791	39.547		39.8843
1.500	0.469	85.0	40.594	40.125	41.030	39.786	40.1181	40.1250
1.500	0.469	85.5	40.832	40.363	41.268	40.025		40.3613
1.500	0.469	86.0	41.071	40.602	41.507	40.264	40.6020	40.6020
1.500	0.469	86.5	41.310	40.841	41.746	40.503		40.8393
1.500	0.469	87.0	41.548	41.079	41.984	40.741	41.0722	41.0790
1.500	0.469	87.5	41.787	41.318	42.224	40.980		41.3163
1.500	0.469	88.0	42.026	41.557	42.463	41.219	41.5570	41.5570
1.500	0.469	88.5	42.265	41.796	42.702	41.458		41.7973
1.500	0.469	89.0	42.503	42.034	42.940	41.697	42.0274	42.0340
1.500	0.469	89.5	42.742	42.273	43.179	41.936		42.2714
1.500	0.469	90.0	42.981	42.512	43.418	42.174	42.5120	42.5120
1.500	0.469	90.5	43.219	42.750	43.656	42.413		42.7484
1.500	0.469	91.0	43.458	42.989	43.895	42.652	42.9825	42.9890
1.500	0.469	91.5	43.697	43.228	44.134	42.891		43.2264
1.500	0.469	92.0	43.935	43.466	44.372	43.130	43.4660	43.4660
1.500	0.469	92.5	44.174	43.705	44.611	43.369		43.7034
1.500	0.469	93.0	44.413	43.944	44.850	43.607	43.9377	43.9440
1.500	0.469	93.5	44.651	44.182	45.088	43.846		44.1804
1.500	0.469	94.0	44.890	44.421	45.327	44.085	44.4210	44.4210
1.500	0.469	94.5	45.129	44.660	45.567	44.324		44.6584
1.500	0.469	95.0	45.367	44.898	45.805	44.563	44.8918	44.8980
1.500	0.469	95.5	45.606	45.137	46.044	44.801		45.1355
1.500	0.469	96.0	45.845	45.376	46.283	45.040	45.3760	45.3760
1.500	0.469	96.5	46.084	45.615	46.522	45.279		45.6135
1.500	0.469	97.0	46.322	45.853	46.760	45.518	45.8469	45.8530

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
1.500	0.469	97.5	46.561	46.092	46.999	45.757		46.0905
1.500	0.469	98.0	46.800	46.331	47.238	45.996	46.3310	46.3310
1.500	0.469	98.5	47.038	46.569	47.476	46.234		46.5675
1.500	0.469	99.0	47.277	46.808	47.715	46.473	46.8020	46.8080
1.500	0.469	99.5	47.516	47.047	47.954	46.712		47.0455
1.500	0.469	100.0	47.754	47.285	48.192	46.951	47.2850	47.2850
2.000	0.625	5.0	3.403	2.778	3.678	1.723	2.6114	2.7780
2.000	0.625	5.5	3.699	3.074	4.005	2.082		3.0363
2.000	0.625	6.0	4.000	3.375	4.332	2.434	3.3750	3.3750
2.000	0.625	6.5	4.304	3.679	4.658	2.781		3.6476
2.000	0.625	7.0	4.610	3.985	4.982	3.123	3.8694	3.9850
2.000	0.625	7.5	4.917	4.292	5.304	3.462		4.2651
2.000	0.625	8.0	5.226	4.601	5.627	3.796	4.6010	4.6010
2.000	0.625	8.5	5.536	4.911	5.949	4.133		4.8874
2.000	0.625	9.0	5.848	5.223	6.272	4.465	5.1342	5.2230
2.000	0.625	9.5	6.160	5.535	6.593	4.796		5.5140
2.000	0.625	10.0	6.472	5.847	6.914	5.125	5.8470	5.8470
2.000	0.625	10.5	6.785	6.160	7.234	5.454		6.1410
2.000	0.625	11.0	7.099	6.474	7.555	5.781	6.4017	6.4740
2.000	0.625	11.5	7.413	6.788	7.876	6.108		6.7707
2.000	0.625	12.0	7.727	7.102	8.195	6.434	7.1020	7.1020
2.000	0.625	12.5	8.042	7.417	8.516	6.759		7.4011
2.000	0.625	13.0	8.357	7.732	8.836	7.084	7.6711	7.7320
2.000	0.625	13.5	8.672	8.047	9.155	7.409		8.0323
2.000	0.625	14.0	8.988	8.363	9.475	7.733	8.3630	8.3630
2.000	0.625	14.5	9.304	8.679	9.795	8.056		8.6654
2.000	0.625	15.0	9.619	8.994	10.114	8.379	8.8914	8.9940

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	15.5	9.935	9.310	10.433	8.702		9.2972
2.000	0.625	16.0	10.252	9.627	10.754	9.025	9.6270	9.6270
2.000	0.625	16.5	10.568	9.943	11.073	9.347		9.9310
2.000	0.625	17.0	10.884	10.259	11.391	9.669	10.2126	10.2590
2.000	0.625	17.5	11.201	10.576	11.711	9.991		10.5647
2.000	0.625	18.0	11.518	10.893	12.031	10.313	10.8930	10.8930
2.000	0.625	18.5	11.834	11.209	12.349	10.634		11.1983
2.000	0.625	19.0	12.151	11.526	12.668	10.955	11.4845	11.5260
2.000	0.625	19.5	12.468	11.843	12.987	11.276		11.8329
2.000	0.625	20.0	12.785	12.160	13.306	11.598	12.1600	12.1600
2.000	0.625	20.5	13.102	12.477	13.625	11.918		12.4674
2.000	0.625	21.0	13.419	12.794	13.944	12.239	12.7565	12.7940
2.000	0.625	21.5	13.736	13.111	14.263	12.560		13.1018
2.000	0.625	22.0	14.053	13.428	14.581	12.680	13.4280	13.4280
2.000	0.625	22.5	14.371	13.746	14.901	13.201		13.7372
2.000	0.625	23.0	14.688	14.063	15.220	13.521	14.0288	14.0630
2.000	0.625	23.5	15.005	14.380	15.538	13.841		14.3716
2.000	0.625	24.0	15.323	14.698	15.857	14.162	14.6980	14.6980
2.000	0.625	24.5	15.640	15.015	16.176	14.482		15.0070
2.000	0.625	25.0	15.957	15.332	16.494	14.802	15.3005	15.3320
2.000	0.625	25.5	16.275	15.650	16.813	15.122		15.6423
2.000	0.625	26.0	16.592	15.967	17.132	15.441	15.9670	15.9670
2.000	0.625	26.5	16.910	16.285	17.451	15.761		16.2776
2.000	0.625	27.0	17.228	16.603	17.770	16.081	16.6739	16.6030
2.000	0.625	27.5	17.545	16.920	18.088	16.401		16.9128
2.000	0.625	28.0	17.863	17.238	18.407	16.720	17.2380	17.2380
2.000	0.625	28.5	18.180	17.555	18.725	17.040		17.5481

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	29.0	18.498	17.873	19.044	17.360	14.8459	17.8730
2.000	0.625	29.5	18.816	18.191	19.363	17.679		18.1843
2.000	0.625	30.0	19.134	18.509	19.682	17.999	18.5090	18.5090
2.000	0.625	30.5	19.451	18.826	19.999	18.318		18.8196
2.000	0.625	31.0	19.769	19.144	20.318	18.638	19.1186	19.1440
2.000	0.625	31.5	20.087	19.462	20.637	18.957		19.4558
2.000	0.625	32.0	20.405	19.780	20.956	19.276	19.7800	19.7800
2.000	0.625	32.5	20.722	20.097	21.274	19.596		20.0909
2.000	0.625	33.0	21.040	20.415	21.592	19.915	20.3912	20.4150
2.000	0.625	33.5	21.358	20.733	21.911	20.234		20.7271
2.000	0.625	34.0	21.676	21.051	22.230	20.553	21.0510	21.0510
2.000	0.625	34.5	21.994	21.369	22.548	20.873		21.3633
2.000	0.625	35.0	22.312	21.687	22.867	21.192	21.6645	21.6870
2.000	0.625	35.5	22.630	22.005	23.186	21.511		21.9995
2.000	0.625	36.0	22.947	22.322	23.503	21.830	22.3220	22.3220
2.000	0.625	36.5	23.265	22.640	23.822	22.149		22.6346
2.000	0.625	37.0	23.583	22.958	24.141	22.468	22.9368	22.9580
2.000	0.625	37.5	23.901	23.276	24.459	22.787		23.2708
2.000	0.625	38.0	24.219	23.594	24.778	23.106	23.5940	23.5940
2.000	0.625	38.5	24.537	23.912	25.096	23.425		23.9069
2.000	0.625	39.0	24.855	24.230	25.415	23.744	24.2098	24.2300
2.000	0.625	39.5	25.173	24.548	25.733	24.063		24.5430
2.000	0.625	40.0	25.491	24.866	26.052	24.382	24.8660	24.8660
2.000	0.625	40.5	25.809	25.184	26.370	24.701		25.1791
2.000	0.625	41.0	26.127	25.502	26.689	25.020	25.4828	25.5020
2.000	0.625	41.5	26.445	25.820	27.007	25.339		25.8153
2.000	0.625	42.0	26.763	26.138	27.326	25.658	26.1380	26.1380

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	42.5	27.081	26.456	27.644	25.977		26.4514
2.000	0.625	43.0	27.399	26.774	27.962	26.296	26.7557	26.7740
2.000	0.625	43.5	27.717	27.092	28.281	26.615		27.0875
2.000	0.625	44.0	28.035	27.410	28.599	26.934	27.4100	27.4100
2.000	0.625	44.5	28.353	27.728	28.918	27.253		27.7236
2.000	0.625	45.0	28.671	28.046	29.236	27.571	28.0285	28.0460
2.000	0.625	45.5	28.989	28.364	29.554	27.890		28.3597
2.000	0.625	46.0	29.307	28.682	29.873	28.209	28.6820	28.6820
2.000	0.625	46.5	29.625	29.000	30.191	28.528		28.9958
2.000	0.625	47.0	29.943	29.318	30.510	28.847	29.3013	29.3180
2.000	0.625	47.5	30.261	29.636	30.828	29.165		29.6319
2.000	0.625	48.0	30.580	29.955	31.147	29.484	29.9550	29.9550
2.000	0.625	48.5	30.898	30.273	31.466	29.803		30.2689
2.000	0.625	49.0	31.216	30.591	31.784	30.122	30.5750	30.5910
2.000	0.625	49.5	31.534	30.909	32.102	30.440		30.9050
2.000	0.625	50.0	31.852	31.227	32.421	30.759	31.2270	31.2270
2.000	0.625	50.5	32.170	31.545	32.739	31.078		31.5411
2.000	0.625	51.0	32.488	31.863	33.057	31.397	31.8476	31.8630
2.000	0.625	51.5	32.806	32.181	33.375	31.715		32.1772
2.000	0.625	52.0	33.124	32.499	33.694	32.034	32.4990	32.4990
2.000	0.625	52.5	33.442	32.817	34.012	32.353		32.8133
2.000	0.625	53.0	33.761	33.136	34.331	32.671	33.1212	33.1360
2.000	0.625	53.5	34.079	33.454	34.650	32.990		33.4503
2.000	0.625	54.0	34.397	33.772	31.968	33.309	33.7720	33.7720
2.000	0.625	54.5	34.715	34.090	35.286	33.627		34.0864
2.000	0.625	55.0	35.033	34.408	35.604	33.946	34.3937	34.4080
2.000	0.625	55.5	35.351	34.726	35.923	34.265		34.7225

## MIL-STD-627A

TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	56.0	35.669	35.044	36.241	34.583	35.0440	35.0440
2.000	0.625	56.5	35.988	35.363	36.560	34.902		35.3595
2.000	0.625	57.0	36.306	35.681	36.878	35.221	35.6672	35.6810
2.000	0.625	57.5	36.624	35.999	37.197	35.539		35.9956
2.000	0.625	58.0	36.942	36.317	37.515	35.858	36.3170	36.3170
2.000	0.625	58.5	37.260	36.635	37.833	36.176		36.6316
2.000	0.625	59.0	37.578	36.953	38.151	36.495	36.9397	36.9530
2.000	0.625	59.5	37.896	37.271	38.470	36.814		37.2677
2.000	0.625	60.0	38.215	37.590	38.789	37.132	37.5900	37.5900
2.000	0.625	60.5	38.533	37.908	39.107	37.451		37.9048
2.000	0.625	61.0	38.851	38.226	39.425	37.769	38.2131	38.2260
2.000	0.625	61.5	39.169	38.544	39.743	38.088		38.5408
2.000	0.625	62.0	39.487	38.862	40.062	38.407	38.8620	38.8620
2.000	0.625	62.5	39.805	39.180	40.380	38.725		39.1769
2.000	0.625	63.0	40.124	39.499	40.699	39.044	39.4865	39.4990
2.000	0.625	63.5	40.442	39.817	41.017	39.362		39.8139
2.000	0.625	64.0	40.760	40.135	41.335	39.681	40.1350	40.1350
2.000	0.625	64.5	41.078	40.453	41.654	40.000		40.4500
2.000	0.625	65.0	41.396	40.771	41.972	40.318	40.7589	40.7710
2.000	0.625	65.5	41.715	41.090	42.291	40.637		41.0870
2.000	0.625	66.0	42.033	41.408	42.609	40.955	41.4080	41.4080
2.000	0.625	66.5	42.351	41.726	42.927	41.274		41.7230
2.000	0.625	67.0	42.669	42.044	43.246	41.592	42.0323	42.0440
2.000	0.625	67.5	42.987	42.362	43.564	41.911		42.3591
2.000	0.625	68.0	43.306	42.681	43.883	42.229	42.6810	42.6810
2.000	0.625	68.5	43.624	42.999	44.201	42.548		42.9961
2.000	0.625	69.0	43.942	43.317	44.519	42.866	43.3056	43.3170

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	69.5	44.260	43.635	44.837	43.185		43.6322
2.000	0.625	70.0	44.578	43.953	45.156	43.503	43.9530	43.9530
2.000	0.625	70.5	44.897	44.272	45.475	43.822		44.2692
2.000	0.625	71.0	45.215	44.590	45.793	44.141	44.5789	44.5900
2.000	0.625	71.5	45.533	44.908	46.111	44.459		44.9053
2.000	0.625	72.0	45.851	45.226	46.429	44.778	45.2260	45.2260
2.000	0.625	72.5	46.169	45.544	46.747	45.096		45.5413
2.000	0.625	73.0	46.488	45.863	47.066	45.415	45.8522	45.8630
2.000	0.625	73.5	46.806	46.181	47.385	45.733		46.1783
2.000	0.625	74.0	47.124	46.499	47.703	46.052	46.4990	46.4990
2.000	0.625	74.5	47.442	46.817	48.021	46.370		46.8144
2.000	0.625	75.0	47.760	47.135	48.339	46.689	47.1245	14.1350
2.000	0.625	75.5	48.079	47.454	48.658	47.007		47.4514
2.000	0.625	76.0	48.397	47.772	48.976	47.326	47.7720	47.7720
2.000	0.625	76.5	48.715	48.090	49.294	47.644		48.0874
2.000	0.625	77.0	49.033	48.408	49.613	47.963	48.3978	48.4080
2.000	0.625	77.5	49.352	48.727	49.932	48.281		48.7245
2.000	0.625	78.0	49.670	49.045	50.250	48.599	49.0450	49.0450
2.000	0.625	78.5	49.988	49.363	50.568	48.918		49.3605
2.000	0.625	79.0	50.306	49.681	50.886	49.236	49.6711	49.6810
2.000	0.625	79.5	50.624	49.999	51.204	49.555		49.9965
2.000	0.625	80.0	50.943	50.318	51.523	49.873	50.3180	50.3180
2.000	0.625	80.5	51.261	50.636	51.841	50.192		50.6336
2.000	0.625	81.0	51.579	50.954	52.160	50.510	50.9443	50.9540
2.000	0.625	81.5	51.897	51.272	52.478	50.829		51.2696
2.000	0.625	82.0	52.216	51.591	52.797	51.147	51.5910	51.5910
2.000	0.625	82.5	52.534	51.909	53.115	51.466		51.9066



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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	83.0	52.852	52.227	53.433	51.784	52.2175	52.2270
2.000	0.625	83.5	53.170	52.545	53.751	52.103		52.5426
2.000	0.625	84.0	53.489	52.864	54.070	52.421	52.8640	52.8640
2.000	0.625	84.5	53.807	53.182	54.388	52.740		52.1797
2.000	0.625	85.0	52.125	53.500	54.707	53.058	53.4908	53.5000
2.000	0.625	85.5	54.443	53.818	55.025	53.376		53.8157
2.000	0.625	86.0	54.761	54.136	55.343	53.695	54.1360	54.1360
2.000	0.625	86.5	55.080	54.455	55.662	54.013		54.4527
2.000	0.625	87.0	55.398	54.773	55.980	54.332	54.7640	54.7730
2.000	0.625	87.5	55.716	55.091	56.298	54.650		55.0888
2.000	0.625	88.0	56.034	55.409	56.616	54.969	55.4090	55.4090
2.000	0.625	88.5	56.353	55.728	56.935	55.287		55.7258
2.000	0.625	89.0	56.671	56.046	57.253	55.606	56.0372	56.0460
2.000	0.625	89.5	56.989	56.364	57.571	55.924		56.3618
2.000	0.625	90.0	57.307	56.682	57.890	56.243	56.6820	56.6820
2.000	0.625	90.5	57.626	57.001	58.209	56.561		56.9988
2.000	0.625	91.0	57.944	57.319	58.527	56.879	57.3104	57.3190
2.000	0.625	91.5	58.262	57.637	58.845	57.198		57.6349
2.000	0.625	92.0	58.580	57.955	59.163	57.516	57.9550	57.9550
2.000	0.625	92.5	58.899	58.274	59.482	57.835		58.2719
2.000	0.625	93.0	59.217	58.592	59.800	58.153	58.5836	58.5920
2.000	0.625	93.5	59.535	58.910	60.118	58.472		58.9079
2.000	0.625	94.0	59.853	59.228	60.436	58.790	59.2280	59.2280
2.000	0.625	94.5	60.172	59.547	60.755	59.108		59.5449
2.000	0.625	95.0	60.490	59.865	61.073	59.427	59.8567	59.8650
2.000	0.625	95.5	60.808	60.183	61.392	59.745		60.1809
2.000	0.625	96.0	61.126	60.501	61.710	60.064	60.5010	60.5010

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.000	0.625	96.5	61.445	60.820	52.029	60.382		60.8180
2.000	0.625	97.0	61.763	61.138	62.347	60.701	61.1299	61.1380
2.000	0.625	97.5	62.081	61.456	62.665	61.019		61.4540
2.000	0.625	98.0	62.399	61.774	62.983	61.337	61.7740	61.7740
2.000	0.625	98.5	62.718	62.093	63.302	61.656		62.0910
2.000	0.625	99.0	63.036	62.411	63.620	61.974	62.4031	62.4110
2.000	0.625	99.5	63.354	62.729	63.938	62.293		62.7270
2.000	0.625	100.0	63.672	63.047	64.256	62.611	63.0470	63.0470
2.500	0.750	5.0	4.253	3.503	4.597	2.161	3.2948	3.5030
2.500	0.750	5.5	4.624	3.874	5.007	2.610		3.8269
2.500	0.750	6.0	5.000	4.250	5.415	3.050	4.2500	4.2500
2.500	0.750	6.5	5.380	4.630	5.822	3.483		4.5908
2.500	0.750	7.0	5.762	5.012	6.227	3.911	4.8675	5.0120
2.500	0.750	7.5	6.146	5.396	6.630	4.335		5.3623
2.500	0.750	8.0	6.533	5.783	7.034	4.756	5.7830	5.7830
2.500	0.750	8.5	6.921	6.171	7.437	5.173		6.1415
2.500	0.750	9.0	7.310	6.560	7.840	5.589	6.4489	6.5600
2.500	0.750	9.5	7.699	6.949	8.240	6.002		6.9227
2.500	0.750	10.0	8.090	7.340	8.642	6.414	7.3400	7.3400
2.500	0.750	10.5	8.482	7.732	9.044	6.825		7.7083
2.500	0.750	11.0	8.874	8.124	9.444	7.234	8.0337	8.1240
2.500	0.750	11.5	9.266	8.516	9.844	7.643		8.4944
2.500	0.750	12.0	9.659	8.909	10.244	8.050	8.9090	8.9090
2.500	0.750	12.5	10.053	9.303	10.645	8.457		9.2832
2.500	0.750	13.0	10.446	9.696	11.044	8.863	9.6198	9.6960
2.500	0.750	13.5	10.841	10.091	11.445	9.268		10.0727
2.500	0.750	14.0	11.235	10.485	11.844	9.673	10.4850	10.4850

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	14.5	11.630	10.880	12.244	10.078		10.8629
2.500	0.750	15.0	12.024	11.274	12.643	10.482	11.2081	11.2740
2.500	0.750	15.5	12.419	11.669	13.042	10.885		11.6531
2.500	0.750	16.0	12.815	12.065	13.442	11.288	12.0650	12.0650
2.500	0.750	16.5	13.210	12.460	13.841	11.691		12.4450
2.500	0.750	17.0	13.605	12.855	14.239	12.094	12.7970	12.8550
2.500	0.750	17.5	14.001	13.251	14.639	12.496		13.2369
2.500	0.750	18.0	14.397	13.647	15.038	12.898	13.6470	13.6470
2.500	0.750	18.5	14.793	14.043	15.437	13.300		14.0297
2.500	0.750	19.0	15.189	14.439	15.835	13.702	14.3871	14.4390
2.500	0.750	19.5	15.585	14.835	16.234	14.103		14.8224
2.500	0.750	20.0	15.981	15.231	16.633	14.504	15.2310	15.2310
2.500	0.750	20.5	16.377	15.627	17.031	14.905		15.6150
2.500	0.750	21.0	16.774	16.024	17.430	15.306	15.9771	16.0240
2.500	0.750	21.5	17.170	16.420	17.829	15.707		16.4085
2.500	0.750	22.0	17.567	16.817	18.228	16.108	16.8170	16.8170
2.500	0.750	22.5	17.963	17.213	18.626	16.508		17.2021
2.500	0.750	23.0	18.360	17.610	19.025	16.909	17.5672	17.6100
2.500	0.750	23.5	18.757	18.007	19.423	17.309		17.9965
2.500	0.750	24.0	19.153	18.403	19.821	17.709	18.4030	18.4030
2.500	0.750	24.5	19.550	18.800	20.220	18.110		18.7900
2.500	0.750	25.0	19.947	19.197	20.618	18.510	19.1576	19.1970
2.500	0.750	25.5	20.344	19.594	21.017	18.909		19.5844
2.500	0.750	26.0	20.741	19.991	21.415	19.309	19.9910	19.9910
2.500	0.750	26.5	21.138	20.388	21.814	19.709		20.3787
2.500	0.750	27.0	21.534	20.784	22.211	20.109	20.7476	20.7840
2.500	0.750	27.5	21.931	21.181	22.610	20.509		21.1721

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	28.0	22.329	21.579	23.009	20.908	21.5790	21.5790
2.500	0.750	28.5	22.726	21.976	23.407	21.308		21.9674
2.500	0.750	29.0	23.123	22.373	23.805	21.707	22.3391	22.3730
2.500	0.750	29.5	23.520	22.770	24.203	22.107		22.7617
2.500	0.750	30.0	23.917	23.167	24.602	22.506	23.1670	23.1670
2.500	0.750	30.5	24.314	23.564	25.000	22.905		23.5559
2.500	0.750	31.0	24.711	23.961	25.398	23.305	23.9293	23.9610
2.500	0.750	31.5	25.109	24.359	25.797	23.704		24.3512
2.500	0.750	32.0	25.506	24.756	26.195	24.103	24.7560	24.7560
2.500	0.750	32.5	25.903	25.153	26.593	24.502		25.1454
2.500	0.750	33.0	26.300	25.550	26.990	24.901	25.5202	25.5500
2.500	0.750	33.5	26.698	25.948	27.389	25.300		25.9407
2.500	0.750	34.0	27.095	26.345	27.787	25.699	26.3450	26.3450
2.500	0.750	34.5	27.492	26.742	28.185	26.098	26.7349	26.7349
2.500	0.750	35.0	27.890	27.140	28.584	26.497	27.1119	27.1400
2.500	0.750	35.5	28.287	27.537	28.982	26.896		27.5301
2.500	0.750	36.0	28.684	27.934	29.379	27.295	27.9340	27.9340
2.500	0.750	36.5	29.082	28.332	29.778	27.694		28.3253
2.500	0.750	37.0	29.479	28.729	30.176	28.093	28.7024	28.7290
2.500	0.750	37.5	29.876	29.126	30.574	28.492		29.1194
2.500	0.750	38.0	30.274	29.524	30.972	28.891	29.5240	29.5240
2.500	0.750	38.5	30.671	29.921	31.370	29.289		29.9146
2.500	0.750	39.0	31.069	30.319	31.769	29.688	30.2938	30.3190
2.500	0.750	39.5	31.466	30.716	32.166	30.087		30.7098
2.500	0.750	40.0	31.864	31.114	32.565	30.486	31.1140	31.1140
2.500	0.750	40.5	32.261	31.511	32.963	30.884		31.5049
2.500	0.750	41.0	32.659	31.909	33.361	31.283	31.8850	31.9090

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	41.5	33.056	32.306	33.759	31.682		32.3001
2.500	0.750	42.0	33.454	32.704	34.157	32.080	32.7040	32.7040
2.500	0.750	42.5	33.851	33.101	34.555	32.479		33.0952
2.500	0.750	43.0	34.249	33.499	34.953	32.877	33.4762	33.4990
2.500	0.750	43.5	34.646	33.896	35.351	33.276		33.8904
2.500	0.750	44.0	35.044	34.294	35.749	33.675	34.2940	34.2940
2.500	0.750	44.5	35.441	34.691	36.147	34.073		34.6855
2.500	0.750	45.0	35.839	35.089	36.545	34.472	35.0672	35.0890
2.500	0.750	45.5	36.237	35.487	36.944	34.870		35.4816
2.500	0.750	46.0	36.634	35.884	37.341	35.269	35.8840	35.8840
2.500	0.750	46.5	37.032	36.282	37.740	35.667		36.2767
2.500	0.750	47.0	37.429	36.679	38.137	36.066	36.6591	36.6790
2.500	0.750	47.5	37.827	37.077	38.536	36.464		37.0718
2.500	0.750	48.0	38.224	37.474	38.933	36.863	37.4740	37.4740
2.500	0.750	48.5	38.622	37.872	39.332	37.261		37.8669
2.500	0.750	49.0	39.020	38.270	39.730	37.660	38.2500	38.2700
2.500	0.750	49.5	39.417	38.667	40.127	38.058		38.6620
2.500	0.750	50.0	39.815	39.065	40.526	38.456	39.0650	39.0650
2.500	0.750	50.5	40.213	39.463	40.924	38.855		39.4581
2.500	0.750	51.0	40.610	39.860	41.322	39.253	39.8407	39.8600
2.500	0.750	51.5	41.008	40.258	41.720	39.652		40.2532
2.500	0.750	52.0	41.405	40.655	42.117	40.050	40.6550	40.6550
2.500	0.750	52.5	41.803	41.053	42.516	40.448		41.0483
2.500	0.750	53.0	42.201	41.451	42.914	40.847	41.4325	41.4510
2.500	0.750	53.5	42.598	41.848	43.311	41.245		41.8434
2.500	0.750	54.0	42.996	42.246	43.710	41.643	42.2460	42.2460
2.500	0.750	54.5	43.394	42.644	44.108	42.042		42.6395

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	55.0	43.791	43.041	44.505	42.440	43.0231	43.0410
2.500	0.750	55.5	44.189	43.439	44.904	42.838		43.4846
2.500	0.750	56.0	44.587	43.837	45.302	43.237	43.8370	43.8370
2.500	0.750	56.5	44.984	44.234	45.699	43.635		44.2297
2.500	0.750	57.0	45.382	44.632	46.098	44.033	44.6148	44.6320
2.500	0.750	57.5	45.780	45.030	46.496	44.432		45.0257
2.500	0.750	58.0	46.178	45.426	46.894	44.830	45.4280	45.4280
2.500	0.750	58.5	46.575	45.825	47.291	45.228		45.8208
2.500	0.750	59.0	46.973	46.223	47.690	45.626	46.2064	46.2230
2.500	0.750	59.5	47.371	46.621	48.088	46.025		46.6169
2.500	0.750	60.0	47.768	47.018	48.485	46.423	47.0180	47.0180
2.500	0.750	60.5	48.166	47.416	48.884	46.821		47.4119
2.500	0.750	61.0	48.564	47.814	49.282	47.219	47.7979	47.8140
2.500	0.750	61.5	48.961	48.211	49.679	47.618		48.2070
2.500	0.750	62.0	49.359	48.609	50.077	48.016	48.6090	48.6090
2.500	0.750	62.5	49.757	49.007	50.476	48.414		49.0031
2.500	0.750	63.0	50.155	49.405	50.874	48.812	49.3894	49.4050
2.500	0.750	63.5	50.552	49.802	51.271	49.210		49.7981
2.500	0.750	64.0	50.950	50.200	51.669	49.609	50.2000	50.2000
2.500	0.750	64.5	51.348	50.598	52.068	50.007		50.5942
2.500	0.750	65.0	51.746	50.996	52.466	50.405	50.9809	50.9960
2.500	0.750	65.5	52.143	51.393	52.863	50.803		51.3893
2.500	0.750	66.0	52.541	51.791	53.261	51.201	51.7910	51.7910
2.500	0.750	66.5	52.939	52.189	53.659	51.600		52.1853
2.500	0.750	67.0	53.336	52.586	54.057	51.998	52.5713	52.5860
2.500	0.750	67.5	53.734	52.984	54.455	52.396		52.9804
2.500	0.750	68.0	54.132	53.382	54.853	52.794	53.3820	53.3820

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	68.5	54.530	53.780	55.251	53.192		53.7764
2.500	0.750	69.0	54.927	54.177	55.649	53.591	54.1628	54.1770
2.500	0.750	69.5	55.325	54.575	56.047	53.989		54.5715
2.500	0.750	70.0	55.723	54.973	56.445	54.387	54.9730	54.9730
2.500	0.750	70.5	56.121	55.371	56.843	54.785		55.3675
2.500	0.750	71.0	56.518	55.768	57.240	55.183	55.7542	55.7680
2.500	0.750	71.5	56.916	56.166	57.639	55.581		56.1626
2.500	0.750	72.0	57.314	56.564	58.037	55.979	56.5640	56.5640
2.500	0.750	72.5	57.712	56.962	58.435	56.378		56.9586
2.500	0.750	73.0	58.109	57.359	58.832	56.776	57.3455	57.3590
2.500	0.750	73.5	58.507	57.757	59.230	57.174		57.7537
2.500	0.750	74.0	58.905	58.155	59.628	57.572	58.1550	58.1550
2.500	0.750	74.5	59.303	58.553	60.027	57.970		58.5497
2.500	0.750	75.0	59.701	58.951	60.425	58.368	58.9379	58.9510
2.500	0.750	75.5	60.098	59.348	60.822	58.766		59.3447
2.500	0.750	76.0	60.496	59.746	61.220	59.164	59.7460	59.7460
2.500	0.750	76.5	60.894	60.144	61.618	59.563		60.1408
2.500	0.750	77.0	61.292	60.542	62.017	59.961	60.5292	60.5420
2.500	0.750	77.5	61.689	60.939	62.414	60.359		60.9358
2.500	0.750	78.0	62.087	61.337	62.812	60.757	61.3370	61.3370
2.500	0.750	78.5	62.485	61.735	63.210	61.155		61.7319
2.500	0.750	79.0	62.883	62.133	63.608	61.553	62.1206	62.1330
2.500	0.750	79.5	63.281	62.531	64.006	61.951		62.5279
2.500	0.750	80.0	63.678	62.928	64.403	62.349	62.9280	62.9280
2.500	0.750	80.5	64.076	63.326	64.802	62.747		63.3230
2.500	0.750	81.0	64.474	63.724	65.200	63.145	63.7119	63.7240
2.500	0.750	81.5	64.872	64.122	65.598	63.544		64.1190

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	82.0	65.269	64.519	65.995	63.942	64.5190	64.5190
2.500	0.750	82.5	65.667	64.917	66.393	64.340		64.9140
2.500	0.750	83.0	66.065	65.315	66.791	64.738	65.3032	65.3150
2.500	0.750	83.5	66.463	65.713	67.189	65.136		65.7101
2.500	0.750	84.0	66.861	66.111	67.588	65.534	66.1110	66.1110
2.500	0.750	84.5	67.258	66.508	67.985	65.932		66.5051
2.500	0.750	85.0	67.656	66.906	68.383	66.330	66.8944	66.9060
2.500	0.750	85.5	68.054	67.304	68.781	66.728		67.3011
2.500	0.750	86.0	68.452	67.702	69.179	67.126	67.7020	67.7020
2.500	0.750	86.5	68.850	68.100	69.577	67.524		68.0972
2.500	0.750	87.0	69.247	68.497	69.974	67.922	68.4857	68.4970
2.500	0.750	87.5	69.645	68.895	70.373	68.320		68.8922
2.500	0.750	88.0	70.043	69.293	70.771	68.718	69.2930	69.2930
2.500	0.750	88.5	70.441	69.691	71.169	69.116		69.6882
2.500	0.750	89.0	70.839	70.089	71.567	69.515	70.0780	70.0890
2.500	0.750	89.5	71.236	70.486	71.964	69.913		70.4833
2.500	0.750	90.0	71.634	70.884	72.362	70.311	70.8840	70.8840
2.500	0.750	90.5	72.032	71.282	72.760	70.709		71.2793
2.500	0.750	91.0	72.430	71.680	73.158	71.107	71.6692	71.6800
2.500	0.750	91.5	72.828	72.078	73.557	71.505		72.0753
2.500	0.750	92.0	73.226	72.476	73.955	71.903	72.4760	72.4760
2.500	0.750	92.5	73.623	72.873	74.352	72.301		72.8703
2.500	0.750	93.0	74.021	73.271	74.750	72.699	73.2604	73.2710
2.500	0.750	93.5	74.419	73.669	75.148	73.097		73.6664
2.500	0.750	94.0	74.817	74.067	75.546	73.495	74.0670	74.0670
2.500	0.750	94.5	75.215	74.465	75.944	73.893		74.4624
2.500	0.750	95.0	75.612	74.862	76.341	74.291	74.8517	74.8620



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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
2.500	0.750	95.5	76.010	75.260	76.739	74.689		75.2574
2.500	0.750	96.0	76.408	75.658	77.138	75.087	75.6580	75.6580
2.500	0.750	96.5	76.806	76.056	77.536	75.485		76.0535
2.500	0.750	97.0	77.204	76.454	77.934	75.883	76.4439	76.4540
2.500	0.750	97.5	77.601	76.851	78.331	76.281		76.8485
2.500	0.750	98.0	77.999	77.249	78.729	76.679	77.2490	77.2490
2.500	0.750	98.5	78.397	77.647	79.127	77.077		77.6445
2.500	0.750	99.0	78.795	78.045	79.525	77.475	78.0351	78.0450
2.500	0.750	99.5	79.193	78.443	79.923	77.873		78.4405
2.500	0.750	100.0	79.591	78.841	80.321	78.271	78.8410	78.8410
3.000	0.875	5.0	5.104	4.229	5.517	2.599	3.9792	4.2290
3.000	0.875	5.5	5.549	4.674	6.009	3.138		4.6175
3.000	0.875	6.0	6.000	5.125	6.498	3.666	5.1250	5.1250
3.000	0.875	6.5	6.455	5.580	6.985	4.186		5.5329
3.000	0.875	7.0	6.914	6.039	7.472	4.700	5.8657	6.0390
3.000	0.875	7.5	7.376	6.501	7.957	5.208		6.4606
3.000	0.875	8.0	7.839	6.964	8.441	5.713	6.9640	6.9640
3.000	0.875	8.5	8.305	7.430	8.925	6.214		7.3946
3.000	0.875	9.0	8.771	7.896	9.407	6.712	7.7627	7.8960
3.000	0.845	9.5	9.239	8.364	9.889	7.209		8.3324
3.000	0.875	10.0	9.708	8.833	10.370	7.703	8.8330	8.8330
3.000	0.875	10.5	10.178	9.303	10.852	8.196		9.2745
3.000	0.875	11.0	10.648	9.773	11.332	8.687	9.6646	9.7730
3.000	0.875	11.5	11.119	10.244	11.813	9.177		10.2181
3.000	0.875	12.0	11.591	10.716	12.294	9.666	10.7160	10.7160
3.000	0.875	12.5	12.063	11.188	12.774	10.154		11.1642
3.000	0.875	13.0	12.536	11.661	13.254	10.641	11.5696	11.6610

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	13.5	13.009	12.134	13.734	11.128		12.1120
3.000	0.875	14.0	13.482	12.607	14.213	11.614	12.6070	12.6070
3.000	0.875	14.5	13.955	13.080	14.692	12.099		13.0595
3.000	0.875	15.0	14.429	13.554	15.171	12.584	13.4750	13.5540
3.000	0.875	15.5	14.903	14.028	15.650	13.068		14.0089
3.000	0.875	16.0	15.377	14.502	16.129	13.552	14.5020	14.5020
3.000	0.875	16.5	15.852	14.977	16.609	14.035		14.9590
3.000	0.875	17.0	16.327	15.452	17.088	14.519	15.3824	15.4520
3.000	0.875	17.5	16.801	15.926	17.566	15.001		15.9091
3.000	0.875	18.0	17.276	16.401	18.045	15.484	16.4040	16.4010
3.000	0.875	18.5	17.751	16.876	18.523	15.966		16.8600
3.000	0.875	19.0	18.227	17.352	19.003	16.448	17.2897	17.3520
3.000	0.875	19.5	18.702	17.827	19.481	16.930		17.8118
3.000	0.875	20.0	19.177	18.302	19.959	17.411	18.3020	18.3020
3.000	0.875	20.5	19.653	18.778	20.438	17.893		18.7636
3.000	0.875	21.0	20.129	19.254	20.917	18.374	19.1977	19.2540
3.000	0.875	21.5	20.604	19.729	21.394	18.855		19.7153
3.000	0.875	22.0	21.080	20.205	21.873	19.335	20.2050	20.2050
3.000	0.875	22.5	21.556	20.681	22.351	19.816		20.6679
3.000	0.875	23.0	22.032	21.157	22.829	20.297	21.1056	21.1570
3.000	0.875	23.5	22.508	21.633	23.308	20.777		21.6204
3.000	0.875	24.0	22.984	22.109	23.786	21.257	22.1090	22.1090
3.000	0.875	24.5	23.460	22.585	24.264	21.737		22.5729
3.000	0.875	25.0	23.936	23.061	24.742	22.217	23.0138	23.0610
3.000	0.875	25.5	24.412	23.537	25.219	22.697		23.5254
3.000	0.875	26.0	24.889	24.014	25.698	23.177	24.0140	24.0140
3.000	0.875	26.5	25.365	24.490	26.176	23.657		24.4789

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	27.0	25.841	24.966	26.654	24.137	24.9223	24.9660
3.000	0.875	27.5	26.318	25.443	27.132	24.616		25.4323
3.000	0.875	28.0	26.794	25.919	27.610	25.096	25.9190	25.9190
3.000	0.875	28.5	27.271	26.396	28.088	25.575		26.3856
3.000	0.875	29.0	27.747	26.872	28.566	26.055	26.8313	26.8720
3.000	0.875	29.5	28.224	27.349	29.044	26.534		27.3390
3.000	0.875	30.0	28.700	27.825	29.521	27.013	27.8250	27.8250
3.000	0.875	30.5	29.177	28.302	30.000	27.492		28.2923
3.000	0.875	31.0	29.654	28.779	30.478	27.971	28.7409	28.7790
3.000	0.875	31.5	30.130	29.255	30.955	28.450		29.2456
3.000	0.875	32.0	30.607	29.732	31.433	28.930	29.7320	29.7320
3.000	0.875	32.5	31.084	30.209	31.911	29.408		30.1999
3.000	0.875	33.0	31.560	30.685	32.389	29.887	30.6493	30.6850
3.000	0.875	33.5	32.037	31.162	32.867	30.366		31.1532
3.000	0.875	34.0	32.514	31.639	33.345	30.845	31.6390	31.6390
3.000	0.875	34.5	32.991	32.116	33.823	31.324		32.1075
3.000	0.875	35.0	33.467	32.592	34.300	31.803	32.5583	32.5920
3.000	0.875	35.5	33.944	33.069	34.778	32.281		33.0607
3.000	0.875	36.0	34.421	33.546	35.256	32.760	33.5460	33.5460
3.000	0.875	36.5	34.898	34.023	35.733	33.239		34.0149
3.000	0.875	37.0	35.375	34.500	36.211	33.717	34.4681	34.5000
3.000	0.875	37.5	35.852	34.977	36.689	34.196		34.9691
3.000	0.875	38.0	36.329	35.454	37.167	34.675	35.4540	35.4540
3.000	0.875	38.5	36.806	35.931	37.645	35.153		35.9233
3.000	0.875	39.0	37.283	36.408	38.123	35.632	36.3778	36.4080
3.000	0.875	39.5	37.760	36.885	38.600	36.110		36.8775
3.000	0.875	40.0	38.236	37.361	39.077	36.589	37.3610	37.3610

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	40.5	38.713	37.838	39.555	37.067		37.8307
3.000	0.875	41.0	39.190	38.315	40.033	37.545	38.2862	38.3150
3.000	0.875	41.5	39.667	38.792	40.510	38.024		38.7849
3.000	0.875	42.0	40.144	39.269	40.968	38.502	39.2690	39.2690
3.000	0.875	42.5	40.621	39.746	41.466	38.981		39.7391
3.000	0.875	43.0	41.099	40.224	41.944	39.459	40.1966	40.2240
3.000	0.875	43.5	41.576	40.701	42.422	39.937		40.6942
3.000	0.875	44.0	42.053	41.178	42.899	40.415	41.1780	41.1780
3.000	0.875	44.5	42.530	41.655	43.377	40.894		41.6484
3.000	0.875	45.0	43.007	42.132	43.855	41.372	42.1058	42.1320
3.000	0.875	45.5	43.484	42.609	44.332	41.850		42.6025
3.000	0.875	46.0	43.961	43.086	44.810	42.328	43.0860	43.0860
3.000	0.875	46.5	44.438	43.563	45.287	42.807		43.5567
3.000	0.875	47.0	44.915	44.040	45.765	43.285	44.0149	44.0400
3.000	0.875	47.5	45.392	44.517	46.242	43.763		44.5108
3.000	0.875	48.0	45.869	44.994	46.720	44.241	44.9940	44.9940
3.000	0.875	48.5	46.346	45.471	47.197	44.719		45.4649
3.000	0.875	49.0	46.824	45.949	47.676	45.197	45.9249	45.9490
3.000	0.875	49.5	47.301	46.426	48.153	45.676		46.4200
3.000	0.875	50.0	47.778	46.903	48.631	46.154	46.9030	46.9030
3.000	0.875	50.5	48.255	47.380	49.108	46.632		47.3742
3.000	0.875	51.0	48.732	47.857	49.586	47.110	47.8339	47.8570
3.000	0.875	51.5	49.209	48.334	50.063	47.588		48.3283
3.000	0.875	52.0	49.687	48.812	50.542	48.066	48.8120	48.8120
3.000	0.875	52.5	50.164	49.289	51.019	48.544		49.2834
3.000	0.875	53.0	50.641	49.766	51.497	49.022	49.7438	49.7660
3.000	0.875	53.5	51.118	50.243	51.974	49.500		50.2375

## MIL-STD-627A

TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	54.0	51.595	50.720	52.451	49.978	50.7200	50.7200
3.000	0.875	54.5	52.073	51.198	52.930	50.456		51.1926
3.000	0.875	55.0	52.550	51.675	53.407	50.934	51.6536	51.6750
3.000	0.875	55.5	53.027	52.152	53.885	51.412		52.1467
3.000	0.875	56.0	53.504	52.629	54.362	51.890	52.6290	52.6290
3.000	0.875	56.5	53.981	53.106	54.839	52.368		53.1008
3.000	0.875	57.0	54.459	53.584	55.318	52.846	53.5633	53.5840
3.000	0.875	57.5	54.936	54.061	55.795	53.324		54.0559
3.000	0.875	58.0	55.413	54.538	56.272	53.802	54.5380	54.5380
3.000	0.875	58.5	55.890	55.015	56.750	54.280		55.0100
3.000	0.875	59.0	56.367	55.492	57.227	54.758	55.4720	55.4920
3.000	0.875	59.5	56.845	55.970	57.705	55.235		55.9650
3.000	0.875	60.0	57.322	56.447	58.183	55.713	56.4470	56.4470
3.000	0.875	60.5	57.799	56.924	58.660	56.191		56.9191
3.000	0.875	61.0	58.276	57.401	59.137	56.669	57.3817	57.4040
3.000	0.875	61.5	58.754	57.879	59.616	57.147		57.8742
3.000	0.875	62.0	59.231	58.356	60.093	57.625	58.3560	58.3560
3.000	0.875	62.5	59.708	58.833	60.570	58.103		58.8283
3.000	0.875	63.0	60.186	59.311	61.049	58.581	59.2923	59.3110
3.000	0.875	63.5	60.663	59.788	61.526	59.059		59.7834
3.000	0.875	64.0	61.140	60.265	62.003	59.536	60.2650	60.2650
3.000	0.875	64.5	61.617	60.742	62.480	60.014		60.7374
3.000	0.875	65.0	62.095	61.220	62.959	60.492	61.2019	61.2200
3.000	0.875	65.5	62.572	61.697	63.436	60.970		61.6925
3.000	0.875	66.0	63.049	62.174	63.913	61.448	62.1740	62.1740
3.000	0.875	66.5	63.526	62.651	64.391	61.926		62.6466
3.000	0.875	67.0	64.004	63.129	64.869	62.403	63.1114	63.1290

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	67.5	64.481	63.606	65.346	62.881		63.6016
3.000	0.875	68.0	64.958	64.083	65.823	63.359	64.0830	64.0830
3.000	0.875	68.5	65.436	64.561	66.302	63.837		64.5567
3.000	0.875	69.0	65.913	65.038	66.779	64.315	65.0209	65.0380
3.000	0.875	69.5	66.390	65.515	67.256	64.792		65.5108
3.000	0.875	70.0	66.868	65.993	67.734	65.270	65.9930	65.9930
3.000	0.875	70.5	67.345	66.470	68.212	65.748		66.4658
3.000	0.875	71.0	67.822	66.947	68.689	66.226	66.9304	66.9470
3.000	0.875	71.5	68.299	67.424	69.166	66.704		67.4199
3.000	0.875	72.0	68.777	67.902	69.644	67.181	67.9020	67.9020
3.000	0.875	72.5	69.254	68.379	70.122	67.659		68.3749
3.000	0.875	73.0	69.731	68.856	70.599	68.137	68.8399	68.8560
3.000	0.875	73.5	70.209	69.334	71.077	68.615		69.3300
3.000	0.875	74.0	70.686	69.811	71.554	69.092	69.8110	69.8110
3.000	0.875	74.5	71.163	70.288	72.031	69.570		70.2840
3.000	0.875	75.0	71.641	70.766	72.510	70.048	70.7503	70.7660
3.000	0.875	75.5	72.118	71.243	72.987	70.526		71.2391
3.000	0.875	76.0	72.595	71.720	73.464	71.003	71.7200	71.7200
3.000	0.875	76.5	73.073	72.198	73.942	71.481		72.1941
3.000	0.875	77.0	73.550	72.675	74.419	71.959	72.6597	72.6750
3.000	0.875	77.5	74.027	73.152	74.897	72.437		73.1482
3.000	0.875	78.0	74.505	73.630	75.375	72.914	73.6300	73.6300
3.000	0.875	78.5	74.982	74.107	75.852	73.392		74.1032
3.000	0.875	79.0	75.459	74.584	76.329	73.870	74.5691	74.5840
3.000	0.875	79.5	75.937	75.062	76.807	74.347		75.0583
3.000	0.875	80.0	76.414	75.539	77.285	74.825	75.5390	75.5390
3.000	0.875	80.5	76.891	76.016	77.762	75.303		76.0123

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	81.0	77.369	76.494	78.240	75.781	76.4795	76.4940
3.000	0.875	81.5	77.846	76.971	78.717	76.258		76.9674
3.000	0.875	82.0	78.323	77.448	79.194	76.736	77.4480	77.4480
3.000	0.875	82.5	78.801	77.926	79.672	77.214		77.9224
3.000	0.875	83.0	79.278	78.403	80.150	77.691	78.3888	78.4030
3.000	0.875	83.5	79.755	78.880	80.627	78.169		78.8765
3.000	0.875	84.0	80.233	79.358	81.105	78.647	79.3580	79.3580
3.000	0.875	84.5	80.710	79.835	81.582	79.124		79.8315
3.000	0.875	85.0	81.188	80.313	82.060	79.602	80.2991	80.3130
3.000	0.875	85.5	81.665	80.790	82.537	80.080		80.7866
3.000	0.875	86.0	82.142	81.267	83.015	80.557	81.2670	81.2670
3.000	0.875	86.5	82.620	81.745	83.493	81.035		81.7416
3.000	0.875	87.0	83.097	82.222	83.970	81.513	82.2085	82.2220
3.000	0.875	87.5	83.574	82.699	84.447	81.990		82.6956
3.000	0.875	88.0	84.052	83.177	84.925	82.468	83.1770	83.1770
3.000	0.875	88.5	84.529	83.654	85.402	82.946		83.6507
3.000	0.875	89.0	85.006	84.131	85.880	83.423	84.1178	84.1310
3.000	0.875	89.5	85.484	84.609	86.358	83.901		84.6057
3.000	0.875	90.0	85.961	85.086	86.835	84.379	85.0860	85.0860
3.000	0.875	90.5	86.439	85.564	87.313	84.856		85.5607
3.000	0.875	91.0	86.916	86.041	87.790	85.334	86.0281	86.0410
3.000	0.875	91.5	87.393	86.518	88.267	85.812		86.5148
3.000	0.875	92.0	87.871	86.996	88.745	86.289	86.9960	86.9960
3.000	0.875	92.5	88.348	87.473	89.223	86.767		87.4698
3.000	0.875	93.0	88.825	87.950	89.700	87.245	87.9373	87.9500
3.000	0.875	93.5	89.303	88.428	90.178	87.722		88.4248
3.000	0.875	94.0	89.780	88.905	90.655	88.200	88.9050	88.9050

## MIL-STD-627A

TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
3.000	0.875	94.5	90.257	89.382	91.132	88.678		89.3789
3.000	0.875	95.0	90.735	89.860	91.610	89.155	89.8476	89.8600
3.000	0.875	95.5	91.212	90.337	92.087	89.633		90.3339
3.000	0.875	96.0	91.690	90.815	92.565	90.111	90.8150	90.8150
3.000	0.875	96.5	92.167	91.292	93.043	90.588		91.2889
3.000	0.875	97.0	92.644	91.769	93.520	91.066	91.7569	91.7690
3.000	0.875	97.5	93.122	92.247	93.998	91.543		92.2440
3.000	0.875	98.0	93.599	92.724	94.475	92.021	92.7240	92.7240
3.000	0.875	98.5	94.077	93.202	94.953	92.499		93.1990
3.000	0.875	99.0	94.554	93.679	95.430	92.976	93.6671	93.6790
3.000	0.875	99.5	95.031	94.156	95.907	93.454		94.1530
3.000	0.875	100.0	95.509	94.634	96.385	93.932	94.6340	94.6340
4.000	1.125	5.0	6.805	5.680	7.355	3.476	5.3469	5.6800
4.000	1.125	5.5	7.399	6.274	8.012	4.194		6.1987
4.000	1.125	6.0	8.000	6.875	8.664	4.898	6.8750	6.8750
4.000	1.125	6.5	8.607	7.482	9.314	5.591		7.4192
4.000	1.125	7.0	9.219	8.094	9.963	6.276	7.8629	8.0940
4.000	1.125	7.5	9.834	8.709	10.609	6.954		8.6551
4.000	1.125	8.0	10.453	9.328	11.255	7.627	9.3280	9.3280
4.000	1.125	8.5	11.073	9.948	11.899	8.295		9.9008
4.000	1.125	9.0	11.695	10.570	12.542	8.960	10.3923	10.5700
4.000	1.125	9.5	12.319	11.194	13.185	9.622		11.1519
4.000	1.125	10.0	12.944	11.819	13.827	10.281	11.8190	11.8190
4.000	1.125	10.5	13.571	12.446	14.470	10.938		12.4081
4.000	1.125	11.0	14.198	13.073	15.110	11.593	12.9285	13.0730
4.000	1.125	11.5	14.826	13.701	15.751	12.246		13.6664
4.000	1.125	12.0	15.455	14.330	16.392	12.898	14.3300	14.3300



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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	12.5	16.084	14.959	17.031	13.549		14.9273
4.000	1.125	13.0	16.714	15.589	17.671	14.199	15.4671	15.5890
4.000	1.125	13.5	17.345	16.220	18.311	14.847		16.1907
4.000	1.125	14.0	17.976	16.851	18.951	15.495	16.8510	16.8510
4.000	1.125	14.5	18.607	17.482	19.590	16.142		17.4547
4.000	1.125	15.0	19.239	18.114	20.229	16.789	18.0086	18.1140
4.000	1.125	15.5	19.871	18.746	20.868	17.434		18.7205
4.000	1.125	16.0	20.503	19.378	21.506	18.079	19.3780	19.3780
4.000	1.125	16.5	21.136	20.011	22.145	18.724		19.9871
4.000	1.125	17.0	21.769	20.644	22.784	19.368	20.5511	20.6440
4.000	1.125	17.5	22.402	21.277	23.422	20.012		21.2544
4.000	1.125	18.0	23.035	21.910	24.060	20.655	21.9100	21.9100
4.000	1.125	18.5	23.669	22.544	24.699	21.298		22.5227
4.000	1.125	19.0	24.302	23.177	25.336	21.941	23.0940	23.1770
4.000	1.125	19.5	24.936	23.811	25.975	22.583		23.7908
4.000	1.125	20.0	25.570	24.445	26.613	23.225	24.4450	24.4450
4.000	1.125	20.5	26.204	25.079	27.250	23.867		25.0598
4.000	1.125	21.0	26.838	25.713	27.888	24.508	25.6380	25.7130
4.000	1.125	21.5	27.472	26.347	28.526	25.150		26.3287
4.000	1.125	22.0	28.107	26.982	29.164	25.791	26.9820	26.9820
4.000	1.125	22.5	28.741	27.616	29.801	26.431		27.5985
4.000	1.125	23.0	29.376	28.251	30.439	27.072	28.1825	28.2510
4.000	1.125	23.5	30.010	28.885	31.076	27.713		28.8682
4.000	1.125	24.0	30.645	29.520	31.714	28.353	29.5200	29.5200
4.000	1.125	24.5	31.280	30.155	32.352	28.993		30.1389
4.000	1.125	25.0	31.915	30.790	32.989	29.633	30.7270	30.7900
4.000	1.125	25.5	32.550	31.425	33.627	30.273		31.4096

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	26.0	33.185	32.060	34.264	30.913	32.0600	32.0600
4.000	1.125	26.5	33.820	32.695	34.901	31.553		32.6801
4.000	1.125	27.0	34.455	33.330	35.539	32.192	33.2717	33.3300
4.000	1.125	27.5	35.090	33.965	36.176	32.832		33.9507
4.000	1.125	28.0	35.726	34.601	36.814	33.471	34.6010	34.6010
4.000	1.125	28.5	36.361	35.236	37.451	34.110		35.2222
4.000	1.125	29.0	36.996	35.871	38.088	34.749	35.8167	35.8710
4.000	1.125	29.5	37.632	36.507	38.725	35.388		36.4937
4.000	1.125	30.0	38.267	37.142	39.362	36.027	37.1420	37.1420
4.000	1.125	30.5	38.903	37.778	40.000	36.666		37.7651
4.000	1.125	31.0	39.538	38.413	40.637	37.305	38.3623	38.4130
4.000	1.125	31.5	40.174	39.049	41.274	37.944		39.0365
4.000	1.125	32.0	40.809	39.684	41.911	38.583	39.6840	39.6840
4.000	1.125	32.5	41.445	40.320	42.548	39.221		40.3079
4.000	1.125	33.0	42.080	40.955	43.185	39.860	40.9073	40.9550
4.000	1.125	33.5	42.716	41.591	43.822	40.498		41.5793
4.000	1.125	34.0	43.352	42.227	44.460	41.137	42.2270	42.2270
4.000	1.125	34.5	43.988	42.863	45.097	41.775		42.8516
4.000	1.125	35.0	44.623	43.498	45.733	42.414	43.4531	43.4980
4.000	1.125	35.5	45.259	44.134	46.370	43.052		44.1229
4.000	1.125	36.0	45.895	44.770	47.008	43.690	44.7700	44.7700
4.000	1.125	36.5	46.531	45.406	47.645	44.328		45.3952
4.000	1.125	37.0	47.167	46.042	48.282	44.967	45.9995	46.0420
4.000	1.125	37.5	47.802	46.677	48.918	45.605		46.6665
4.000	1.125	38.0	48.438	47.313	49.555	46.243	47.3130	47.3130
4.000	1.125	38.5	49.074	47.949	50.192	46.881		47.9388
4.000	1.125	39.0	49.710	48.585	50.829	47.519	48.5447	48.5850

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	39.5	50.346	49.221	51.466	48.157		49.2110
4.000	1.125	40.0	50.982	49.857	52.103	48.795	49.8570	49.8570
4.000	1.125	40.5	51.618	50.493	52.740	49.433		50.4833
4.000	1.125	41.0	52.254	51.129	53.377	50.071	51.0907	51.1290
4.000	1.125	41.5	52.890	51.765	54.014	50.708		51.7555
4.000	1.125	42.0	53.526	52.401	54.651	51.346	52.4010	52.4010
4.000	1.125	42.5	54.162	53.037	55.288	51.984		53.0278
4.000	1.125	43.0	54.798	53.673	55.925	52.622	53.6364	53.6730
4.000	1.125	43.5	55.434	54.309	56.562	53.260		54.3000
4.000	1.125	44.0	56.070	54.945	57.199	53.897	54.9450	54.9450
4.000	1.125	44.5	56.706	55.581	57.835	54.535		55.5722
4.000	1.125	45.0	57.342	56.217	58.472	55.173	56.1821	56.2170
4.000	1.125	45.5	57.978	56.853	59.109	55.810		56.8444
4.000	1.125	46.0	58.615	57.490	59.747	56.448	57.4900	57.4900
4.000	1.125	46.5	59.251	58.126	60.383	57.086		58.1175
4.000	1.125	47.0	59.887	58.762	61.020	57.723	58.7286	58.7620
4.000	1.125	47.5	60.523	59.398	61.657	58.361		59.3897
4.000	1.125	48.0	61.159	60.034	62.294	58.998	60.0340	60.0340
4.000	1.125	48.5	61.795	60.670	62.930	59.636		60.6619
4.000	1.125	49.0	62.432	61.307	63.568	60.273	61.2749	61.3070
4.000	1.125	49.5	63.068	61.943	64.205	60.911		61.9351
4.000	1.125	50.0	63.704	62.579	64.841	61.548	62.5790	62.5790
4.000	1.125	50.5	64.340	63.215	65.478	62.186		63.2072
4.000	1.125	51.0	64.976	63.851	66.114	62.823	63.8202	63.8510
4.000	1.125	51.5	65.613	64.488	66.752	63.460		64.4804
4.000	1.125	52.0	66.249	65.124	67.389	64.098	65.1240	65.1240
4.000	1.125	52.5	66.885	65.760	68.025	64.735		65.7525

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	53.0	67.521	66.396	68.662	65.373	66.3663	66.3960
4.000	1.125	53.5	68.157	67.032	69.298	66.010		67.0247
4.000	1.125	54.0	68.794	67.669	69.936	66.647	67.6690	67.6690
4.000	1.125	54.5	69.430	68.305	70.572	67.285		68.2978
4.000	1.125	55.0	70.066	68.941	71.209	67.922	68.9124	68.9410
4.000	1.125	55.5	70.703	69.578	71.846	68.559		69.5709
4.000	1.125	56.0	71.339	70.214	72.483	69.197	70.2140	70.2140
4.000	1.125	56.5	71.975	70.850	73.119	69.834		70.8430
4.000	1.125	57.0	72.611	71.486	73.756	70.471	71.4584	71.4860
4.000	1.125	57.5	73.248	72.123	74.393	71.108		72.1162
4.000	1.125	58.0	73.884	72.759	75.030	71.746	72.7590	72.7590
4.000	1.125	58.5	74.520	73.395	75.666	72.383		73.3883
4.000	1.125	59.0	75.157	74.032	76.304	73.020	74.0054	74.0320
4.000	1.125	59.5	75.793	74.668	76.940	73.657		74.6614
4.000	1.125	60.0	76.429	75.304	77.577	74.295	75.3040	75.3040
4.000	1.125	60.5	77.066	75.941	76.214	74.932		75.9345
4.000	1.125	61.0	77.702	76.577	76.851	75.569	76.5512	76.5770
4.000	1.125	61.5	78.338	77.213	79.487	76.206		77.2066
4.000	1.125	62.0	78.975	77.850	80.124	76.843	77.8500	77.8500
4.000	1.125	62.5	79.611	78.486	80.761	77.480		78.4797
4.000	1.125	63.0	80.247	79.122	81.307	78.118	79.0971	79.1220
4.000	1.125	63.5	80.884	79.759	82.035	78.755		79.7528
4.000	1.125	64.0	81.520	80.395	82.671	79.392	80.3950	80.3950
4.000	1.125	64.5	82.156	81.031	83.307	80.029		81.0249
4.000	1.125	65.0	82.793	81.668	83.945	80.666	81.6438	81.6680
4.000	1.125	65.5	83.429	82.304	84.581	81.303		82.2980
4.000	1.125	66.0	84.066	82.941	85.218	81.940	82.9410	82.9410

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	66.5	84.702	83.577	85.855	82.577		83.5711
4.000	1.125	67.0	85.338	84.213	86.491	83.215	84.1895	84.2130
4.000	1.125	67.5	85.975	84.850	87.128	83.852		84.8442
4.000	1.125	68.0	86.611	85.486	87.765	84.489	85.4860	85.4860
4.000	1.125	68.5	87.247	86.122	88.401	85.126		86.1163
4.000	1.125	69.0	87.884	86.759	89.038	85.763	86.7362	86.7590
4.000	1.125	69.5	88.520	87.395	89.675	85.400		87.3893
4.000	1.125	70.0	89.157	88.032	90.312	87.037	88.0320	88.0320
4.000	1.125	70.5	89.793	88.668	90.948	87.674		88.6624
4.000	1.125	71.0	90.430	89.305	91.586	88.311	89.2829	89.3050
4.000	1.125	71.5	91.066	89.941	92.222	88.948		89.9355
4.000	1.125	72.0	91.702	90.577	92.858	89.585	90.5770	90.5770
4.000	1.125	72.5	92.339	91.214	93.496	90.222		91.2086
4.000	1.125	73.0	92.975	91.850	94.132	90.859	91.8285	91.8500
4.000	1.125	73.5	93.612	92.487	94.769	91.496		92.4817
4.000	1.125	74.0	94.248	93.123	95.406	92.133	93.1230	93.1230
4.000	1.125	74.5	94.884	93.759	96.042	92.770		93.7537
4.000	1.125	75.0	95.521	94.396	96.679	93.407	94.3751	94.3960
4.000	1.125	75.5	96.157	95.032	97.315	94.044		95.0268
4.000	1.125	76.0	96.794	95.669	97.953	94.681	95.6690	95.6690
4.000	1.125	76.5	97.430	96.305	98.589	95.318		96.2999
4.000	1.125	77.0	98.067	96.942	99.226	95.955	96.9216	96.9420
4.000	1.125	77.5	98.703	97.578	99.862	96.592		97.5729
4.000	1.125	78.0	99.340	98.215	100.500	97.229	98.2150	98.2150
4.000	1.125	78.5	99.976	98.851	101.136	97.866		98.8460
4.000	1.125	79.0	100.612	99.487	101.772	98.503	99.4671	99.4870
4.000	1.125	79.5	101.249	100.124	102.409	99.140		100.1191

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	80.0	101.885	100.760	103.046	99.777	100.7600	100.7600
4.000	1.125	80.5	102.522	101.397	103.683	100.414		101.3921
4.000	1.125	81.0	103.158	102.033	104.319	101.051	102.0136	102.0330
4.000	1.125	81.5	103.795	102.670	104.956	101.688		102.6652
4.000	1.125	82.0	104.431	103.306	105.593	102.325	103.3060	103.3060
4.000	1.125	82.5	105.068	103.943	106.230	102.961		103.9382
4.000	1.125	83.0	105.704	104.579	106.866	103.598	104.5601	104.5790
4.000	1.125	83.5	106.341	105.216	107.503	104.235		105.2113
4.000	1.125	84.0	106.977	105.852	108.140	104.872	105.8520	105.8520
4.000	1.125	84.5	107.614	106.489	108.777	105.509		106.4844
4.000	1.125	85.0	108.250	107.125	109.413	106.146	107.1065	107.1250
4.000	1.125	85.5	108.886	107.761	110.049	106.783		107.7564
4.000	1.125	86.0	109.523	108.398	110.686	107.420	108.3980	108.3980
4.000	1.125	86.5	110.159	109.034	111.323	108.057		109.0295
4.000	1.125	87.0	110.796	109.671	111.960	108.694	109.6529	109.6710
4.000	1.125	87.5	111.432	110.307	112.596	109.331		110.3025
4.000	1.125	88.0	112.069	110.944	113.233	109.967	110.9440	110.9440
4.000	1.125	88.5	112.705	111.580	113.870	110.604		111.5756
4.000	1.125	89.0	113.342	112.217	114.507	111.241	112.1993	112.2170
4.000	1.125	89.5	113.978	112.853	115.143	111.878		112.8486
4.000	1.125	90.0	114.615	113.490	115.780	112.515	113.4900	113.4900
4.000	1.125	90.5	115.251	114.126	116.416	113.152		114.1217
4.000	1.125	91.0	115.888	114.763	117.053	113.789	114.7457	114.7630
4.000	1.125	91.5	116.524	115.399	117.690	114.426		115.3947
4.000	1.125	92.0	117.161	116.036	118.327	115.062	116.0360	116.0360
4.000	1.125	92.5	117.797	116.672	118.963	115.699		116.6678
4.000	1.125	93.0	118.434	117.309	119.600	116.336	117.2921	117.3090

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TABLE IX. Technical characteristics for sprocket wheels for roller chains standard roller series (ANSI B29.2, ANSI B29.4) - Continued.

P	D	NE	PD	BD	OD	MHD	CD-1	CD-2
4.000	1.125	93.5	119.070	117.945	120.236	116.973		117.9408
4.000	1.125	94.0	119.707	118.582	120.874	117.610	118.5820	118.5820
4.000	1.125	94.5	120.343	119.218	121.510	118.247		119.2138
4.000	1.125	95.0	120.980	119.855	122.147	118.884	119.6369	119.6550
4.000	1.125	95.5	121.616	120.491	122.783	119.521		120.4869
4.000	1.125	96.0	122.253	121.128	123.420	120.157	121.1280	121.1280
4.000	1.125	96.5	122.889	121.764	124.056	120.794		121.7599
4.000	1.125	97.0	123.526	122.401	124.694	121.430	122.3868	122.4010
4.000	1.125	97.5	124.162	123.037	125.330	122.068		123.0330
4.000	1.125	98.0	124.799	123.674	125.967	122.705	123.6740	123.6740
4.000	1.125	98.5	125.435	124.310	126.603	123.342		124.3060
4.000	1.125	99.0	126.072	124.947	127.240	123.978	124.9311	124.9470
4.000	1.125	99.5	126.708	125.583	127.876	124.615		125.5791
4.000	1.125	100.0	127.345	126.220	128.514	125.252	126.2280	126.2280

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#### 4. SPROCKET WHEELS FOR ROLLER CHAINS (ANSI B29.4 LARGE ROLLER SERIES) MIL-STD-423.

##### A. DIAMETERS

Sprockets for double-pitch chains of the large roller series have one set of teeth. See Figure 22.

P = Chain Pitch  
PD = Pitch Diameter  
D = Roller Diameter  
N = Number of Teeth

Bottom Diameter of Sprocket =  $PD - D$

Pitch Diameter of Sprocket =  $\frac{P}{\sin \frac{180^\circ}{N}}$

$$\frac{P}{\sin \frac{180^\circ}{N}}$$

Caliper Diameter for Even No. of Teeth = Bottom Diameter

Caliper Diameter for Odd No. of Teeth =  $PD \left( \cos \frac{90^\circ}{N} \right) - D$

Tolerances on bottom or caliper diameter of sprockets

Plus tolerance = 0.000

Minus tolerance =  $0.001 P \sqrt{N} + 0.003$

Aproximate Outside Diameter of Sprocket equals

$$PD + P \left( 0.6 - \tan \frac{90^\circ}{N} \right)$$

Maximum Hub Diameter (MHD) of Sprockets equals

$$P \left( \cot \frac{180^\circ}{N} - 0.5 \right) - .030$$

(but not to exceed Bottom Diameter - .030)

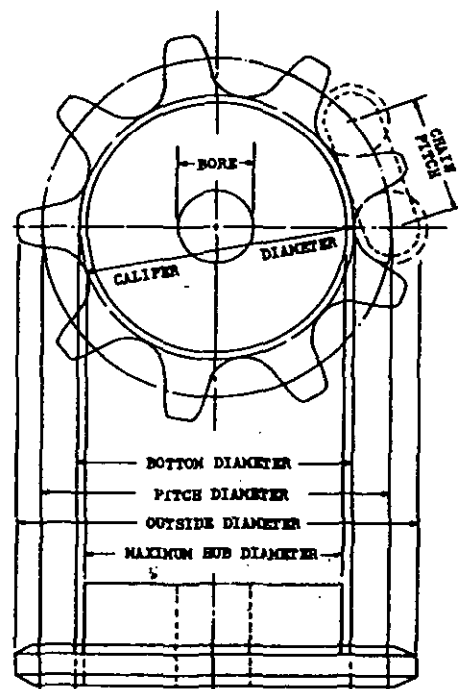


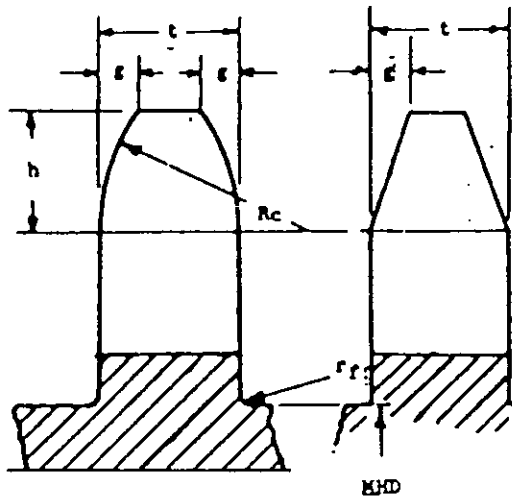
FIGURE 22. Diameters.



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## B. SPROCKET TOOTH SECTION PROFILE

The section profile shows the recommended chamfering of sprocket teeth.



W = Chain Width

MHD = Maximum Hub Diameter

$t = 0.93W - 0.006$  (Maximum)

Tolerance on t when machined =  
Plus zero, minus  $(0.01W - 0.006)$ .

$h = 0.25 P$  = Depth of chamfer

$g = 0.0625 P$  approximately (but  
not to exceed  $\frac{W}{3}$ )

$R_c$  min. =  $0.532 P$  (approximately  
tangent to side) Chamfer radius.

$r_f$  max. =  $0.02 P$  for maximum hub  
diameter (but not to exceed 0.040)  
= Fillet radius

\*\* FIGURE 23. Tooth profile.

\*\* Flange chamfer may be radial,  
straight, or anything in between.

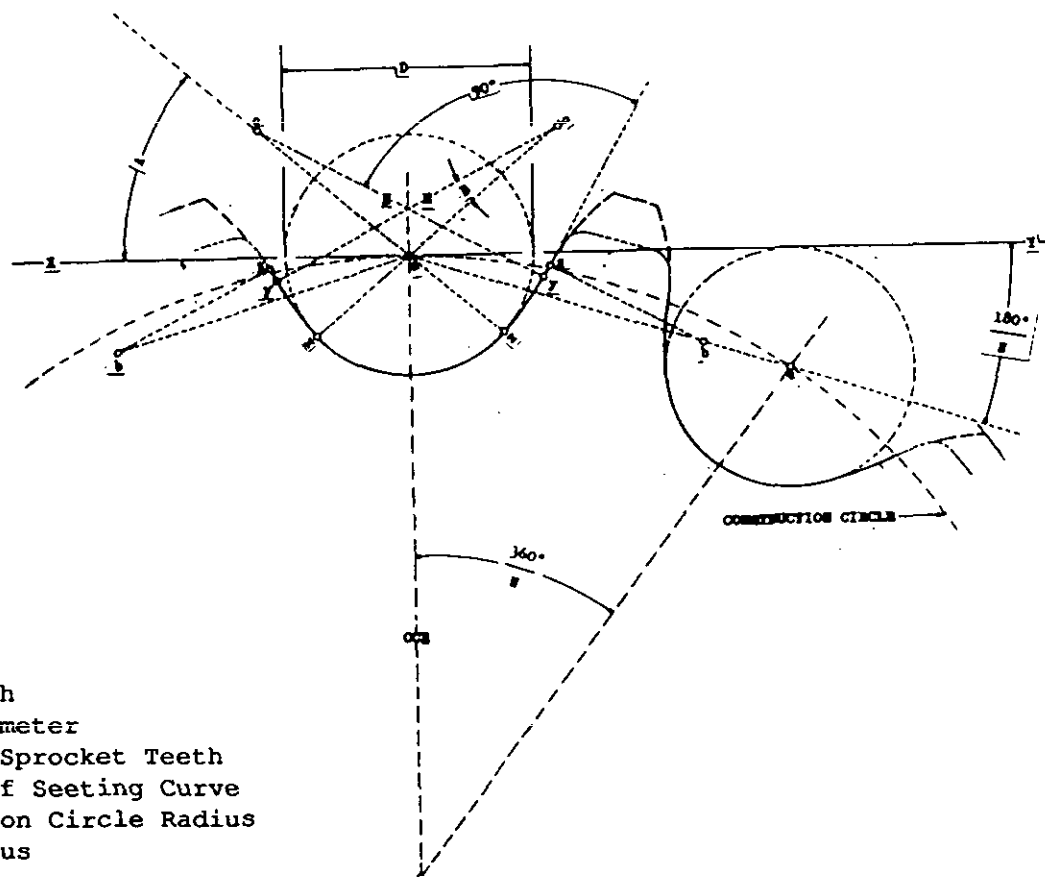
TABLE X. Sprocket tooth section profile (in inches).

ASA chain No.	Pitch (P)	Width of chain (W)	Maximum sprocket thickness (t)	*Minus tolerance on (t)	Depth of chamfer (h)	Width of chamfer (g)	Minimum radius ( $R_c$ )
C-2042	1.00	0.3125	0.284	0.009	0.25	0.0625	0.531
C-2052	1.25	0.375	0.343	0.010	0.3125	0.078	0.664
C-2062	1.50	0.50	0.459	0.011	0.375	0.0938	0.796
C-2082	2.00	0.625	0.575	0.012	0.50	0.125	1.062
C-2102	2.50	0.75	0.692	0.014	0.625	0.157	1.327
C-2122	3.00	1.00	0.924	0.016	0.75	0.188	1.593
C-2162	4.00	1.25	1.156	0.019	1.00	0.25	2.124

\* When machined

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## C. TOOTH FORM



## LEGEND:

P = Chain Pitch  
 D = Roller Diameter  
 N = Number of Sprocket Teeth  
 Ds = Diameter of Seeting Curve  
 CCR = Construction Circle Radius  
 P = Pitch Radius

Figure 9 and table I cover tooth space form for the base series chains, B29.1 Roller Chain Sprockets, where are also applicable to B29.4 chains of the large roller series. When cutting sprocket teeth, the same space cutter, or hob, for the base series roller chain should be used except for sprockets for the 4 inch pitch chain which requires tooth cutting of teeth suited to its respective roller diameter.

FIGURE 24. Tooth form.

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$$PR = \frac{\frac{P}{2}}{\sin \left( \frac{180^\circ}{N} \right)} \quad CCR = PR + \frac{(1.005D + 0.003) - D}{2} \quad \text{Angle A} = 35^\circ + \frac{60^\circ}{N}$$

$$\text{Angle B} = 18^\circ - \frac{56^\circ}{N}$$

Distance E from c to y =  $1.3025D + 0.0015$

Diameter of seating curve,  $D_s = 1.005D + \frac{\quad}{\quad}$

Tolerance on  $D_c$  is all plus and =  $0.003D + 0.005$ .

Distance from a to b =  $1.40D$

$$y \text{ to } s = D \left[ \frac{1.40 \sin (17^\circ - \frac{64^\circ}{N})}{N} - \frac{0.8 \sin (18^\circ - \frac{56^\circ}{N})}{N} \right]$$

$$\text{Radius R of seating curve} = \frac{D_s}{2} = 0.5025D + 0.0015$$

$$\text{Radius of topping curve, } F = D \left[ \frac{0.8 \cos (18^\circ - \frac{56^\circ}{N})}{N} + \frac{1.40 \cos (17^\circ - \frac{64^\circ}{N})}{N} \right] - 1.3025 - 0.0015$$

Line cy is parallel to line bs.

Point b is located on a line drawn from a to c.

Distance a to c may be assumed to equal pitch of chain.

Points a and c are the center of the seating curve radius.

Points a and c are located on the construction circle.

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	5.	1.701	1.076	1.976	.846	.9927
1.000	.625	6.	2.000	1.375	2.332	1.202	1.3750
1.000	.625	7.	2.305	1.680	2.677	1.547	1.6222
1.000	.625	8.	2.613	1.988	3.014	1.884	1.9880
1.000	.625	9.	2.924	2.299	3.348	2.217	2.2546
1.000	.625	10.	3.236	2.611	3.673	2.548	2.6110
1.000	.625	11.	3.549	2.924	4.005	2.876	2.8879
1.000	.625	12.	3.864	3.239	4.332	3.202	3.2390
1.000	.625	13.	4.179	3.554	4.658	3.527	3.5235
1.000	.625	14.	4.494	3.869	4.981	3.851	3.8690
1.000	.625	15.	4.810	4.185	5.305	4.175	4.1587
1.000	.625	16.	5.126	4.501	5.628	4.497	4.5010
1.000	.625	17.	5.442	4.817	5.949	4.820	4.7938
1.000	.625	18.	5.759	5.134	6.272	5.141	5.1340
1.000	.625	19.	6.076	5.451	6.593	5.463	5.4302
1.000	.625	20.	6.392	5.767	6.913	5.784	5.7670
1.000	.625	21.	6.710	6.085	7.235	6.105	6.0662
1.000	.625	22.	7.027	6.402	7.556	6.425	6.4020
1.000	.625	23.	7.344	6.719	7.876	6.746	6.7019
1.000	.625	24.	7.661	7.036	8.196	7.066	7.0360
1.000	.625	25.	7.979	7.354	8.516	7.386	7.3383
1.000	.625	26.	8.296	7.671	8.836	7.706	7.6710
1.000	.625	27.	8.614	7.989	9.156	8.026	7.9744
1.000	.625	28.	8.931	8.306	9.475	8.345	8.3060
1.000	.625	29.	9.249	8.624	9.795	8.665	8.6104
1.000	.625	30.	9.567	8.942	10.115	8.984	8.9420
1.000	.625	31.	9.885	9.260	10.434	9.304	9.2473
1.000	.625	32.	10.202	9.577	10.753	9.623	9.5770
1.000	.625	33.	10.520	9.895	11.072	9.942	9.8831
1.000	.625	34.	10.838	10.213	11.392	10.262	10.2130
1.000	.625	35.	11.156	10.531	11.711	10.581	10.5198
1.000	.625	36.	11.474	10.849	12.030	10.900	10.8490
1.000	.625	37.	11.792	11.167	12.350	11.219	11.1564

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
1.000	.625	38.	12.110	11.485	12.669	11.538	11.4850
1.000	.625	39.	12.428	11.803	12.988	11.857	11.7929
1.000	.625	40.	12.745	12.120	13.306	12.176	12.1200
1.000	.625	41.	13.063	12.438	13.625	12.495	12.4284
1.000	.625	42.	13.381	12.756	13.944	12.814	12.7560
1.000	.625	43.	13.700	13.075	14.264	13.133	13.0659
1.000	.625	44.	14.018	13.393	14.582	13.452	13.3930
1.000	.625	45.	14.336	13.711	14.901	13.771	13.7023
1.000	.625	46.	14.654	14.029	15.220	14.089	14.0290
1.000	.625	47.	14.972	14.347	15.539	14.408	14.3386
1.000	.625	48.	15.290	14.665	15.857	14.727	14.6650
1.000	.625	49.	15.608	14.983	16.176	15.046	14.9750
1.000	.625	50.	15.926	15.301	16.495	15.365	15.3010
1.000	.625	51.	16.244	15.619	16.813	15.683	15.6113
1.000	.625	52.	16.562	15.937	17.132	16.002	15.9370
1.000	.625	53.	16.880	16.255	17.450	16.321	16.2476
1.000	.625	54.	17.198	16.573	17.769	16.639	16.5730
1.000	.625	55.	17.517	16.892	18.089	16.958	16.8849
1.000	.625	56.	17.835	17.210	18.407	17.277	17.2100
1.000	.625	57.	18.153	17.528	18.726	17.595	17.5211
1.000	.625	58.	18.471	17.846	19.044	17.914	17.8460
1.000	.625	59.	18.789	18.164	19.362	18.233	18.1573
1.000	.625	60.	19.107	18.482	19.681	18.551	18.4820
1.250	.750	5.	2.127	1.377	2.471	1.065	1.2729
1.250	.750	6.	2.500	1.750	2.915	1.510	1.7500
1.250	.750	7.	2.881	2.131	3.346	1.941	2.0588
1.250	.750	8.	3.266	2.516	3.767	2.363	2.5160
1.250	.750	9.	3.655	2.905	4.185	2.779	2.8495
1.250	.750	10.	4.045	3.295	4.597	3.192	3.2950
1.250	.750	11.	4.437	3.687	5.007	3.602	3.6418
1.250	.750	12.	4.830	4.080	5.416	4.010	4.0800
1.250	.750	13.	5.223	4.473	5.821	4.416	4.4349
1.250	.750	14.	5.617	4.887	6.226	4.822	4.8670

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
1.250	.750	15.	6.012	5.262	6.631	5.226	5.2291
1.250	.750	16.	6.407	5.657	7.034	5.629	5.6570
1.250	.750	17.	6.803	6.053	7.487	6.032	6.0240
1.250	.750	18.	7.198	6.448	7.839	6.434	6.4480
1.250	.750	19.	7.594	6.844	8.241	6.836	6.8181
1.250	.750	20.	7.991	7.241	8.643	7.237	7.2410
1.250	.750	21.	8.387	7.637	9.043	7.638	7.6135
1.250	.750	22.	8.783	8.033	9.444	8.039	8.0330
1.250	.750	23.	9.180	8.430	9.845	8.439	8.4086
1.250	.750	24.	9.577	8.827	10.245	8.840	8.8270
1.250	.750	25.	9.973	9.223	10.644	9.240	9.2033
1.250	.750	26.	10.370	9.620	11.045	9.640	9.6200
1.250	.750	27.	10.767	10.017	11.444	10.039	9.9988
1.250	.750	28.	11.164	10.414	11.844	10.439	10.4140
1.250	.750	29.	11.561	10.811	12.243	10.839	10.7940
1.250	.750	30.	11.958	11.208	12.643	11.238	11.2080
1.250	.750	31.	12.356	11.606	13.043	11.637	11.5901
1.250	.750	32.	12.753	12.003	13.442	12.036	12.0030
1.250	.750	33.	13.150	12.400	13.841	12.436	12.3851
1.250	.750	34.	13.547	12.797	14.239	12.835	12.7970
1.250	.750	35.	13.945	13.195	14.639	13.234	13.1810
1.250	.750	36.	14.342	13.592	15.038	13.633	13.5920
1.250	.750	37.	14.740	13.990	15.437	14.031	13.9767
1.250	.750	38.	15.137	14.387	15.835	14.430	14.3870
1.250	.750	39.	15.534	14.784	16.234	14.829	14.7714
1.250	.750	40.	15.932	15.182	16.633	15.228	15.1820
1.250	.750	41.	16.329	15.579	17.031	15.626	15.5670
1.250	.750	42.	16.727	15.977	17.430	16.025	15.9770
1.250	.750	43.	17.124	16.374	17.828	16.424	16.3626
1.250	.750	44.	17.522	16.772	18.227	16.822	16.7720
1.250	.750	45.	17.919	17.169	18.625	17.221	17.1581
1.250	.750	46.	18.317	17.567	19.024	17.619	17.5670
1.250	.750	47.	18.715	17.965	19.423	18.018	17.9545

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
1.250	.750	48.	19.112	18.362	19.821	18.416	18.3620
1.250	.750	49.	19.510	18.760	20.220	18.815	18.7500
1.250	.750	50.	19.907	19.157	20.618	19.213	19.1570
1.250	.750	51.	20.305	19.555	21.017	19.612	19.5454
1.250	.750	52.	20.703	19.953	21.415	20.010	19.9530
1.250	.750	53.	21.100	20.350	21.813	20.408	20.3407
1.250	.750	54.	21.498	20.748	22.212	20.807	20.7480
1.250	.750	55.	21.896	21.146	22.610	21.205	21.1371
1.250	.750	56.	22.293	21.543	23.008	21.603	21.5430
1.250	.750	57.	22.691	21.941	23.407	22.002	21.9324
1.250	.750	58.	23.089	22.339	23.805	22.400	22.3390
1.250	.750	59.	23.486	22.736	24.203	22.798	22.7277
1.250	.750	60.	23.884	23.134	24.601	23.196	23.1340
1.500	.875	5.	2.552	1.677	2.965	1.285	1.5521
1.500	.875	6.	3.000	2.125	3.498	1.818	2.1250
1.500	.875	7.	3.457	2.582	4.015	2.335	2.4953
1.500	.875	8.	3.920	3.045	4.522	2.841	3.0450
1.500	.875	9.	4.386	3.511	5.022	3.341	3.4444
1.500	.875	10.	4.854	3.979	5.517	3.837	3.9790
1.500	.875	11.	5.324	4.449	6.008	4.329	4.3948
1.500	.875	12.	5.796	4.921	6.499	4.818	4.9210
1.500	.875	13.	6.268	5.393	6.986	5.306	5.3473
1.500	.875	14.	6.741	5.866	7.472	5.792	5.8660
1.500	.875	15.	7.215	6.340	7.957	6.277	6.3005
1.500	.875	16.	7.689	6.814	8.441	6.761	6.8140
1.500	.875	17.	8.163	7.288	8.924	7.244	7.2532
1.500	.875	18.	8.638	7.763	9.407	7.727	7.7630
1.500	.875	19.	9.113	8.238	9.889	8.209	8.2069
1.500	.875	20.	9.589	8.714	10.371	8.691	8.7140
1.500	.875	21.	10.064	9.189	10.852	9.172	9.1609
1.500	.875	22.	10.540	9.665	11.333	9.653	9.6650
1.500	.875	23.	11.016	10.141	11.813	10.133	10.1153
1.500	.875	24.	11.492	10.617	12.294	10.614	10.6170

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	25.	11.968	11.093	12.774	11.094	11.0694
1.500	.875	26.	12.444	11.569	13.253	11.574	11.5690
1.500	.875	27.	12.921	12.046	13.734	12.053	12.0241
1.500	.875	28.	13.397	12.522	14.213	12.533	12.5220
1.500	.875	29.	13.874	12.999	14.693	13.012	12.9787
1.500	.875	30.	14.350	13.475	15.171	13.492	13.4750
1.500	.875	31.	14.827	13.952	15.651	13.971	13.9330
1.500	.875	32.	15.303	14.428	16.129	14.450	14.4280
1.500	.875	33.	15.780	14.905	16.609	14.929	14.8871
1.500	.875	34.	16.257	15.382	17.088	15.408	15.3820
1.500	.875	35.	16.734	15.859	17.567	15.886	15.8421
1.500	.875	36.	17.211	16.336	18.046	16.365	16.3360
1.500	.875	37.	17.687	16.812	18.523	16.844	16.7961
1.500	.875	38.	18.164	17.289	19.002	17.322	17.2890
1.500	.875	39.	18.641	17.766	19.481	17.801	17.7509
1.500	.875	40.	19.118	18.243	19.959	18.279	18.2430
1.500	.875	41.	19.595	18.720	20.438	18.758	18.7056
1.500	.875	42.	20.072	19.197	20.916	19.236	19.1970
1.500	.875	43.	20.549	19.674	21.394	19.714	19.6603
1.500	.875	44.	21.026	20.151	21.872	20.193	20.1510
1.500	.875	45.	21.503	20.628	22.351	20.671	20.6149
1.500	.875	46.	21.980	21.105	22.829	21.149	21.1050
1.500	.875	47.	22.458	21.583	23.308	21.627	21.5705
1.500	.875	48.	22.935	22.060	23.786	22.106	22.0600
1.500	.875	49.	23.412	22.537	24.264	22.584	22.5250
1.500	.875	50.	23.889	23.014	24.742	23.062	23.0140
1.500	.875	51.	24.366	23.491	25.220	23.540	23.4794
1.500	.875	52.	24.843	23.968	25.698	24.018	23.9680
1.500	.875	53.	25.320	24.445	26.176	24.496	24.4339
1.500	.875	54.	25.798	24.923	26.655	24.974	24.9230
1.500	.875	55.	26.275	25.400	27.132	25.452	25.3893
1.500	.875	56.	26.752	25.877	27.610	25.930	25.8770
1.500	.875	57.	27.229	26.354	28.088	26.408	26.3437



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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	58.	27.707	26.832	28.567	26.886	26.8320
1.500	.875	59.	28.184	27.309	29.044	27.364	27.2990
1.500	.875	60.	28.661	27.786	29.522	27.842	27.7860
2.000	1.125	5.	3.403	2.278	3.953	1.723	2.1114
2.000	1.125	6.	4.000	2.875	4.664	2.434	2.8750
2.000	1.125	7.	4.610	3.485	5.354	3.123	3.3694
2.000	1.125	8.	5.226	4.101	6.028	3.798	4.1010
2.000	1.125	9.	5.848	4.723	6.695	4.465	4.6342
2.000	1.125	10.	6.472	5.347	7.355	5.125	5.3470
2.000	1.125	11.	7.099	5.974	8.012	5.781	5.9017
2.000	1.125	12.	7.727	6.602	8.664	6.434	6.6020
2.000	1.125	13.	8.357	7.232	9.314	7.084	7.1711
2.000	1.125	14.	8.988	7.863	9.963	7.733	7.8630
2.000	1.125	15.	9.619	8.494	10.609	8.379	8.4413
2.000	1.125	16.	10.252	9.127	11.255	9.025	9.1270
2.000	1.125	17.	10.884	9.759	11.899	9.669	9.7126
2.000	1.125	18.	11.518	10.393	12.543	10.313	10.3930
2.000	1.125	19.	12.151	11.026	13.185	10.955	10.9845
2.000	1.125	20.	12.785	11.660	13.828	11.598	11.6600
2.000	1.125	21.	13.419	12.294	14.469	12.239	12.2565
2.000	1.125	22.	14.053	12.928	15.110	12.880	12.9280
2.000	1.125	23.	14.688	13.563	15.751	13.521	13.5288
2.000	1.125	24.	15.323	14.198	16.392	14.162	14.1980
2.000	1.125	25.	15.957	14.832	17.031	14.802	14.8005
2.000	1.125	26.	16.592	15.467	17.671	15.441	15.4670
2.000	1.125	27.	17.228	16.103	18.312	16.081	16.0739
2.000	1.125	28.	17.863	16.738	18.951	16.720	16.7380
2.000	1.125	29.	18.498	17.373	19.590	17.360	17.3459
2.000	1.125	30.	19.134	18.009	20.229	17.999	18.0090
2.000	1.125	31.	19.769	18.644	20.868	18.638	18.6186
2.000	1.125	32.	20.405	19.280	21.507	19.276	19.2800
2.000	1.125	33.	21.040	19.915	22.145	19.915	19.8912
2.000	1.125	34.	21.676	20.551	22.784	20.553	20.5510

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	35.	22.312	21.187	23.422	21.192	21.1645
2.000	1.125	36.	22.947	21.822	24.060	21.830	21.8220
2.000	1.125	37.	23.583	22.458	24.698	22.468	22.4368
2.000	1.125	38.	24.219	23.094	25.336	23.106	23.0940
2.000	1.125	39.	24.855	23.730	25.975	23.744	23.7098
2.000	1.125	40.	25.491	24.366	26.613	24.382	24.3660
2.000	1.125	41.	26.127	25.002	27.250	25.020	24.9828
2.000	1.125	42.	26.763	25.638	27.888	25.658	25.6380
2.000	1.125	43.	27.399	26.274	28.526	26.296	26.2557
2.000	1.125	44.	28.035	26.910	29.164	26.934	26.9100
2.000	1.125	45.	28.671	27.546	29.801	27.571	27.5285
2.000	1.125	46.	29.307	28.182	30.439	28.209	28.1820
2.000	1.125	47.	29.943	28.818	31.076	28.847	28.8013
2.000	1.125	48.	30.580	29.455	31.715	29.484	29.4550
2.000	1.125	49.	31.216	30.091	32.352	30.122	30.0750
2.000	1.125	50.	31.852	30.727	32.989	30.759	30.7270
2.000	1.125	51.	32.488	31.363	33.626	31.397	31.3476
2.000	1.125	52.	33.124	31.999	34.264	32.034	31.9990
2.000	1.125	53.	33.761	32.636	34.902	32.671	32.6212
2.000	1.125	54.	34.397	33.272	35.539	33.309	33.2720
2.000	1.125	55.	35.033	33.908	36.176	33.946	33.8937
2.000	1.125	56.	35.669	34.544	36.813	34.583	34.5440
2.000	1.125	57.	36.306	35.181	37.451	35.221	35.1672
2.000	1.125	58.	36.942	35.817	38.088	35.858	35.8170
2.000	1.125	59.	37.578	36.453	38.725	36.495	36.4397
2.000	1.125	60.	38.215	37.090	39.363	37.132	37.0900
2.500	1.563	5.	4.253	2.690	4.941	2.161	2.4818
2.500	1.563	6.	5.000	3.437	5.830	3.050	3.4370
2.500	1.563	7.	5.762	4.199	6.692	3.911	4.0545
2.500	1.563	8.	6.533	4.970	7.536	4.756	4.9700
2.500	1.563	9.	7.310	5.747	8.369	5.589	5.6359
2.500	1.563	10.	8.090	6.527	9.194	6.414	6.5270
2.500	1.563	11.	8.874	7.311	10.015	7.234	7.2207

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.563	12.	9.659	8.096	10.830	8.050	8.0960
2.500	1.563	13.	10.446	8.883	11.643	8.863	8.8068
2.500	1.563	14.	11.235	9.672	12.454	9.673	9.6720
2.500	1.563	15.	12.024	10.461	13.261	10.482	10.3951
2.500	1.563	16.	12.815	11.252	14.069	11.288	11.2520
2.500	1.563	17.	13.605	12.042	14.874	12.094	11.9840
2.500	1.563	18.	14.397	12.834	15.679	12.898	12.8340
2.500	1.563	19.	15.189	13.626	16.482	13.702	13.5741
2.500	1.563	20.	15.981	14.418	17.284	14.504	14.4180
2.500	1.563	21.	16.774	15.211	18.087	15.306	15.1641
2.500	1.563	22.	17.567	16.004	18.888	16.108	16.0040
2.500	1.563	23.	18.360	16.797	19.689	16.909	16.7542
2.500	1.563	24.	19.153	17.590	20.489	17.709	17.5900
2.500	1.563	25.	19.947	18.384	21.290	18.510	18.3446
2.500	1.563	26.	20.741	19.178	22.090	19.309	19.1780
2.500	1.563	27.	21.534	19.971	22.889	20.109	19.9346
2.500	1.563	28.	22.329	20.766	23.689	20.908	20.7660
2.500	1.563	29.	23.123	21.560	24.488	21.707	21.5261
2.500	1.563	30.	23.917	22.354	25.286	22.506	22.3540
2.500	1.563	31.	24.711	23.148	26.084	23.305	23.1163
2.500	1.563	32.	25.506	23.943	26.883	24.103	23.9430
2.500	1.563	33.	26.300	24.737	27.681	24.901	24.7072
2.500	1.563	34.	27.095	25.532	28.480	25.699	25.5320
2.500	1.563	35.	27.890	26.327	29.278	26.497	26.2989
2.500	1.563	36.	28.684	27.121	30.075	27.295	27.1210
2.500	1.563	37.	29.479	27.916	30.873	28.093	27.8894
2.500	1.563	38.	30.274	28.711	31.671	28.891	28.7110
2.500	1.563	39.	31.069	29.506	32.469	29.688	29.4808
2.500	1.563	40.	31.864	30.301	33.266	30.486	30.3010
2.500	1.563	41.	32.659	31.096	34.063	31.283	31.0720
2.500	1.563	42.	33.454	31.891	34.861	32.080	31.8910
2.500	1.563	43.	34.249	32.686	35.658	32.877	32.6632
2.500	1.563	44.	35.044	33.481	36.455	33.675	33.4810

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.563	45.	35.839	34.276	37.252	34.472	34.2542
2.500	1.563	46.	36.634	35.071	38.049	35.269	35.0710
2.500	1.563	47.	37.429	35.866	38.846	36.066	35.8451
2.500	1.563	48.	38.224	36.661	39.642	36.863	36.6610
2.500	1.563	49.	39.020	37.457	40.440	37.660	37.4370
2.500	1.563	50.	39.815	38.252	41.237	38.456	38.2520
2.500	1.563	51.	40.610	39.047	42.033	39.253	39.0277
2.500	1.563	52.	41.405	39.842	42.830	40.050	39.8420
2.500	1.563	53.	42.201	40.638	43.627	40.847	40.6195
2.500	1.563	54.	42.996	41.433	44.424	41.643	41.4330
2.500	1.563	55.	43.791	42.228	45.220	42.440	42.2101
2.500	1.563	56.	44.587	43.024	46.017	43.237	43.0240
2.500	1.563	57.	45.382	43.819	46.813	44.033	43.8018
2.500	1.563	58.	46.178	44.615	47.611	44.830	44.6150
2.500	1.563	59.	46.973	45.410	48.407	45.626	45.3934
2.500	1.563	60.	47.768	46.205	49.203	46.423	46.2050
3.000	1.750	5.	5.104	3.354	5.929	2.599	3.1042
3.000	1.750	6.	6.000	4.250	6.996	3.666	4.2500
3.000	1.750	7.	6.914	5.164	8.029	4.700	4.9907
3.000	1.750	8.	7.839	6.089	9.042	5.713	6.0890
3.000	1.750	9.	8.771	7.021	10.042	6.712	6.8877
3.000	1.750	10.	9.708	7.958	11.033	7.703	7.9580
3.000	1.750	11.	10.648	8.898	12.017	8.687	8.7896
3.000	1.750	12.	11.591	9.841	12.996	9.666	9.8410
3.000	1.750	13.	12.536	10.786	13.972	10.641	10.6946
3.000	1.750	14.	13.482	11.732	14.944	11.614	11.7320
3.000	1.750	15.	14.429	12.679	15.914	12.584	12.6000
3.000	1.750	16.	15.377	13.627	16.882	13.552	13.6270
3.000	1.750	17.	16.327	14.577	17.849	14.519	14.5074
3.000	1.750	18.	17.276	15.526	18.814	15.484	15.5260
3.000	1.750	19.	18.227	16.477	19.779	16.448	16.4147
3.000	1.750	20.	19.177	17.427	20.741	17.411	17.4270
3.000	1.750	21.	20.129	18.379	21.704	18.374	18.3227

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
3.000	1.750	22.	21.080	19.330	22.666	19.335	19.3300
3.000	1.750	23.	22.032	20.282	23.627	20.297	20.2306
3.000	1.750	24.	22.984	21.234	24.588	21.257	21.2340
3.000	1.750	25.	23.936	22.186	25.547	22.217	22.1388
3.000	1.750	26.	24.889	23.139	26.508	23.177	23.1390
3.000	1.750	27.	25.841	24.091	27.466	24.137	24.0473
3.000	1.750	28.	26.794	25.044	28.426	25.096	25.0440
3.000	1.750	29.	27.747	25.997	29.384	26.055	25.9563
3.000	1.750	30.	28.700	26.950	30.343	27.013	26.9500
3.000	1.750	31.	29.654	27.904	31.302	27.971	27.8659
3.000	1.750	32.	30.607	28.857	32.260	28.930	28.8570
3.000	1.750	33.	31.560	29.810	33.217	29.887	29.7743
3.000	1.750	34.	32.514	30.764	34.175	30.845	30.7640
3.000	1.750	35.	33.467	31.717	35.132	31.803	31.6833
3.000	1.750	36.	34.421	32.671	36.090	32.760	32.6710
3.000	1.750	37.	35.375	33.625	37.048	33.717	33.5931
3.000	1.750	38.	36.329	34.579	38.005	34.675	34.5790
3.000	1.750	39.	37.283	35.533	38.962	35.632	35.5028
3.000	1.750	40.	38.236	36.486	39.918	36.589	36.4860
3.000	1.750	41.	39.190	37.440	40.875	37.545	37.4112
3.000	1.750	42.	40.144	38.394	41.832	38.502	38.3940
3.000	1.750	43.	41.099	39.349	42.790	39.459	39.3216
3.000	1.750	44.	42.053	40.303	43.746	40.415	40.3030
3.000	1.750	45.	43.007	41.257	44.702	41.372	41.2308
3.000	1.750	46.	43.961	42.211	45.659	42.328	42.2110
3.000	1.750	47.	44.915	43.165	46.615	43.285	43.1399
3.000	1.750	48.	45.869	44.119	47.571	44.241	44.1190
3.000	1.750	49.	46.824	45.074	48.528	45.197	45.0499
3.000	1.750	50.	47.778	46.028	49.484	46.154	46.0280
3.000	1.750	51.	48.732	46.982	50.440	47.110	46.9589
3.000	1.750	52.	49.687	47.937	51.396	48.066	47.9370
3.000	1.750	53.	50.641	48.891	52.352	49.022	48.8688
3.000	1.750	54.	51.595	49.845	53.308	49.978	49.8450

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TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
3.000	1.750	55.	52.550	50.800	54.265	50.934	50.7786
3.000	1.750	56.	53.504	51.754	55.220	51.890	51.7540
3.000	1.750	57.	54.459	52.709	56.177	52.846	52.6883
3.000	1.750	58.	55.413	53.663	57.132	53.802	53.6630
3.000	1.750	59.	56.367	54.617	58.087	54.758	54.5970
3.000	1.750	60.	57.322	55.572	59.044	55.713	55.5720
4.000	2.250	5.	6.805	4.555	7.905	3.476	4.2219
4.000	2.250	6.	8.000	5.750	9.328	4.898	5.7500
4.000	2.250	7.	9.219	6.969	10.706	6.276	6.7379
4.000	2.250	8.	10.453	8.203	12.057	7.627	8.2030
4.000	2.250	9.	11.695	9.445	13.390	8.960	9.2673
4.000	2.250	10.	12.944	10.694	14.711	10.281	10.6940
4.000	2.250	11.	14.198	11.948	16.023	11.593	11.8035
4.000	2.250	12.	15.455	13.205	17.329	12.898	13.2050
4.000	2.250	13.	16.714	14.464	18.628	14.199	14.3421
4.000	2.250	14.	17.976	15.726	19.926	15.495	15.7260
4.000	2.250	15.	19.239	16.989	21.219	16.789	16.8836
4.000	2.250	16.	20.503	18.253	22.509	18.079	18.2530
4.000	2.250	17.	21.769	19.519	23.799	19.368	19.4261
4.000	2.250	18.	23.035	20.785	25.085	20.655	20.7850
4.000	2.250	19.	24.302	22.052	26.371	21.941	21.9690
4.000	2.250	20.	25.570	23.320	27.655	23.225	23.3200
4.000	2.250	21.	26.838	24.588	28.938	24.508	24.5130
4.000	2.250	22.	28.107	25.857	30.221	25.791	25.8570
4.000	2.250	23.	29.376	27.126	31.502	27.072	27.0575
4.000	2.250	24.	30.645	28.395	32.783	28.353	28.3950
4.000	2.250	25.	31.915	29.665	34.063	29.633	29.6020
4.000	2.250	26.	33.185	30.935	35.343	30.913	30.9350
4.000	2.250	27.	34.455	32.205	36.622	32.192	32.1467
4.000	2.250	28.	35.726	33.476	37.902	33.471	33.4760
4.000	2.250	29.	36.996	34.746	39.179	34.749	34.6917
4.000	2.250	30.	38.267	36.017	40.457	36.027	36.0170
4.000	2.250	31.	39.538	37.288	41.735	37.305	37.2373

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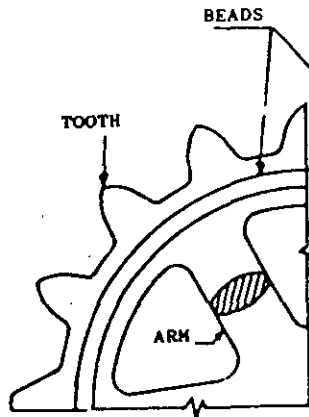
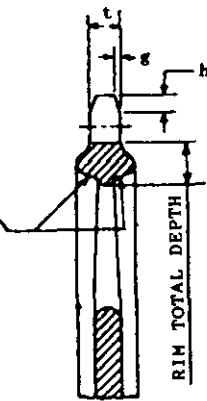
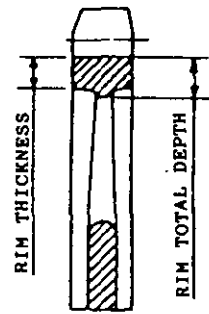
TABLE XI. Sprocket wheels for roller chains (ANSI B29.4 large roller series) ANSI B29.2.

P	D	N	PD	BD	OD	MHD	CD
4.000	2.250	32.	40.809	38.559	43.013	38.583	38.5590
4.000	2.250	33.	42.080	39.830	44.290	39.860	39.7823
4.000	2.250	34.	43.352	41.102	45.567	41.137	41.1020
4.000	2.250	35.	44.623	42.373	46.843	42.414	42.3281
4.000	2.250	36.	45.895	43.645	48.121	43.690	43.6450
4.000	2.250	37.	47.167	44.917	49.397	44.967	44.8745
4.000	2.250	38.	48.438	46.188	50.673	46.243	46.1880
4.000	2.250	39.	49.710	47.460	51.949	47.519	47.4197
4.000	2.250	40.	50.982	48.732	53.225	48.795	48.7320
4.000	2.250	41.	52.254	50.004	54.501	50.071	49.9657
4.000	2.250	42.	53.526	51.276	55.776	51.346	51.2760
4.000	2.250	43.	54.798	52.548	57.052	52.622	52.5114
4.000	2.250	44.	56.070	53.820	58.327	53.897	53.8200
4.000	2.250	45.	57.342	55.092	59.602	55.173	55.0571
4.000	2.250	46.	58.615	56.365	60.879	56.448	56.3650
4.000	2.250	47.	59.887	57.637	62.153	57.723	57.6036
4.000	2.250	48.	61.159	58.909	63.428	58.998	58.9090
4.000	2.250	49.	62.432	60.182	64.704	60.273	60.1499
4.000	2.250	50.	63.704	61.454	65.978	61.548	61.4540
4.000	2.250	51.	64.976	62.726	67.253	62.823	62.6952
4.000	2.250	52.	66.249	63.999	68.528	64.098	63.9990
4.000	2.250	53.	67.521	65.271	69.803	65.373	65.2413
4.000	2.250	54.	68.794	66.544	71.078	66.647	66.5440
4.000	2.250	55.	70.066	67.816	72.352	67.922	67.7874
4.000	2.250	56.	71.339	69.089	73.627	69.197	69.0890
4.000	2.250	57.	72.611	70.361	74.901	70.471	70.3334
4.000	2.250	58.	73.884	71.634	76.176	71.746	71.6340
4.000	2.250	59.	75.157	72.907	77.451	73.020	72.8804
4.000	2.250	60.	76.429	74.179	78.725	74.295	74.1790

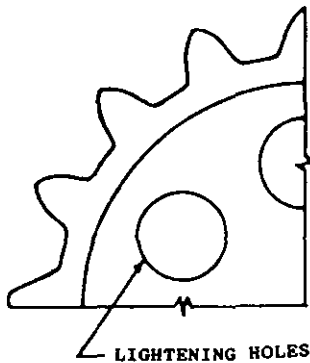
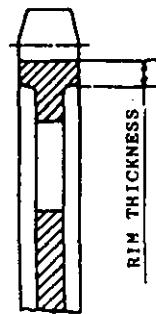
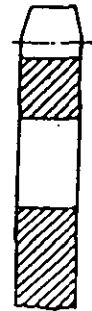
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## 5. SPROCKET WHEELS FOR ROLLER CHAINS (ASA B29.10) MIL-STD-424

## A. TYPES AND CROSS SECTIONS

Figure 25. Profile.Figure 26. Web center.Figure 27. Plate center.

## ARM TYPES

Figure 28. Profile.Figure 29. Web center.Figure 30. Plate center.

## SOLID CENTER TYPES

R = Roller Diameter

W = Inside Width of Chain Between Sidebars

g = approximately .2 t      h = approximately .5 R      t (Max.) = .9 W

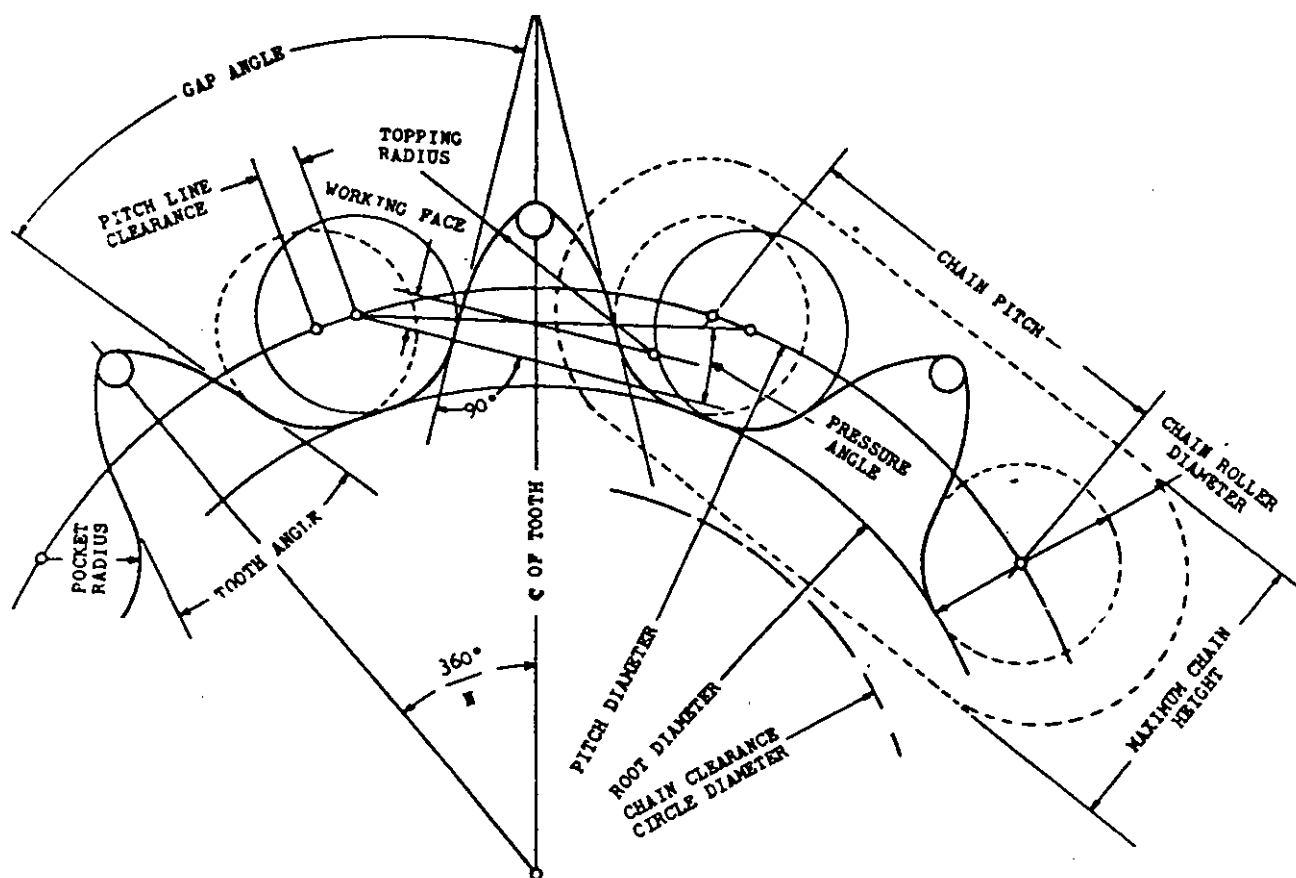
t (Max.) + allowable face run-out = .95 W

Maximum allowable face run-out = 0.0625 inch per 12 inches of Pitch Diameter



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## B. TOOTH FORM AND MAXIMUM HUB DIAMETER

FIGURE 31. Tooth form.

## LEGEND:

P = Chain Pitch  
 C = Clearance Circle Factor  
 U = Maximum Chain Height  
 M = Pitch Diameter Factor  
 N = Number of Teeth  
 R = Chain Roller Diameter

## NOTE:

See Table 12 for Pressure Angle, Tooth Angle, C, M and N.

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The elements of a chain sprocket and the tooth form may be determined by the following:

$$\text{Pitch Diameter} = (P) (M) = \frac{P}{\sin \frac{180^\circ}{N}}$$

$$* \text{ Root Diameter (Maximum)} = (P) (M) - R$$

$$** \text{ Chain Clearance Circle} = (P) (C) - U$$

$$\text{Pitch Line Clearance} = 0.1 (P)$$

$$\text{Pitch Diameter Factor} = \csc \frac{180}{N}$$

$$\text{Clearance Circle Factor} = \cot \frac{180}{N} - .05$$

Gap Angle as shown

Pressure Angle as shown

$$*** \text{ Working Face} = 0.01 (P) (N)$$

$$* \text{ Pocket Radius (Maximum)} = R/2$$

$$\text{Topping Radius} = 0.5 (P)$$

Tooth Angle as shown

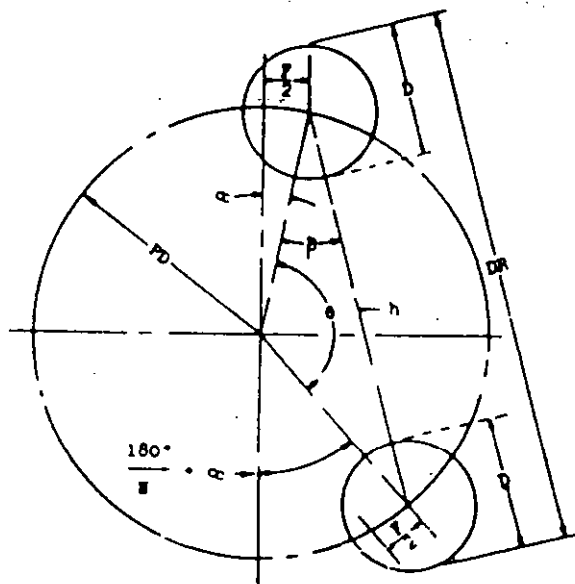
\* Root diameters and pocket radii must not exceed the maximums obtained from these formulae. Oversize dimensions cause improper chain and sprocket action and excessive chain loads.

\*\* No portion of hub, beads, lugs, or fillets shall extend beyond this circle in the sidebar zone.

\*\*\* Tooth working face length provides for approximately 6 percent chain pitch elongation for sprockets having less than 40 teeth. As the number of teeth increases, the possible chain pitch elongation is progressively reduced to less than 2 percent at 100 teeth.

## SPROCKET TOOTH FORM

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Figure 32. Showing caliper diameter.

## LEGEND:

P = Chain Pitch	CD = Caliper Diameter
D = Roller Diameter	OD = Outside Diameter
PD = Pitch Diameter	PR = Pitch Radius
PA = Pressure Angle	F = Pitch Line Clearance
WF = Working Face	DR = Diameter Over Rollers
TR = Topping Radius	BD = RD = Bottom or Root Diameter
N = Number of Teeth	

$$PD = \frac{P}{\sin \frac{180^\circ}{N}} \quad PR = \frac{PD}{2} \quad F = 0.10P \quad WF = 0.10 \ 0.01(P)(N)$$

$$TR = 0.50P \quad \frac{F}{PD} = \sin o_C$$

Formula for calculating the Caliper Diameter (CD) of sprockets with pitch line clearance. See Figure 32.

$$\theta = 180^\circ - \left( \frac{180^\circ}{N} + 2 o_C \right) \quad \sin \theta = \sin \left[ 180^\circ - \left( \frac{180^\circ}{N} + 2 o_C \right) \right]$$

$$\beta = \frac{180^\circ - \theta}{2} = \frac{\left( \frac{180^\circ}{N} + 2 o_C \right)}{2} \quad \sin \beta = \sin \frac{\left( \frac{180^\circ}{N} + 2 o_C \right)}{2}$$

$$h = \frac{PR \sin \theta}{\sin \beta}$$

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CR = Caliper Diameter =  $h + D$  for a sprocket having an odd number of teeth.

CD =  $(P)(M) - D$  = Caliper Diameter for a sprocket having an even number of teeth.

Formula for calculating the Outside Diameter (OD) of sprockets with Pitch Line Clearance. See Figure 33.

$$\frac{OD}{2} = \frac{PD}{2} \cdot \cos \left( \frac{180^\circ}{N} - Z \right) - \frac{\left( \frac{D}{2} + TR + WF \tan C \right)}{(1 + \tan^2 C)^{1/2}} +$$

$$\left\{ TR^2 + \left[ y_b - \frac{\tan C (D/2 + TR + WF)}{(1 + \tan^2 C)^{1/2}} \right]^2 \right\}^{1/2}$$

$$Z = \arcsin \left( 0.1 \sin \frac{180^\circ}{N} \right) \quad 0 - 90^\circ - (Z + PA) \quad y_b = \frac{PD}{2} \sin \left( \frac{180^\circ}{N} - Z \right)$$

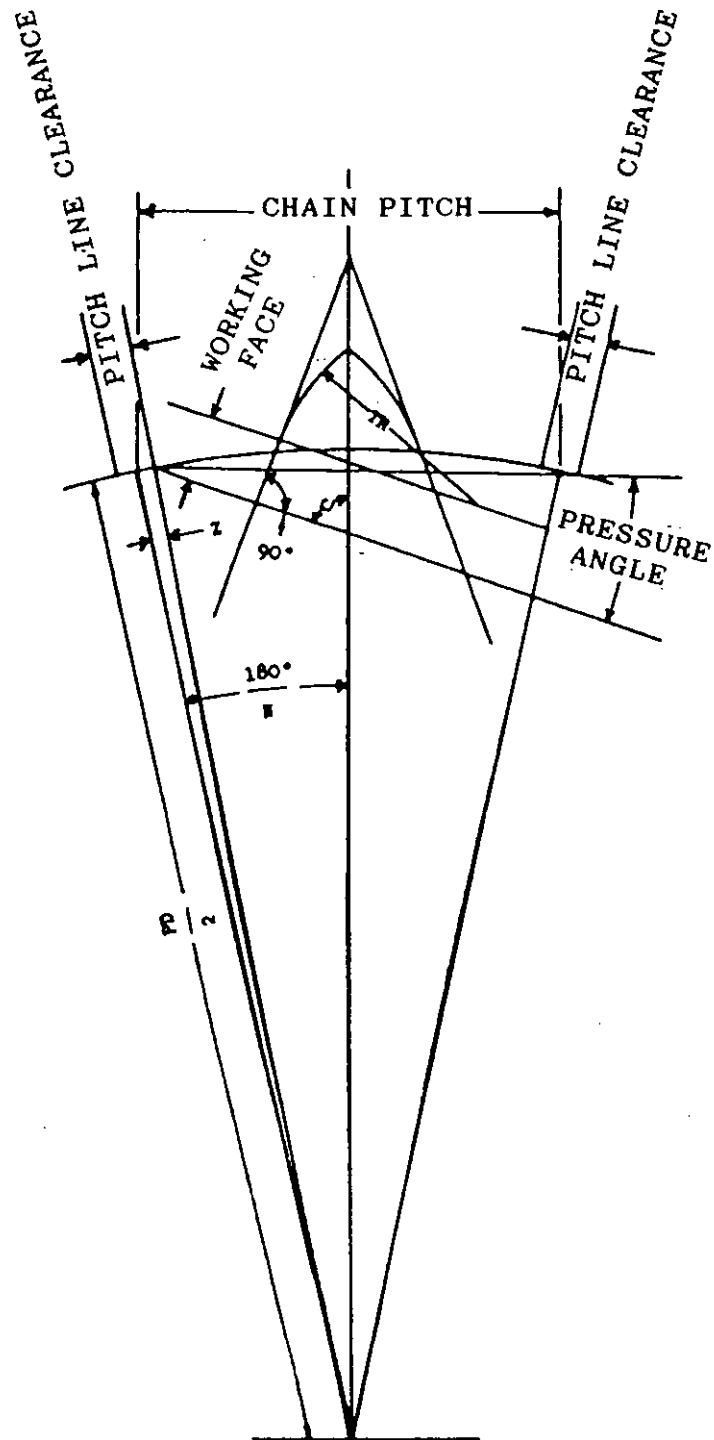


FIGURE 33. Showing technical elements for outside diameter.

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TABLE XII. Factors for determining tooth form.

N	M	PRESSURE ANGLE	TOOTH ANGLE	C	N	M	PRESSURE ANGLE	TOOTH ANGLE	C
7	2.304	10°	25°	2.02	54	17.198	27°	55°	17.11
8	2.613	11°	26°	2.36	55	17.516	27°	55°	17.43
9	2.923	12°	28°	2.69	56	17.834	27°	55°	17.75
10	3.236	13°	30°	3.02	57	18.152	27°	55°	18.07
11	3.549	14°	31°	3.35	58	18.471	27°	55°	18.39
12	3.863	15°	33°	3.68	59	18.789	27°	55°	18.71
13	4.178	16°	35°	4.00	60	19.107	27°	55°	19.03
14	4.494	17°	36°	4.33	61	19.425	27°	55°	19.35
15	4.809	18°	38°	4.65	62	19.743	27°	55°	19.66
16	5.125	19°	40°	4.97	63	20.061	27°	55°	19.98
17	5.442	20°	42°	5.29	64	20.380	27°	55°	20.30
18	5.758	20°	42°	5.62	65	20.698	27°	55°	20.62
19	6.075	21°	44°	5.94	66	21.016	27°	55°	20.94
20	6.392	21°	44°	6.26	67	21.334	27°	55°	21.26
21	6.709	22°	46°	6.58	68	21.652	27°	55°	21.58
22	7.026	22°	46°	6.89	69	21.971	27°	55°	21.89
23	7.343	22°	46°	7.22	70	22.289	27°	55°	22.21
24	7.661	23°	47°	7.54	71	22.607	28°	56°	22.53
25	7.978	23°	47°	7.86	72	22.925	28°	56°	22.85
26	8.296	23°	47°	8.18	73	23.243	28°	56°	23.17
27	8.613	23°	47°	8.50	74	23.562	28°	56°	23.49
28	8.931	24°	49°	8.82	75	23.880	28°	56°	23.80
29	9.249	24°	49°	9.14	76	24.198	28°	56°	24.12
30	9.566	24°	49°	9.46	77	24.516	28°	56°	24.44
31	9.884	24°	49°	9.78	78	24.834	28°	56°	24.76
32	10.202	24°	49°	10.10	79	25.153	28°	56°	25.08
33	10.520	25°	51°	10.42	80	25.471	28°	56°	25.40
34	10.837	25°	51°	10.74	81	25.789	28°	56°	25.72
35	11.155	25°	51°	11.07	82	26.107	28°	56°	26.04
36	11.473	25°	51°	11.38	83	26.426	28°	56°	26.35
37	11.791	25°	51°	11.69	84	26.744	28°	56°	26.67
38	12.109	25°	51°	12.06	85	27.062	28°	56°	26.99
39	12.427	25°	51°	12.33	86	27.380	28°	56°	27.31

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TABLE XII. Factors for determining tooth form, continued.

N	M	PRESSURE ANGLE	TOOTH ANGLE	C	N	M	PRESSURE ANGLE	TOOTH ANGLE	C
40	12.745	25°	51°	12.65	87	27.699	28°	56°	27.63
41	13.063	26°	53°	12.97	88	28.017	28°	56°	27.95
42	13.381	26°	53°	13.29	89	28.335	28°	56°	28.26
43	13.699	26°	53°	13.61	90	28.653	28°	56°	28.58
44	14.017	26°	53°	13.93	91	28.971	28°	56°	28.90
45	14.335	26°	53°	14.25	92	29.290	28°	56°	29.22
46	14.653	26°	53°	14.56	93	29.608	28°	56°	29.54
47	14.971	26°	53°	14.88	94	29.926	28°	56°	29.86
48	15.289	26°	53°	15.20	95	30.244	28°	56°	30.17
49	15.607	26°	53°	15.48	96	30.563	28°	56°	30.49
50	15.926	26°	53°	15.84	97	30.881	29°	58°	30.81
51	16.244	26°	53°	16.16	98	31.199	29°	58°	31.13
52	16.562	26°	53°	16.48	99	31.518	29°	58°	31.46
53	16.880	27°	55°	16.80	100	31.836	29°	58°	31.78

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	7.	3.457	2.582	3.960	1.601	2.4588
1.500	.875	8.	3.920	3.045	4.478	2.108	3.0450
1.500	.875	9.	4.386	3.511	4.960	2.608	3.4158
1.500	.875	10.	4.854	3.979	5.440	3.103	3.9790
1.500	.875	11.	5.324	4.449	5.986	3.595	4.3714
1.500	.875	12.	5.796	4.921	6.376	4.085	4.9210
1.500	.875	13.	6.268	5.393	6.928	4.573	5.3274
1.500	.875	14.	6.741	5.866	7.390	5.059	5.8660
1.500	.875	15.	7.215	6.340	7.778	5.543	6.2832
1.500	.875	16.	7.689	6.814	8.246	6.028	6.8140
1.500	.875	17.	8.163	7.288	8.712	6.511	7.2380
1.500	.875	18.	8.638	7.763	9.288	6.994	7.7630
1.500	.875	19.	9.113	8.238	9.750	7.475	8.1933
1.500	.875	20.	9.589	8.714	10.248	7.957	8.7140
1.500	.875	21.	10.064	9.189	10.700	8.438	9.1485
1.500	.875	22.	10.540	9.665	11.198	8.920	9.6650
1.500	.875	23.	11.016	10.141	11.694	9.400	10.1041
1.500	.875	24.	11.492	10.617	12.150	9.880	10.6170
1.500	.875	25.	11.968	11.093	12.644	10.360	11.0590
1.500	.875	26.	12.444	11.569	13.054	10.840	11.5690
1.500	.875	27.	12.921	12.046	13.548	11.320	12.0145
1.500	.875	28.	13.397	12.522	14.000	11.800	12.5220
1.500	.875	29.	13.874	12.999	14.570	12.278	12.9697
1.500	.875	30.	14.350	13.475	15.062	12.758	13.4750
1.500	.875	31.	14.827	13.952	15.550	13.237	13.9246
1.500	.875	32.	15.303	14.428	16.038	13.717	14.4280
1.500	.875	33.	15.780	14.905	16.494	14.195	14.8793
1.500	.875	34.	16.257	15.382	16.980	14.674	15.3820
1.500	.875	35.	16.734	15.859	17.468	15.152	15.8347
1.500	.875	36.	17.211	16.336	17.954	15.632	16.3360
1.500	.875	37.	17.687	16.812	18.440	16.111	16.7891
1.500	.875	38.	18.164	17.289	18.924	16.589	17.2890
1.500	.875	39.	18.641	17.766	19.408	17.068	17.7442



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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
1.500	.875	40.	19.118	18.243	19.890	17.546	18.2430
1.500	.875	41.	19.595	18.720	20.326	18.025	18.6993
1.500	.875	42.	20.072	19.197	20.804	18.503	19.1970
1.500	.875	43.	20.549	19.674	21.286	18.980	19.6543
1.500	.875	44.	21.026	20.151	21.762	19.459	20.1510
1.500	.875	45.	21.503	20.628	22.236	19.937	20.6091
1.500	.875	46.	21.980	21.105	22.712	20.416	21.1050
1.500	.875	47.	22.458	21.583	23.184	20.894	21.5649
1.500	.875	48.	22.935	22.060	23.654	21.373	22.0600
1.500	.875	49.	23.412	22.537	24.122	21.850	22.5197
1.500	.875	50.	23.889	23.014	24.580	22.328	23.0140
1.500	.875	51.	24.366	23.491	25.040	22.807	23.4744
1.500	.875	52.	24.843	23.968	25.494	23.284	23.9680
1.500	.875	53.	25.320	24.445	25.826	23.762	24.4290
1.500	.875	54.	25.798	24.923	26.128	24.241	24.9230
1.500	.875	55.	26.275	25.400	26.632	24.719	25.3846
1.500	.875	56.	26.752	25.877	27.138	25.196	25.8770
1.500	.875	57.	27.229	26.354	27.640	25.675	26.3391
1.500	.875	58.	27.707	26.832	28.146	26.152	26.8320
1.500	.875	59.	28.184	27.309	28.652	26.630	27.2946
1.500	.875	60.	28.661	27.786	29.154	27.109	27.7860
1.654	.875	7.	3.812	2.937	4.500	2.226	2.8011
1.654	.875	8.	4.322	3.447	5.038	2.785	3.4470
1.654	.875	9.	4.836	3.961	5.566	3.336	3.8560
1.654	.875	10.	5.352	4.477	6.090	3.882	4.4770
1.654	.875	11.	5.871	4.996	6.614	4.424	4.9104
1.654	.875	12.	6.391	5.515	7.222	4.965	5.5160
1.654	.875	13.	6.911	6.036	7.648	5.503	5.9637
1.654	.875	14.	7.433	6.558	8.174	6.038	6.5580
1.654	.875	15.	7.955	7.080	8.768	6.573	7.0174
1.654	.875	16.	8.478	7.603	9.282	7.107	7.6030
1.654	.875	17.	9.001	8.126	9.712	7.640	8.0708
1.654	.875	18.	9.525	8.650	10.264	8.172	8.6500

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
1.654	.875	19.	10.049	9.174	10.772	8.703	9.1247
1.654	.875	20.	10.573	9.698	11.322	9.234	9.6980
1.654	.875	21.	11.098	10.223	11.920	9.765	10.1784
1.654	.875	22.	11.622	10.747	12.468	10.296	10.7470
1.654	.875	23.	12.147	11.272	13.014	10.825	11.2313
1.654	.875	24.	12.672	11.797	13.518	11.354	11.7970
1.654	.875	25.	13.197	12.322	14.064	11.884	12.2845
1.654	.875	26.	13.722	12.847	14.610	12.413	12.8470
1.654	.875	27.	14.247	13.372	15.154	12.942	13.3373
1.654	.875	28.	14.773	13.898	15.658	13.472	13.8980
1.654	.875	29.	15.298	14.423	16.204	13.999	14.3907
1.654	.875	30.	15.823	14.948	16.744	14.528	14.9480
1.654	.875	31.	16.349	15.474	17.290	15.056	15.4438
1.654	.875	32.	16.875	16.000	17.832	15.585	16.0000
1.654	.875	33.	17.400	16.525	18.328	16.113	16.4966
1.654	.875	34.	17.926	17.051	18.868	16.641	17.0510
1.654	.875	35.	18.452	17.577	19.410	17.168	17.5503
1.654	.875	36.	18.978	18.103	19.950	17.698	18.1030
1.654	.875	37.	19.503	18.628	20.488	18.225	18.6027
1.654	.875	38.	20.029	19.154	21.024	18.753	19.1540
1.654	.875	39.	20.555	19.680	21.564	19.280	19.6560
1.654	.875	40.	21.081	20.206	21.984	19.808	20.2060
1.654	.875	41.	21.607	20.732	22.470	20.336	20.7092
1.654	.875	42.	22.133	21.258	23.004	20.863	21.2580
1.654	.875	43.	22.659	21.784	23.536	21.389	21.7622
1.654	.875	44.	23.185	22.310	24.066	21.917	22.3100
1.654	.875	45.	23.711	22.836	24.594	22.445	22.8152
1.654	.875	46.	24.237	23.362	25.122	22.972	23.3620
1.654	.875	47.	24.763	23.888	25.650	23.500	23.8681
1.654	.875	48.	25.289	24.414	26.170	24.027	24.4140
1.654	.875	49.	25.815	24.940	26.696	24.553	24.9209
1.654	.875	50.	26.342	25.467	27.360	25.081	25.4670
1.654	.875	51.	26.868	25.993	27.878	25.609	25.9747

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
1.654	.875	52.	27.394	26.519	28.406	26.135	26.5190
1.654	.875	53.	27.920	27.045	28.840	26.662	27.0273
1.654	.875	54.	28.446	27.571	29.354	27.190	27.5710
1.654	.875	55.	28.972	28.097	29.856	27.717	28.0800
1.654	.875	56.	29.499	28.624	30.358	28.243	28.6240
1.654	.875	57.	30.025	29.150	30.844	28.771	29.1336
1.654	.875	58.	30.551	29.676	31.320	29.297	29.6760
1.654	.875	59.	31.077	30.202	31.714	29.825	30.1861
1.654	.875	60.	31.604	30.729	32.188	30.352	30.7290
1.750	1.000	7.	4.033	3.033	4.654	1.921	2.8892
1.750	1.000	8.	4.573	3.573	5.224	2.512	3.5730
1.750	1.000	9.	5.117	4.117	5.818	3.095	4.0059
1.750	1.000	10.	5.663	4.663	6.368	3.672	4.6630
1.750	1.000	11.	6.212	5.212	7.004	4.246	5.1214
1.750	1.000	12.	6.761	5.761	7.466	4.819	5.7610
1.750	1.000	13.	7.313	6.313	8.104	5.387	6.2365
1.750	1.000	14.	7.864	6.864	8.566	5.954	6.8640
1.750	1.000	15.	8.417	7.417	9.104	6.520	7.3508
1.750	1.000	16.	8.970	7.970	9.730	7.085	7.9700
1.750	1.000	17.	9.524	8.524	10.278	7.648	8.4656
1.750	1.000	18.	10.078	9.078	10.860	8.212	9.0780
1.750	1.000	19.	10.632	9.632	11.396	8.774	9.5798
1.750	1.000	20.	11.187	10.187	11.890	9.335	10.1870
1.750	1.000	21.	11.742	10.742	12.428	9.897	10.6948
1.750	1.000	22.	12.297	11.297	13.004	10.459	11.2970
1.750	1.000	23.	12.852	11.852	13.670	11.019	11.8089
1.750	1.000	24.	13.407	12.407	14.204	11.579	12.4070
1.750	1.000	25.	13.963	12.963	14.780	12.139	12.9234
1.750	1.000	26.	14.518	13.518	15.356	12.699	13.5180
1.750	1.000	27.	15.074	14.074	15.934	13.259	14.0373
1.750	1.000	28.	15.630	14.630	16.460	13.819	14.6300
1.750	1.000	29.	16.186	15.186	17.036	14.377	15.1518
1.750	1.000	30.	16.742	15.742	17.606	14.937	15.7420

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
1.750	1.000	31.	17.298	16.298	18.178	15.495	16.2661
1.750	1.000	32.	17.854	16.854	18.750	16.055	16.8540
1.750	1.000	33.	18.410	17.410	19.272	16.614	17.3800
1.750	1.000	34.	18.966	17.966	19.842	17.172	17.9660
1.750	1.000	35.	19.523	18.523	20.410	17.730	18.4947
1.750	1.000	36.	20.079	19.079	20.978	18.290	19.0790
1.750	1.000	37.	20.635	19.635	21.544	18.848	19.6082
1.750	1.000	38.	21.192	20.192	22.116	19.407	20.1920
1.750	1.000	39.	21.748	20.748	22.680	19.965	20.7226
1.750	1.000	40.	22.305	21.305	23.244	20.523	21.3050
1.750	1.000	41.	22.861	21.861	23.748	21.081	21.8369
1.750	1.000	42.	23.418	22.418	24.312	21.640	22.4180
1.750	1.000	43.	23.974	22.974	24.870	22.196	22.9510
1.750	1.000	44.	24.531	23.531	25.432	22.754	23.5310
1.750	1.000	45.	25.087	24.087	25.988	23.313	24.0650
1.750	1.000	46.	25.644	24.644	26.542	23.871	24.6440
1.750	1.000	47.	26.200	25.200	27.098	24.429	25.1709
1.750	1.000	48.	26.757	25.757	27.646	24.987	25.7570
1.750	1.000	49.	27.314	26.314	28.198	25.544	26.2938
1.750	1.000	50.	27.870	26.870	28.742	26.102	26.8700
1.750	1.000	51.	28.427	27.427	29.278	26.660	27.4076
1.750	1.000	52.	28.984	27.984	29.818	27.217	27.9840
1.750	1.000	53.	29.541	28.541	30.248	27.775	28.5223
1.750	1.000	54.	30.097	29.097	30.740	28.333	29.0970
1.750	1.000	55.	30.654	29.654	31.164	28.892	29.6360
1.750	1.000	56.	31.211	30.211	31.668	29.448	30.2110
1.750	1.000	57.	31.767	30.767	32.256	30.006	30.7496
1.750	1.000	58.	32.324	31.324	32.846	30.563	31.3240
1.750	1.000	59.	32.881	31.881	33.436	31.121	31.8642
1.750	1.000	60.	33.438	32.438	34.024	31.679	32.4380
2.000	1.125	7.	4.610	3.485	5.356	2.302	3.3207
2.000	1.125	8.	5.226	4.101	6.044	2.978	4.1010
2.000	1.125	9.	5.848	4.723	6.674	3.644	4.5961

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	10.	6.472	5.347	7.312	4.304	5.3470
2.000	1.125	11.	7.099	5.974	7.936	4.960	5.8705
2.000	1.125	12.	7.727	6.602	8.568	5.614	6.6020
2.000	1.125	13.	8.357	7.232	9.190	6.264	7.1446
2.000	1.125	14.	8.988	7.863	9.814	6.912	7.8630
2.000	1.125	15.	9.619	8.494	10.440	7.558	8.4183
2.000	1.125	16.	10.252	9.127	11.144	8.204	9.1270
2.000	1.125	17.	10.884	9.759	11.684	8.848	9.6923
2.000	1.125	18.	11.518	10.393	12.348	9.492	10.3930
2.000	1.125	19.	12.151	11.026	12.964	10.134	10.9663
2.000	1.125	20.	12.785	11.660	13.708	10.776	11.6600
2.000	1.125	21.	13.419	12.294	14.324	11.418	12.2400
2.000	1.125	22.	14.053	12.928	14.986	12.060	12.9280
2.000	1.125	23.	14.688	13.563	15.650	12.700	13.5138
2.000	1.125	24.	15.323	14.198	16.260	13.340	14.1980
2.000	1.125	25.	15.957	14.832	16.918	13.980	14.7867
2.000	1.125	26.	16.592	15.467	17.578	14.620	15.4670
2.000	1.125	27.	17.228	16.103	18.238	15.260	16.0611
2.000	1.125	28.	17.863	16.738	18.840	15.900	16.7380
2.000	1.125	29.	18.498	17.373	19.498	16.538	17.3340
2.000	1.125	30.	19.134	18.009	20.154	17.178	18.0090
2.000	1.125	31.	19.769	18.644	20.704	17.816	18.6075
2.000	1.125	32.	20.405	19.280	21.358	18.456	19.2800
2.000	1.125	33.	21.040	19.915	21.958	19.094	19.8807
2.000	1.125	34.	21.676	20.551	22.706	19.732	20.5510
2.000	1.125	35.	22.312	21.187	23.358	20.370	21.1547
2.000	1.125	36.	22.947	21.822	24.004	21.010	21.8220
2.000	1.125	37.	23.583	22.458	24.654	21.648	22.4274
2.000	1.125	38.	24.219	23.094	25.302	22.286	23.0940
2.000	1.125	39.	24.855	23.730	25.952	22.924	23.7010
2.000	1.125	40.	25.491	24.366	26.596	23.562	24.3660
2.000	1.125	41.	26.127	25.002	27.178	24.200	24.9744
2.000	1.125	42.	26.763	25.638	27.820	24.838	25.6380

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	43.	27.399	26.274	28.464	25.474	26.2477
2.000	1.125	44.	28.035	26.910	29.104	26.112	26.9100
2.000	1.125	45.	28.671	27.546	29.742	26.750	27.5209
2.000	1.125	46.	29.307	28.182	30.376	27.388	28.1820
2.000	1.125	47.	29.943	28.818	31.010	28.026	28.7939
2.000	1.125	48.	30.580	29.455	31.646	28.664	29.4550
2.000	1.125	49.	31.216	30.091	32.276	29.300	30.0679
2.000	1.125	50.	31.852	30.727	32.902	29.938	30.7270
2.000	1.125	51.	32.488	31.363	33.520	30.576	31.3408
2.000	1.125	52.	33.124	31.999	34.142	31.212	31.9990
2.000	1.125	53.	33.761	32.636	34.646	31.850	32.6147
2.000	1.125	54.	34.397	33.272	35.232	32.488	33.2720
2.000	1.125	55.	35.033	33.908	35.796	33.126	33.8874
2.000	1.125	56.	35.669	34.544	36.200	33.762	34.5440
2.000	1.125	57.	36.306	35.181	36.876	34.400	35.1612
2.000	1.125	58.	36.942	35.817	37.548	35.036	35.8170
2.000	1.125	59.	37.578	36.453	38.218	35.674	36.4338
2.000	1.125	60.	38.215	37.090	38.892	36.312	37.0900
2.000	1.125	61.	38.851	37.726	39.564	36.948	37.7075
2.000	1.125	62.	39.487	38.362	40.236	37.586	38.3620
2.000	1.125	63.	40.124	38.999	40.912	38.222	38.9810
2.000	1.125	64.	40.760	39.635	41.584	38.860	39.6350
2.000	1.125	65.	41.396	40.271	42.256	39.498	40.2536
2.000	1.125	66.	42.033	40.908	42.928	40.134	40.9080
2.000	1.125	67.	42.669	41.544	43.600	40.772	41.5271
2.000	1.125	68.	43.306	42.181	44.274	41.408	42.1810
2.000	1.125	69.	43.942	42.817	44.948	42.046	42.8006
2.000	1.125	70.	44.578	43.453	45.622	42.682	43.4530
2.000	1.125	71.	45.215	44.090	46.292	43.320	44.0741
2.000	1.125	72.	45.851	44.726	46.964	43.956	44.7260
2.000	1.125	73.	46.488	45.3636	47.640	44.594	45.3475
2.000	1.125	74.	47.124	45.999	48.312	45.230	45.9990
2.000	1.125	75.	47.760	46.635	48.984	45.868	46.6199

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.000	1.125	76.	48.397	47.272	49.656	46.504	47.2720
2.000	1.125	77.	49.033	47.908	50.328	47.142	47.8933
2.000	1.125	78.	49.670	48.545	51.002	47.778	48.5450
2.000	1.125	79.	50.306	49.181	51.674	48.416	49.1667
2.000	1.125	80.	50.943	49.818	52.346	49.052	49.8180
2.000	1.125	81.	51.579	50.454	53.018	49.690	50.4400
2.000	1.125	82.	52.216	51.091	53.692	50.326	51.0910
2.000	1.125	83.	52.852	51.727	54.366	50.964	51.7134
2.000	1.125	84.	53.489	52.364	55.036	51.600	52.3640
2.000	1.125	85.	54.125	53.000	55.708	52.238	52.9867
2.000	1.125	86.	54.761	53.636	56.380	52.874	53.6360
2.000	1.125	87.	55.398	54.273	57.054	53.510	54.2600
2.000	1.125	88.	56.034	54.909	57.728	54.148	54.9090
2.000	1.125	89.	56.671	55.546	58.398	54.784	55.5333
2.000	1.125	90.	57.307	56.182	59.070	55.422	56.1820
2.000	1.125	91.	57.944	56.819	59.744	56.058	56.8066
2.000	1.125	92.	58.580	57.455	60.418	56.696	57.4550
2.000	1.125	93.	59.217	58.092	61.090	57.332	58.0798
2.000	1.125	94.	59.853	58.728	61.760	57.968	58.7280
2.000	1.125	95.	60.490	59.365	62.436	58.606	59.3531
2.000	1.125	96.	61.126	60.001	63.108	59.242	60.0010
2.000	1.125	97.	61.763	60.638	63.780	59.880	60.6263
2.000	1.125	98.	62.399	61.274	64.452	60.516	61.2740
2.000	1.125	99.	63.036	61.911	65.126	61.154	61.8996
2.000	1.125	100.	63.672	62.547	65.796	61.790	62.5470
2.500	1.250	7.	5.762	4.512	6.830	3.190	4.3066
2.500	1.250	8.	6.533	5.283	7.644	4.035	5.2830
2.500	1.250	9.	7.310	6.060	8.520	4.868	5.9013
2.500	1.250	10.	8.090	6.840	9.268	5.693	6.8400
2.500	1.250	11.	8.874	7.624	10.104	6.513	7.4946
2.500	1.250	12.	9.659	8.409	10.888	7.330	8.4090
2.500	1.250	13.	10.446	9.196	11.672	8.143	9.0867
2.500	1.250	14.	11.235	9.985	12.454	8.953	9.9850

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.250	15.	12.024	10.774	13.234	9.760	10.6794
2.500	1.250	16.	12.815	11.565	14.014	10.568	11.5650
2.500	1.250	17.	13.605	12.355	14.890	11.373	12.2716
2.500	1.250	18.	14.397	13.147	15.722	12.178	13.1470
2.500	1.250	19.	15.189	13.939	16.398	12.980	13.8644
2.500	1.250	20.	15.981	14.731	17.230	13.783	14.7310
2.500	1.250	21.	16.774	15.524	18.000	14.585	15.4566
2.500	1.250	22.	17.567	16.317	18.930	15.388	16.3170
2.500	1.250	23.	18.360	17.110	19.760	16.188	17.0484
2.500	1.250	24.	19.153	17.903	20.518	16.988	17.9030
2.500	1.250	25.	19.947	18.697	21.346	17.788	18.6404
2.500	1.250	26.	20.741	19.491	22.174	18.588	19.4910
2.500	1.250	27.	21.534	20.284	22.998	19.388	20.2316
2.500	1.250	28.	22.329	21.079	23.758	20.188	21.0790
2.500	1.250	29.	23.123	21.873	24.582	20.985	21.8242
2.500	1.250	30.	23.917	22.667	25.404	21.785	22.6670
2.500	1.250	31.	24.711	23.461	26.226	22.583	23.4154
2.500	1.250	32.	25.506	24.256	27.050	23.383	24.2560
2.500	1.250	33.	26.300	25.050	27.690	24.180	25.0071
2.500	1.250	34.	27.095	25.845	28.506	24.978	25.8450
2.500	1.250	35.	27.890	26.640	29.326	25.775	26.5996
2.500	1.250	36.	28.684	27.434	30.142	26.575	27.4340
2.500	1.250	37.	29.479	28.229	30.956	27.373	28.1908
2.500	1.250	38.	30.274	29.024	31.892	28.170	29.0240
2.500	1.250	39.	31.069	29.819	32.706	28.968	29.7827
2.500	1.250	40.	31.864	30.614	33.522	29.765	30.6140
2.500	1.250	41.	32.659	31.409	34.256	30.563	31.3745
2.500	1.250	42.	33.454	32.204	35.068	31.360	32.2040
2.500	1.250	43.	34.249	32.999	35.878	32.155	32.9661
2.500	1.250	44.	35.044	33.794	36.686	32.953	33.7940
2.500	1.250	45.	35.839	34.589	37.496	33.750	34.5576
2.500	1.250	46.	36.634	35.384	38.300	34.548	35.3840
2.500	1.250	47.	37.429	36.179	39.106	35.345	36.1489



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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.250	48.	38.224	36.974	39.914	36.143	36.9740
2.500	1.250	49.	39.020	37.770	40.714	36.938	37.7411
2.500	1.250	50.	39.815	38.565	41.516	37.735	38.5650
2.500	1.250	51.	40.610	39.360	42.314	38.533	39.3323
2.500	1.250	52.	41.405	40.155	43.110	39.328	40.1550
2.500	1.250	53.	42.201	40.951	43.794	40.125	40.9243
2.500	1.250	54.	42.996	41.746	44.584	40.923	41.7460
2.500	1.250	55.	43.791	42.541	45.362	41.720	42.5153
2.500	1.250	56.	44.587	43.337	46.144	42.515	43.3370
2.500	1.250	57.	45.382	44.132	46.916	43.313	44.1072
2.500	1.250	58.	46.178	44.928	47.678	44.108	44.9280
2.500	1.250	59.	46.973	45.723	48.434	44.905	45.6990
2.500	1.250	60.	47.768	46.518	49.164	45.703	46.5180
2.500	1.250	61.	48.564	47.314	49.874	46.498	47.2908
2.500	1.250	62.	49.359	48.109	50.468	47.295	48.1090
2.500	1.250	63.	50.155	48.905	51.210	48.090	48.8826
2.500	1.250	64.	50.950	49.700	52.050	48.888	49.7000
2.500	1.250	65.	51.746	50.496	52.892	49.685	50.4742
2.500	1.250	66.	52.541	51.291	53.732	50.480	51.2910
2.500	1.250	67.	53.336	52.086	54.572	51.278	52.0649
2.500	1.250	68.	54.132	52.882	55.414	52.073	52.8820
2.500	1.250	69.	54.927	53.677	56.252	52.870	53.6565
2.500	1.250	70.	55.723	54.473	57.094	53.665	54.4730
2.500	1.250	71.	56.518	55.268	57.938	54.463	55.2481
2.500	1.250	72.	57.314	56.064	58.778	55.258	56.0640
2.500	1.250	73.	58.109	56.859	59.618	56.055	56.8396
2.500	1.250	74.	58.905	57.655	60.460	56.850	57.6550
2.500	1.250	75.	59.701	58.451	61.300	57.648	58.4321
2.500	1.250	76.	60.496	59.246	62.140	58.443	59.2460
2.500	1.250	77.	61.292	60.042	62.982	59.240	60.0236
2.500	1.250	78.	62.087	60.837	63.822	60.035	60.8370
2.500	1.250	79.	62.883	61.633	64.662	60.833	61.6151
2.500	1.250	80.	63.678	62.428	65.502	61.628	62.4280

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.500	1.250	81.	64.474	63.224	66.344	62.425	63.2065
2.500	1.250	82.	65.269	64.019	67.184	63.220	64.0190
2.500	1.250	83.	66.065	64.815	68.024	64.018	64.7980
2.500	1.250	84.	66.861	65.611	68.866	64.813	65.6110
2.500	1.250	85.	67.656	66.406	69.706	65.610	66.3894
2.500	1.250	86.	68.452	67.202	70.550	66.405	67.2020
2.500	1.250	87.	69.247	67.997	71.388	37.200	67.9807
2.500	1.250	88.	70.043	68.793	72.230	67.998	68.7930
2.500	1.250	89.	70.839	69.589	73.070	68.793	69.5731
2.500	1.250	90.	71.634	70.384	73.910	69.590	70.3840
2.500	1.250	91.	72.430	71.180	74.754	70.385	71.1645
2.500	1.250	92.	73.226	71.976	75.594	71.183	71.9760
2.500	1.250	93.	74.021	72.771	76.436	71.978	72.7558
2.500	1.250	94.	74.817	73.567	77.272	72.773	73.5670
2.500	1.250	95.	75.612	74.362	78.114	73.570	74.3471
2.500	1.250	96.	76.408	75.158	78.954	74.365	75.1580
2.500	1.250	97.	77.204	75.954	79.796	75.163	75.9394
2.500	1.250	98.	77.999	76.749	80.636	75.958	76.7490
2.500	1.250	99.	78.795	77.545	81.476	76.755	77.5307
2.500	1.250	100.	79.591	78.341	82.318	77.550	78.3410
2.609	.875	7.	6.013	5.138	7.498	4.161	4.9237
2.609	.875	8.	6.818	5.943	8.362	5.043	5.9430
2.609	.875	9.	7.628	6.753	9.200	5.911	6.5874
2.609	.875	10.	8.443	7.568	10.074	6.772	7.5680
2.609	.875	11.	9.261	8.386	10.910	7.628	8.2510
2.609	.875	12.	10.080	9.205	11.744	8.481	9.2050
2.609	.875	13.	10.902	10.027	12.570	9.329	9.9130
2.609	.875	14.	11.725	10.850	13.396	10.175	10.8500
2.609	.875	15.	12.549	11.674	14.312	11.017	11.5753
2.609	.875	16.	13.373	12.498	15.036	11.860	12.4980
2.609	.875	17.	14.199	13.324	15.854	12.700	13.2370
2.609	.875	18.	15.025	14.150	16.824	13.540	14.1500
2.609	.875	19.	15.851	14.976	17.642	14.378	14.8982

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.609	.875	20.	16.678	15.803	18.516	15.215	15.8030
2.609	.875	21.	17.505	16.630	19.228	16.053	16.5596
2.609	.875	22.	18.333	17.458	20.098	16.890	17.4580
2.609	.875	23.	19.160	18.285	21.066	17.725	18.2208
2.609	.875	24.	19.988	19.113	21.876	18.560	19.1130
2.609	.875	25.	20.817	19.942	22.744	19.395	19.8829
2.609	.875	26.	21.645	20.770	23.612	20.230	20.7700
2.609	.875	27.	22.473	21.598	24.480	21.065	21.5433
2.609	.875	28.	23.302	22.427	25.286	21.899	22.4270
2.609	.875	29.	24.131	23.256	26.152	22.732	23.2051
2.609	.875	30.	24.960	24.085	27.018	23.567	24.0850
2.609	.875	31.	25.789	24.914	27.882	24.399	24.8664
2.609	.875	32.	26.618	25.743	28.748	25.234	25.7430
2.609	.875	33.	27.447	26.572	29.546	26.066	26.5273
2.609	.875	34.	28.276	27.401	30.408	26.898	27.4010
2.609	.875	35.	29.106	28.231	31.274	27.731	28.1886
2.609	.875	36.	29.935	29.060	32.014	28.565	29.0600
2.609	.875	37.	30.764	29.889	32.874	29.398	29.8491
2.609	.875	38.	31.594	30.719	33.734	30.230	30.7190
2.609	.875	39.	32.423	31.548	34.592	31.062	31.5102
2.609	.875	40.	33.253	32.378	35.450	31.895	32.3780
2.609	.875	41.	34.083	33.208	36.360	32.727	33.1720
2.609	.875	42.	34.912	34.037	37.216	33.559	34.0370
2.609	.875	43.	35.742	34.867	38.076	34.389	34.8327
2.609	.875	44.	36.572	35.697	38.932	35.221	35.6970
2.609	.875	45.	37.402	36.527	39.788	36.053	36.4942
2.609	.875	46.	38.231	37.356	40.644	36.886	37.3560
2.609	.875	47.	39.061	38.186	41.500	37.718	38.1546
2.609	.875	48.	39.891	39.016	42.354	38.550	39.0160
2.609	.875	49.	40.721	39.846	43.208	39.380	39.8159
2.609	.875	50.	41.551	40.676	44.064	40.212	40.6760
2.609	.875	51.	42.381	41.506	44.914	41.044	41.4771
2.609	.875	52.	43.211	42.336	45.768	41.874	42.3360

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
2.609	.875	53.	44.041	43.166	46.522	42.706	43.1382
2.609	.875	54.	44.871	43.996	47.372	43.538	43.9960
2.609	.875	55.	45.701	44.826	48.218	44.371	44.7992
2.609	.875	56.	46.531	45.656	49.064	45.200	45.6560
2.609	.875	57.	47.361	46.486	49.912	46.033	46.4601
2.609	.875	58.	48.191	47.316	50.754	46.862	47.3160
2.609	.875	59.	49.021	48.146	51.600	47.695	47.1210
2.609	.875	60.	49.851	48.976	52.440	48.527	48.9760
3.067	1.625	7.	7.069	5.444	8.316	3.839	5.1920
3.067	1.625	8.	8.014	6.389	9.342	4.875	6.3890
3.067	1.625	9.	8.967	7.342	10.286	5.897	7.1473
3.067	1.625	10.	9.925	8.300	11.290	6.909	8.3000
3.067	1.625	11.	10.886	9.261	12.298	7.915	9.1023
3.067	1.625	12.	11.850	10.225	13.264	8.918	10.2250
3.067	1.625	13.	12.816	11.191	14.230	9.914	11.0569
3.067	1.625	14.	13.783	12.158	15.302	10.908	12.1580
3.067	1.625	15.	14.751	13.126	16.136	11.899	13.0100
3.067	1.625	16.	15.721	14.096	17.208	12.889	14.0960
3.067	1.625	17.	16.691	15.066	18.044	13.77	14.9637
3.067	1.625	18.	17.662	16.037	19.066	14.865	16.0370
3.067	1.625	19.	18.634	17.009	20.130	15.849	16.9178
3.067	1.625	20.	19.606	17.981	21.152	16.834	17.9810
3.067	1.625	21.	20.878	18.953	22.094	17.818	18.8703
3.067	1.625	22.	21.551	19.926	23.110	18.803	19.9260
3.067	1.625	23.	22.524	20.899	24.000	19.784	20.8235
3.067	1.625	24.	23.497	21.872	24.942	20.766	21.8720
3.067	1.625	25.	24.471	22.846	25.952	21.747	22.7765
3.067	1.625	26.	25.445	23.820	27.086	22.728	23.8200
3.067	1.625	27.	26.418	24.793	28.098	23.710	24.7287
3.067	1.625	28.	27.393	25.768	29.030	24.691	25.7680
3.067	1.625	29.	28.367	26.742	30.038	25.670	26.6821
3.067	1.625	30.	29.341	27.716	31.044	26.651	27.7160
3.067	1.625	31.	30.316	28.691	32.052	27.629	28.6350

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
3.067	1.625	32.	31.290	29.665	33.058	28.611	29.6650
3.067	1.625	33.	32.265	30.640	33.978	29.589	30.5874
3.067	1.625	34.	33.240	31.615	34.982	30.568	31.6150
3.067	1.625	35.	34.215	32.590	35.980	31.546	32.5404
3.067	1.625	36.	35.190	33.565	36.986	32.527	33.5650
3.067	1.625	37.	36.165	34.540	37.980	33.506	34.4931
3.067	1.625	38.	37.140	35.515	38.982	34.484	35.5150
3.067	1.625	39.	38.115	36.490	39.978	35.463	36.4455
3.067	1.625	40.	39.090	37.465	40.976	36.441	37.4650
3.067	1.625	41.	40.066	38.441	41.876	37.419	38.3987
3.067	1.625	42.	41.041	39.416	42.868	38.398	39.4160
3.067	1.625	43.	42.016	40.391	43.858	39.373	40.3506
3.067	1.625	44.	42.992	41.367	44.848	40.351	41.3670
3.067	1.625	45.	43.967	42.342	45.848	41.330	42.3034
3.067	1.625	46.	44.943	43.318	46.828	42.308	43.3180
3.067	1.625	47.	45.918	44.293	47.804	43.286	44.2561
3.067	1.625	48.	46.894	45.269	48.780	44.265	45.2690
3.067	1.625	49.	47.869	46.244	49.758	45.240	46.2086
3.067	1.625	50.	48.845	47.220	50.736	46.219	47.2200
3.067	1.625	51.	49.821	48.196	51.700	47.197	48.1620
3.067	1.625	52.	50.796	49.171	52.668	48.172	49.1710
3.067	1.625	53.	51.772	50.147	53.644	49.1561	50.1143
3.067	1.625	54.	52.748	51.123	54.626	50.129	51.1230
3.067	1.625	55.	53.723	52.098	55.604	51.107	52.0665
3.067	1.625	56.	54.699	53.074	56.580	52.083	53.0740
3.067	1.625	57.	55.675	54.050	57.556	53.061	54.0196
3.067	1.625	58.	56.651	55.026	58.532	54.036	55.0260
3.067	1.625	59.	57.626	56.001	59.508	55.015	55.9716
3.067	1.625	60.	58.602	56.977	60.484	55.993	56.9770
3.067	1.625	61.	59.578	57.953	61.460	56.968	57.9246
3.067	1.625	62.	60.554	58.929	62.436	57.947	58.9290
3.067	1.625	63.	61.530	59.905	63.412	58.922	59.8775
3.067	1.625	64.	62.506	60.881	64.388	59.900	60.8810

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
3.067	1.625	65.	63.481	61.856	64.846	60.879	61.8293
3.067	1.625	66.	64.457	62.832	65.876	61.854	62.8320
3.067	1.625	67.	65.433	63.808	66.908	62.832	63.7821
3.067	1.625	68.	66.409	64.784	67.940	63.808	64.7840
3.067	1.625	69.	67.385	65.760	68.972	64.786	65.7349
3.067	1.625	70.	68.361	66.736	70.004	65.761	66.7360
3.067	1.625	71.	69.337	67.712	71.036	66.740	67.6876
3.067	1.625	72.	70.313	68.688	72.066	67.715	68.6880
3.067	1.625	73.	71.289	69.664	73.096	68.694	69.6402
3.067	1.625	74.	72.265	70.640	74.130	69.669	70.6400
3.067	1.625	75.	73.241	71.616	75.160	70.647	71.5929
3.067	1.625	76.	74.217	72.592	76.194	71.623	72.5920
3.067	1.625	77.	75.193	73.568	77.226	72.601	73.5455
3.067	1.625	78.	76.169	74.544	78.256	73.576	74.5440
3.067	1.625	79.	77.145	75.520	79.286	74.555	75.4980
3.067	1.625	80.	78.121	76.496	80.320	75.530	76.4960
3.067	1.625	81.	79.097	77.472	81.350	76.508	77.4506
3.067	1.625	82.	80.073	78.448	82.380	77.484	78.4480
3.067	1.625	83.	81.049	79.424	83.412	78.462	79.4031
3.067	1.625	84.	82.025	80.400	84.444	79.437	80.4000
3.067	1.625	85.	83.001	81.376	85.474	80.416	81.3556
3.067	1.625	86.	83.977	82.352	86.508	81.391	82.3520
3.067	1.625	87.	84.953	83.328	87.540	82.366	83.3081
3.067	1.625	88.	85.929	84.304	88.570	83.345	84.3040
3.067	1.625	89.	86.905	85.280	89.602	84.320	85.2605
3.067	1.625	90.	87.881	86.256	90.632	85.298	86.2560
3.067	1.625	91.	88.857	87.232	91.664	86.274	87.2129
3.067	1.625	92.	89.833	88.208	92.696	87.252	88.2080
3.067	1.625	93.	90.809	89.184	93.726	88.227	89.1653
3.067	1.625	94.	91.785	90.160	94.756	89.203	90.1600
3.067	1.625	95.	92.769	91.136	95.790	90.181	91.1177
3.067	1.625	96.	93.737	92.112	96.822	91.156	92.1120
3.067	1.625	97.	94.713	93.088	97.852	92.135	93.0701

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
3.067	1.625	98.	95.690	94.065	98.886	93.110	94.0650
3.067	1.625	99.	96.666	95.041	99.916	94.088	95.0235
3.067	1.625	100.	97.642	96.017	100.946	95.064	96.0170
3.075	1.250	7.	7.087	5.837	8.630	4.542	5.5844
3.075	1.250	8.	8.035	6.785	9.668	5.581	6.7850
3.075	1.250	9.	8.991	7.741	10.684	6.605	7.5458
3.075	1.250	10.	9.951	8.701	11.672	7.620	8.7010
3.075	1.250	11.	10.915	9.665	12.650	8.629	9.5059
3.075	1.250	12.	11.881	10.631	13.626	9.634	10.6310
3.075	1.250	13.	12.849	11.599	14.630	10.634	11.4646
3.075	1.250	14.	13.819	12.569	15.598	11.630	12.5690
3.075	1.250	15.	14.790	13.540	16.684	12.623	13.4237
3.075	1.250	16.	15.762	14.513	17.524	13.616	14.5120
3.075	1.250	17.	16.735	15.485	18.486	14.606	15.3824
3.075	1.250	18.	17.708	16.458	19.634	15.597	16.4580
3.075	1.250	19.	18.682	17.32	20.590	16.584	17.3403
3.075	1.250	20.	19.657	18.407	21.498	17.571	18.4070
3.075	1.250	21.	20.632	19.382	22.450	18.558	19.2990
3.075	1.250	22.	21.607	20.357	23.472	19.545	20.3570
3.075	1.250	23.	22.583	21.333	24.622	20.529	21.2573
3.075	1.250	24.	23.558	22.308	25.566	21.513	22.3080
3.075	1.250	25.	24.535	23.285	26.590	22.497	23.2154
3.075	1.250	26.	25.511	24.261	27.610	23.481	24.2610
3.075	1.250	27.	26.487	25.237	28.628	24.465	25.1725
3.075	1.250	28.	27.464	26.214	29.570	25.449	26.2140
3.075	1.250	29.	28.441	27.191	30.586	26.430	27.1310
3.075	1.250	30.	29.418	28.168	31.608	27.414	28.1680
3.075	1.250	31.	30.395	29.145	32.494	28.395	29.0889
3.075	1.250	32.	31.372	30.122	33.508	29.379	30.1220
3.075	1.250	33.	32.349	31.099	34.438	30.360	31.0463
3.075	1.250	34.	33.327	32.077	35.450	31.341	32.0770
3.075	1.250	35.	34.304	33.054	36.596	32.322	33.0043
3.075	1.250	36.	35.282	34.032	37.610	33.306	34.0320

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
3.075	1.250	37.	36.259	35.009	38.620	34.286	34.9620
3.075	1.250	38.	37.237	35.987	39.632	35.267	35.9870
3.075	1.250	39.	38.215	36.965	40.642	36.248	36.9204
3.075	1.250	40.	39.192	37.942	41.652	37.229	37.9420
3.075	1.250	41.	40.170	38.920	42.574	38.210	38.8776
3.075	1.250	42.	41.148	39.898	43.580	39.191	39.8980
3.075	1.250	43.	42.126	40.876	44.586	40.169	40.8355
3.075	1.250	44.	43.104	41.854	45.592	41.150	41.8540
3.075	1.250	45.	44.082	42.832	46.594	42.131	42.7933
3.075	1.250	46.	45.060	43.810	47.600	43.112	43.8100
3.075	1.250	47.	46.038	44.788	48.600	44.093	44.7510
3.075	1.250	48.	47.016	45.766	49.604	45.074	45.7660
3.075	1.250	49.	47.994	46.744	50.604	46.051	46.7085
3.075	1.250	50.	48.972	47.722	51.602	47.032	47.7220
3.075	1.250	51.	49.951	48.701	52.602	48.013	48.6669
3.075	1.250	52.	50.929	49.679	53.598	48.991	49.6790
3.075	1.250	53.	51.907	50.657	54.468	49.972	50.6242
3.075	1.250	54.	52.885	51.635	55.462	50.953	51.6350
3.075	1.250	55.	53.863	52.613	56.448	51.934	52.5814
3.075	1.250	56.	54.842	53.592	57.440	52.912	53.5920
3.075	1.250	57.	55.820	54.570	58.426	53.893	54.5395
3.075	1.250	58.	56.798	55.548	59.408	54.870	55.5480
3.075	1.250	59.	57.777	56.527	60.390	55.851	56.4975
3.075	1.250	60.	58.755	57.505	61.366	56.832	57.5050
3.500	1.750	7.	8.067	6.317	9.596	4.716	6.0295
3.500	1.750	8.	9.146	7.396	10.728	5.899	7.3960
3.500	1.750	9.	10.233	8.483	11.854	7.065	8.2609
3.500	1.750	10.	11.326	9.576	13.052	8.220	9.5760
3.500	1.750	11.	12.423	10.673	14.108	9.368	10.4919
3.500	1.750	12.	13.523	11.773	15.212	10.512	11.7730
3.500	1.750	13.	14.625	12.875	16.308	11.650	12.7220
3.500	1.750	14.	15.729	13.979	17.456	12.784	13.9790
3.500	1.750	15.	16.834	15.084	18.548	13.914	14.9516



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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
3.500	1.750	16.	17.940	16.190	19.638	15.045	16.1900
3.500	1.750	17.	19.048	17.298	20.840	16.172	17.1812
3.500	1.750	18.	20.156	18.406	21.892	17.299	18.4060
3.500	1.750	19.	21.264	19.514	22.976	18.422	19.4096
3.500	1.750	20.	22.374	20.624	24.258	19.546	20.6240
3.500	1.750	21.	23.483	21.733	25.336	20.669	21.6386
3.500	1.750	22.	24.593	22.843	26.500	21.793	22.8430
3.500	1.750	23.	25.704	23.954	27.536	22.913	23.8678
3.500	1.750	24.	26.815	25.065	28.606	24.033	25.0650
3.500	1.750	25.	27.926	26.176	29.888	25.153	26.0967
3.500	1.750	26.	29.037	27.287	31.044	26.273	27.2870
3.500	1.750	27.	30.148	28.398	32.198	27.393	28.3246
3.500	1.750	28.	31.260	29.510	33.262	28.513	29.5100
3.500	1.750	29.	32.372	30.622	34.414	29.629	30.5537
3.500	1.750	30.	33.484	31.734	35.570	30.749	31.7340
3.500	1.750	31.	34.596	32.846	36.718	31.866	32.7821
3.500	1.750	32.	35.708	33.958	37.868	32.986	33.9580
3.500	1.750	33.	36.820	35.070	38.922	34.102	35.0100
3.500	1.750	34.	37.933	36.183	40.070	35.219	36.1830
3.500	1.750	35.	39.045	37.295	41.216	36.335	37.2384
3.500	1.750	36.	40.158	38.408	42.364	37.455	38.4080
3.500	1.750	37.	41.271	39.521	43.508	38.572	39.4675
3.500	1.750	38.	42.383	40.633	44.502	39.688	40.6330
3.500	1.750	39.	43.496	41.746	45.642	40.805	41.6952
3.500	1.750	40.	44.609	42.859	46.778	41.921	42.8590
3.500	1.750	41.	45.722	43.972	47.806	43.038	43.9237
3.500	1.750	42.	46.835	45.085	48.936	44.154	45.0850
3.500	1.750	43.	47.948	46.198	50.068	45.267	46.1520
3.500	1.750	44.	49.061	47.311	51.196	46.384	47.3110
3.500	1.750	45.	50.175	48.425	52.488	47.500	48.3810
3.500	1.750	46.	51.288	49.538	53.622	48.617	49.5380
3.500	1.750	47.	52.401	50.651	54.748	49.733	50.6089
3.500	1.750	48.	53.514	51.764	55.874	50.850	51.7640

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
3.500	1.750	49.	54.628	52.878	56.998	51.963	52.8376
3.500	1.750	50.	55.741	53.991	58.114	53.079	53.9910
3.500	1.750	51.	56.854	55.104	59.232	54.196	55.0652
3.500	1.750	52.	57.968	56.218	60.348	55.309	56.2180
3.500	1.750	53.	59.081	57.331	61.308	56.425	57.2936
3.500	1.750	54.	60.195	58.445	62.410	57.542	58.4450
3.500	1.750	55.	61.308	59.558	63.506	58.658	59.5220
3.500	1.750	56.	62.421	60.671	64.594	59.771	60.6710
3.500	1.750	57.	63.535	61.785	65.674	60.888	61.7503
3.500	1.750	58.	64.649	62.899	66.744	62.001	62.8990
3.500	1.750	59.	65.762	64.012	67.796	63.117	63.9784
3.500	1.750	60.	66.876	65.1226	68.828	64.234	65.1260
4.063	1.750	7.	9.364	7.614	11.374	6.107	7.2802
4.063	1.750	8.	10.617	8.867	12.690	7.480	8.8670
4.063	1.750	9.	11.879	10.129	14.024	8.833	9.8711
4.063	1.750	10.	13.148	11.398	15.370	10.174	11.3980
4.063	1.750	11.	14.421	12.671	16.658	11.506	12.4607
4.063	1.750	12.	15.698	13.948	17.986	12.835	13.9480
4.063	1.750	13.	16.978	15.228	19.264	14.155	15.0504
4.063	1.750	14.	18.259	16.509	20.540	15.472	16.5090
4.063	1.750	15.	19.542	17.792	21.814	16.784	17.6383
4.063	1.750	16.	20.826	19.076	23.084	18.097	19.0760
4.063	1.750	17.	22.112	20.362	24.486	19.405	20.2265
4.063	1.750	18.	23.398	21.648	25.712	20.713	21.6480
4.063	1.750	19.	24.685	22.935	27.106	22.017	22.8138
4.063	1.750	20.	25.973	24.223	28.464	23.322	24.2230
4.063	1.750	21.	27.261	25.511	29.584	24.626	25.4014
4.063	1.750	22.	28.549	26.799	30.934	25.930	26.7990
4.063	1.750	23.	29.838	28.088	32.424	27.230	27.9880
4.063	1.750	24.	31.128	29.378	33.676	28.530	29.3780
4.063	1.750	25.	32.418	30.668	35.024	29.830	30.5760
4.063	1.750	26.	33.708	31.958	36.372	31.131	31.9580
4.063	1.750	27.	34.998	33.248	37.720	32.431	33.1628

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
4.063	1.750	28.	36.288	34.538	38.816	33.731	34.5380
4.063	1.750	29.	37.579	35.829	40.156	35.027	35.7497
4.063	1.750	30.	38.870	37.120	41.498	36.327	37.1200
4.063	1.750	31.	40.161	38.411	42.838	37.623	38.3368
4.063	1.750	32.	41.452	39.702	44.330	38.923	39.7020
4.063	1.750	33.	42.743	40.993	45.560	40.220	40.9233
4.063	1.750	34.	44.035	42.285	46.898	41.516	42.2850
4.063	1.750	35.	45.326	43.576	48.234	42.812	43.5103
4.063	1.750	36.	46.618	44.868	49.572	44.112	44.8680
4.063	1.750	37.	47.909	46.159	50.904	45.408	46.0969
4.063	1.750	38.	49.201	47.451	52.240	46.704	47.4510
4.063	1.750	39.	50.493	48.743	53.574	48.000	48.6841
4.063	1.750	40.	51.785	50.035	54.906	49.296	50.0350
4.063	1.750	41.	53.077	51.327	56.110	50.592	51.2709
4.063	1.750	42.	54.369	52.619	57.438	51.889	52.6190
4.063	1.750	43.	55.661	53.911	58.766	53.181	53.8575
4.063	1.750	44.	56.953	55.203	60.092	54.477	55.2030
4.063	1.750	45.	58.245	56.495	61.416	55.773	56.4439
4.063	1.750	46.	59.538	57.788	62.740	57.069	57.7880
4.063	1.750	47.	60.830	59.080	64.062	58.365	59.0311
4.063	1.750	48.	62.122	60.372	65.380	59.661	60.3720
4.063	1.750	49.	63.415	61.665	66.698	60.953	61.6181
4.063	1.750	50.	64.707	62.957	68.014	62.249	62.9570
4.063	1.750	51.	66.000	64.250	69.332	63.545	62.2049
4.063	1.750	52.	67.292	65.542	70.646	62.837	65.5420
4.063	1.750	53.	68.585	66.835	71.786	66.133	66.7916
4.063	1.750	54.	69.877	68.127	73.092	67.429	68.1270
4.063	1.750	55.	71.170	69.420	74.394	68.726	69.3782
4.063	1.750	56.	72.462	70.712	75.694	70.018	70.7120
4.063	1.750	57.	73.755	72.005	76.988	71.314	71.9647
4.063	1.750	58.	75.048	73.298	78.282	72.606	73.2980
4.063	1.750	59.	76.340	74.590	79.570	73.902	74.5510
4.063	1.750	60.	77.633	75.883	80.852	75.198	75.8830

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
4.073	1.781	7.	9.387	7.606	11.374	5.752	7.2714
4.073	1.781	8.	10.643	8.862	12.726	7.129	8.8620
4.073	1.781	9.	11.909	10.128	14.084	8.485	9.8695
4.073	1.781	10.	13.181	11.400	15.386	9.829	11.4000
4.073	1.781	11.	14.457	12.676	16.674	11.165	12.4652
4.073	1.781	12.	15.737	13.956	17.970	12.497	13.9560
4.073	1.781	13.	17.019	15.238	19.252	13.821	15.0600
4.073	1.781	14.	18.304	16.523	20.568	15.140	16.5230
4.073	1.781	15.	19.590	17.809	21.844	16.456	17.6549
4.073	1.781	16.	20.878	19.097	23.114	17.771	19.0970
4.073	1.781	17.	22.166	20.385	24.388	19.083	20.2491
4.073	1.781	18.	23.455	21.674	25.882	20.394	21.6740
4.073	1.781	19.	24.746	22.965	27.014	21.702	22.8435
4.073	1.781	20.	26.036	24.255	28.372	23.009	24.2550
4.073	1.781	21.	27.328	25.547	29.768	24.317	25.4371
4.073	1.781	22.	28.620	26.836	31.126	25.624	26.8390
4.073	1.781	23.	29.912	28.131	32.482	26.927	28.0307
4.073	1.781	24.	31.204	29.423	33.592	28.231	29.4230
4.073	1.781	25.	32.497	30.716	34.940	29.534	30.6238
4.073	1.781	26.	33.791	32.010	36.288	30.838	32.0100
4.073	1.781	27.	35.084	33.303	37.782	32.141	33.2176
4.073	1.781	28.	36.378	34.597	39.028	33.444	34.5970
4.073	1.781	29.	37.671	35.890	40.374	34.744	35.8105
4.073	1.781	30.	38.965	37.184	41.720	36.047	37.1840
4.073	1.781	31.	40.260	38.479	43.066	37.346	38.4046
4.073	1.781	32.	41.554	39.773	44.410	38.650	39.7730
4.073	1.781	33.	42.848	41.067	45.636	39.949	40.9972
4.073	1.781	34.	44.143	42.362	46.978	41.248	42.3620
4.073	1.781	35.	45.438	43.657	48.318	42.547	43.5911
4.073	1.781	36.	46.732	44.951	49.658	43.851	44.9510
4.073	1.781	37.	48.027	46.246	50.826	45.150	46.1837
4.073	1.781	38.	49.322	47.541	52.162	46.449	47.5410
4.073	1.781	39.	50.617	48.836	53.494	47.749	48.7769

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TABLE XIII.. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
4.073	1.781	40.	51.912	50.131	54.824	49.048	50.1310
4.073	1.781	41.	53.208	51.427	56.214	50.347	51.3708
4.073	1.781	42.	54.503	52.722	57.362	51.646	52.7220
4.073	1.781	43.	55.798	54.017	58.870	52.942	53.9634
4.073	1.781	44.	57.093	55.312	60.196	54.241	55.3120
4.073	1.781	45.	58.389	56.608	61.524	55.540	56.5568
4.073	1.781	46.	59.684	57.903	62.850	56.840	57.9030
4.073	1.781	47.	60.980	59.199	64.176	58.139	59.1500
4.073	1.781	48.	62.275	60.494	65.496	59.438	60.4940
4.073	1.781	49.	63.571	61.790	66.818	60.733	61.7430
4.073	1.781	50.	64.866	63.085	68.136	62.033	63.0850
4.073	1.781	51.	66.162	64.381	69.454	63.332	64.3358
4.073	1.781	52.	67.458	65.677	70.770	64.627	65.6770
4.073	1.781	53.	68.753	66.972	71.912	65.926	66.9285
4.073	1.781	54.	70.049	68.268	73.216	67.226	68.2680
4.073	1.781	55.	71.345	69.564	74.522	68.525	69.5221
4.073	1.781	56.	72.641	70.860	75.822	69.820	70.8800
4.073	1.781	57.	73.937	72.156	77.120	71.119	72.1156
4.073	1.781	58.	75.232	73.451	78.412	72.415	73.4510
4.073	1.781	59.	76.528	74.747	79.700	73.714	74.7080
4.073	1.781	60.	77.824	76.043	80.980	75.013	76.0430
4.500	2.250	7.	10.371	8.121	12.300	5.992	7.7523
4.500	2.250	8.	11.759	9.509	13.796	7.513	9.5090
4.500	2.250	9.	13.157	10.907	15.266	9.012	10.6214
4.500	2.250	10.	14.562	12.32	16.736	10.497	12.3120
4.500	2.250	11.	15.973	13.723	18.156	11.973	13.4901
4.500	2.250	12.	17.387	15.137	19.578	13.444	15.1370
4.500	2.250	13.	18.804	16.554	21.032	14.907	16.3573
4.500	2.250	14.	20.223	17.973	22.440	16.365	17.9730
4.500	2.250	15.	21.644	19.394	23.850	17.818	19.2237
4.500	2.250	16.	23.066	20.816	25.248	19.272	20.8160
4.500	2.250	17.	24.490	22.240	26.646	20.721	22.0899
4.500	2.250	18.	25.914	23.664	28.144	22.170	23.6640

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
4.500	2.250	19.	27.340	25.090	29.688	23.614	24.9558
4.500	2.250	20.	28.766	26.516	31.034	25.059	26.5160
4.500	2.250	21.	30.193	27.943	32.418	26.503	27.8216
4.500	2.250	22.	31.620	29.370	33.914	27.948	29.3700
4.500	2.250	23.	33.048	30.798	35.564	29.388	30.6872
4.500	2.250	24.	34.476	32.226	36.936	30.828	32.2260
4.500	2.250	25.	35.904	33.654	38.426	32.268	33.5521
4.500	2.250	26.	37.333	35.083	39.758	33.708	35.0830
4.500	2.250	27.	38.762	36.512	41.244	35.148	36.4176
4.500	2.250	28.	40.191	37.941	42.604	36.588	37.9410
4.500	2.250	29.	41.621	39.371	44.248	38.023	39.2832
4.500	2.250	30.	43.050	40.800	45.730	39.463	40.8000
4.500	2.250	31.	44.480	42.230	47.210	40.899	42.1478
4.500	2.250	32.	45.910	43.660	48.688	42.339	43.6600
4.500	2.250	33.	47.340	45.090	50.044	43.774	45.0128
4.500	2.250	34.	48.771	46.521	51.520	45.210	46.5210
4.500	2.250	35.	50.201	47.951	52.992	46.645	47.8782
4.500	2.250	36.	51.632	49.382	54.464	48.085	49.3820
4.500	2.250	37.	53.062	50.812	55.936	49.521	50.7432
4.500	2.250	38.	54.493	52.243	57.406	50.956	52.2430
4.500	2.250	39.	55.924	53.674	58.876	52.392	53.6087
4.500	2.250	40.	57.355	55.105	60.338	53.827	55.1050
4.500	2.250	41.	58.786	56.536	61.660	55.263	56.4739
4.500	2.250	42.	60.217	57.967	63.122	56.698	57.9670
4.500	2.250	43.	61.648	59.398	64.580	58.129	59.3388
4.500	2.250	44.	63.079	60.829	65.824	59.565	60.8290
4.500	2.250	45.	64.510	62.260	67.276	61.000	62.2034
4.500	2.250	46.	65.941	63.691	68.722	62.436	63.6910
4.500	2.250	47.	67.373	65.123	70.166	63.871	65.0688
4.500	2.250	48.	68.804	66.554	71.606	65.307	66.5540
4.500	2.250	49.	70.235	67.985	73.046	66.738	67.9331
4.500	2.250	50.	71.667	69.417	74.480	68.173	69.4170
4.500	2.250	51.	73.098	70.848	76.158	69.609	70.7981

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
4.500	2.250	52.	74.530	72.280	77.592	71.040	72.2800
4.500	2.250	53.	75.961	73.711	78.832	72.475	73.6630
4.500	2.250	54.	77.393	75.143	80.250	73.911	75.1430
4.500	2.250	55.	78.825	76.575	81.658	75.346	76.5287
4.500	2.250	56.	80.256	78.006	83.062	76.777	78.0060
4.500	2.250	57.	81.688	79.438	84.448	78.213	79.3933
4.500	2.250	58.	83.120	80.870	85.828	79.644	80.8700
4.500	2.250	59.	84.551	82.301	87.186	81.079	82.2579
4.500	2.250	60.	85.983	83.733	88.510	82.515	83.7330
5.000	2.500	7.	11.524	9.024	13.692	6.505	8.6132
5.000	2.500	8.	13.066	10.566	15.346	8.195	10.5660
5.000	2.500	9.	14.619	12.119	16.948	9.860	11.8017
5.000	2.500	10.	16.180	13.680	18.618	11.510	13.6800
5.000	2.250	11.	17.747	15.247	20.198	13.150	14.9882
5.000	2.250	12.	19.319	16.819	21.832	14.785	16.8190
5.000	2.250	13.	20.893	18.393	23.346	16.410	18.1745
5.000	2.250	14.	22.470	19.970	24.968	18.030	19.9700
5.000	2.250	15.	24.049	21.549	26.530	19.645	21.3598
5.000	2.250	16.	25.629	23.129	28.080	21.260	23.1290
5.000	2.250	17.	27.211	24.711	29.638	22.870	24.5442
5.000	2.250	18.	28.794	26.294	31.306	24.480	26.2940
5.000	2.250	19.	30.378	27.878	32.850	26.085	27.7289
5.000	2.500	20.	31.962	29.462	34.654	27.690	29.4620
5.000	2.500	21.	33.548	31.048	36.196	29.295	30.9131
5.000	2.500	22.	35.133	32.633	37.712	30.900	32.6330
5.000	2.500	23.	36.720	34.220	39.370	32.500	34.0969
5.000	2.500	24.	38.306	35.806	41.042	34.100	35.8060
5.000	2.500	25.	39.894	37.394	42.698	35.700	37.2808
5.000	2.500	26.	41.481	38.981	44.350	37.300	38.9810
5.000	2.500	27.	43.069	40.569	45.850	38.900	40.4642
5.000	2.500	28.	44.657	42.157	47.368	40.500	42.1570
5.000	2.500	29.	46.245	43.745	49.014	42.095	43.6474
5.000	2.500	30.	47.834	45.334	50.814	43.695	45.3340

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
5.000	2.500	31.	49.423	46.923	52.460	45.290	46.8317
5.000	2.500	32.	51.011	48.511	54.102	46.890	48.5110
5.000	2.500	33.	52.601	50.101	55.600	48.485	50.0153
5.000	2.500	34.	54.190	51.690	57.240	50.080	51.6900
5.000	2.500	35.	55.779	53.279	58.876	51.675	53.1982
5.000	2.500	36.	57.369	54.869	60.512	53.275	54.8690
5.000	2.500	37.	58.958	56.458	62.148	54.870	56.3815
5.000	2.500	38.	60.548	58.048	63.780	56.465	58.0480
5.000	2.500	39.	62.138	59.638	65.410	58.060	59.5655
5.000	2.500	40.	63.727	61.227	67.038	59.655	61.2270
5.000	2.500	41.	65.317	62.817	68.512	61.250	62.7480
5.000	2.500	42.	66.907	64.407	70.138	62.845	64.4070
5.000	2.500	43.	68.498	65.998	71.760	64.435	65.9322
5.000	2.500	44.	70.088	67.588	73.380	66.030	67.5880
5.000	2.500	45.	71.678	69.178	74.994	67.625	69.1151
5.000	2.500	46.	73.268	70.768	76.608	69.220	70.7680
5.000	2.500	47.	74.859	72.359	78.012	70.815	72.2988
5.000	2.500	48.	76.449	73.949	79.614	72.410	73.9490
5.000	2.500	49.	78.039	75.539	81.212	74.000	75.4813
5.000	2.500	50.	79.630	77.130	82.810	75.595	77.1300
5.000	2.500	51.	81.220	78.720	84.402	77.190	78.6645
5.000	2.500	52.	82.811	80.311	85.984	78.780	80.3110
5.000	2.500	53.	84.402	81.902	87.594	80.375	81.8486
5.000	2.500	54.	85.992	83.492	89.164	81.970	83.4920
5.000	2.500	55.	87.583	85.083	90.730	83.565	85.0316
5.000	2.500	56.	89.174	86.674	92.290	85.155	86.6740
5.000	2.500	57.	90.764	88.264	93.834	86.750	88.2144
5.000	2.500	58.	92.355	89.855	95.362	88.340	89.8550
5.000	2.500	59.	93.946	91.446	96.876	89.935	91.3981
5.000	2.500	60.	95.537	93.037	98.350	91.530	93.0370
6.000	3.000	7.	13.829	10.829	16.432	8.031	10.3361
6.000	3.000	8.	15.679	12.679	18.440	10.059	12.6790
6.000	3.000	9.	17.543	14.543	20.356	12.057	14.1622



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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
6.000	3.000	10.	19.416	16.416	22.318	14.037	16.4160
6.000	3.000	11.	21.297	18.297	24.240	16.005	17.9865
6.000	3.000	12.	23.182	20.182	26.134	17.967	20.1820
6.000	3.000	13.	25.071	22.071	28.016	19.917	21.8088
6.000	3.000	14.	26.964	23.964	29.960	21.861	23.9640
6.000	3.000	15.	28.858	25.858	31.832	23.799	25.6310
6.000	3.000	16.	30.755	27.755	33.702	25.737	27.7550
6.000	3.000	17.	32.653	29.653	35.562	27.669	29.4529
6.000	3.000	18.	34.553	31.553	37.562	29.601	31.5530
6.000	3.000	19.	36.453	33.453	39.422	31.527	33.2740
6.000	3.000	20.	38.355	35.355	41.418	33.453	35.3550
6.000	3.000	21.	40.257	37.257	43.266	35.379	37.0951
6.000	3.000	22.	42.160	39.160	45.424	37.305	39.1600
6.000	3.000	23.	44.064	41.064	47.414	39.225	40.9163
6.000	3.000	24.	45.968	42.968	49.078	41.145	42.9680
6.000	3.000	25.	47.872	44.872	51.062	43.065	44.7361
6.000	3.000	26.	49.777	46.777	53.220	44.985	46.7770
6.000	3.000	27.	51.683	48.683	55.204	46.905	48.5572
6.000	3.000	28.	53.588	50.588	57.026	48.825	50.5880
6.000	3.000	29.	55.494	52.494	59.004	50.439	52.3769
6.000	3.000	30.	57.401	54.401	60.796	52.659	54.4010
6.000	3.000	31.	59.307	56.307	62.764	54.573	56.1975
6.000	3.000	32.	61.214	58.214	64.736	56.493	58.2140
6.000	3.000	33.	63.121	60.121	66.538	58.407	60.0181
6.000	3.000	34.	65.028	62.028	68.694	60.321	62.0280
6.000	3.000	35.	66.935	63.935	70.658	62.235	63.8380
6.000	3.000	36.	68.842	65.842	72.622	64.155	65.8420
6.000	3.000	37.	70.750	67.750	74.582	66.069	67.6582
6.000	3.000	38.	72.657	69.657	76.540	67.983	69.6570
6.000	3.000	39.	74.565	71.565	78.500	69.897	71.4780
6.000	3.000	40.	76.473	73.473	80.454	71.811	73.4730
6.000	3.000	41.	78.381	75.381	82.216	73.725	75.2982
6.000	3.000	42.	80.289	77.289	84.160	75.639	77.2890

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
6.000	3.000	43.	82.197	79.197	86.106	77.547	79.1181
6.000	3.000	44.	84.105	81.105	88.048	79.461	81.1050
6.000	3.000	45.	86.014	83.014	89.990	81.375	82.9386
6.000	3.000	46.	87.922	84.922	91.926	83.289	84.9220
6.000	3.000	47.	89.830	86.830	93.858	85.203	86.7578
6.000	3.000	48.	91.739	88.739	95.786	87.117	88.7390
6.000	3.000	49.	93.647	90.647	97.712	89.025	90.5777
6.000	3.000	50.	95.556	92.556	99.638	90.939	92.5560
6.000	3.000	51.	97.464	94.464	101.280	92.853	94.3975
6.000	3.000	52.	99.373	96.373	103.184	94.761	96.3730
6.000	3.000	53.	101.282	98.282	104.814	86.675	98.2180
6.000	3.000	54.	103.191	100.191	106.690	98.589	100.1910
6.000	3.000	55.	105.099	102.099	108.554	100.503	102.0373
6.000	3.000	56.	107.008	104.008	110.408	102.411	104.0080
6.000	3.000	57.	108.917	105.917	112.234	104.325	105.8575
6.000	3.000	58.	110.826	107.826	114.434	106.233	107.8260
6.000	3.000	59.	112.735	109.735	116.238	108.147	109.6775
6.000	3.000	60.	114.644	111.644	118.010	110.061	111.6440
7.000	3.500	7.	16.133	12.633	19.170	8.932	12.0579
7.000	3.500	8.	18.292	14.792	21.486	11.298	14.7920
7.000	3.500	9.	20.467	16.967	23.776	15.629	16.5227
7.000	3.500	10.	22.652	19.152	26.010	15.939	19.1520
7.000	3.500	11.	24.846	21.346	48.248	18.235	20.9837
7.000	3.500	12.	27.046	23.546	30.520	20.524	23.5460
7.000	3.500	13.	29.250	25.750	32.724	22.790	25.4440
7.000	3.500	14.	31.458	27.958	34.912	25.067	27.9580
7.000	3.500	15.	33.668	30.168	37.140	27.328	29.9032
7.000	3.500	16.	35.881	32.381	39.320	29.589	32.3810
7.000	3.500	17.	38.095	34.595	41.450	31.843	34.3615
7.000	3.500	18.	40.311	36.811	43.830	34.097	36.8110
7.000	3.500	19.	42.529	39.029	45.994	36.344	38.8202
7.000	3.500	20.	44.747	41.247	48.320	38.591	41.2470
7.000	3.500	21.	46.967	43.467	50.474	40.838	43.2782

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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
7.000	3.500	22.	49.187	45.687	52.796	43.085	45.6870
7.000	3.500	23.	51.408	47.908	55.118	45.325	47.7356
7.000	3.500	24.	53.629	50.129	57.460	47.565	50.1290
7.000	3.500	25.	55.851	52.351	59.574	49.805	52.1925
7.000	3.500	26.	58.074	54.574	61.886	52.045	54.5740
7.000	3.500	27.	60.297	56.797	64.196	54.285	56.6502
7.000	3.500	28.	62.520	59.020	66.532	56.525	59.0200
7.000	3.500	29.	64.743	61.243	68.838	58.758	61.1064
7.000	3.500	30.	66.967	63.467	71.142	60.998	63.4670
7.000	3.500	31.	69.192	65.692	73.448	63.231	65.5642
7.000	3.500	32.	71.416	67.916	75.748	65.471	67.9160
7.000	3.500	33.	73.641	70.141	77.622	67.704	70.0210
7.000	3.500	34.	75.866	72.366	79.914	69.937	72.3660
7.000	3.500	35.	78.091	74.591	82.202	72.170	74.4778
7.000	3.500	36.	80.316	76.816	84.724	74.410	76.8160
7.000	3.500	37.	82.541	79.041	87.012	76.643	78.9340
7.000	3.500	38.	84.767	81.267	89.296	78.876	81.2670
7.000	3.500	39.	86.993	83.493	91.582	81.109	83.3914
7.000	3.500	40.	89.218	85.718	93.862	83.342	85.7180
7.000	3.500	41.	91.444	87.944	95.918	85.575	87.8474
7.000	3.500	42.	93.670	90.170	98.190	87.808	90.1700
7.000	3.500	43.	95.897	92.397	100.456	90.034	92.3049
7.000	3.500	44.	98.123	94.623	102.722	92.267	94.6230
7.000	3.500	45.	100.349	96.849	104.980	94.500	96.7610
7.000	3.500	46.	102.576	99.076	107.246	96.733	99.0760
7.000	3.500	47.	104.802	101.302	109.500	98.966	101.2177
7.000	3.500	48.	107.029	103.529	111.752	101.190	103.5290
7.000	3.500	49.	109.255	105.755	113.998	103.425	105.6742
7.000	3.500	50.	111.482	107.982	116.240	105.658	107.9820
7.000	3.500	51.	113.709	110.209	118.478	107.891	110.1314
7.000	3.500	52.	115.935	112.435	120.706	110.117	112.4350
7.000	3.500	53.	118.162	114.662	122.630	112.350	114.5873
7.000	3.500	54.	120.389	116.889	124.832	114.583	116.8890

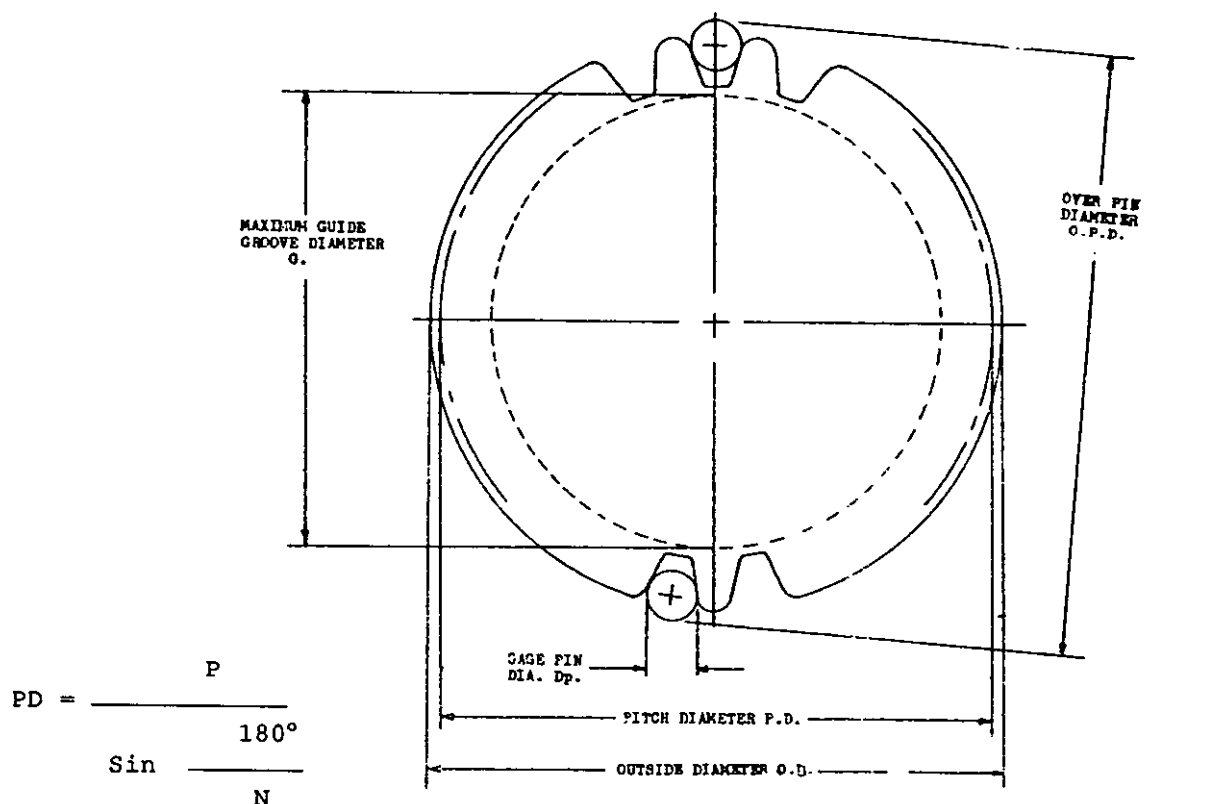
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TABLE XIII. Sprocket wheels for roller chains (ANSI B29.10) ANSI B29.4.

P	D	N	PD	BD	OD	MHD	CD
7.000	3.500	55.	122.616	119.116	127.03	116.816	119.0440
7.000	3.500	56.	124.843	121.343	128.818	119.042	121.3430
7.000	3.500	57.	127.070	123.570	130.960	121.275	123.5005
7.000	3.500	58.	129.297	125.797	133.070	123.501	125.7970
7.000	3.500	59.	131.524	128.024	135.146	125.734	127.9569
7.000	3.500	60.	133.751	130.251	137.140	127.967	130.2510

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6. Sprocket wheels for silent chains 60° inverted tooth (ANSI B29.10)
- a. Diameters.



$$D_p = 0.625P$$

$$OPD \text{ (For Even No. of Teeth)} = PD - 0.125P \csc \left( 30 - \frac{180^\circ}{N} \right) + 0.625P$$

$$OPD \text{ (For Odd No. of Teeth)} = \cos \frac{90^\circ}{N} \left[ PD - 0.125P \csc \left( 30 - \frac{180^\circ}{N} \right) \right] + 0.625P$$

$$OD \text{ (For Rounded Teeth)} = P \left( \cot \frac{180^\circ}{N} + 0.08 \right)$$

$$OD \text{ (For Square Teeth)} = 2 \sqrt{X^2 + L^2 - 2XL \cos \phi_c}$$

FIGURE 34. Diameters.

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WHERE

$$\begin{aligned}
 X &= Y \cos o_c - \sqrt{(0.15P)^2 - (Y \sin o_c)^2} \\
 Y &= P (0.500 - 0.375 \sec o_c) \cot o_c + 0.11P \\
 L &= Y + \frac{E}{2} \text{ (See Figure 35 for E)} \\
 o_c &= (30 - \frac{360^\circ}{N})
 \end{aligned}$$

$$G \text{ (max.)} = P \left( \cot \frac{180^\circ}{N} - 1.16 \right)$$

FIGURE 34. Diameters, continued.

## LEGEND

P = Chain Pitch

PD = Pitch Diameter

OD = Outside Diameter

Dp = Gage Pin Diameter

N = Number of Teeth

E = Diameter to Center of  
Topping Curve

OPD = Over Pin Diameter

G = Maximum Guide Groove  
Diameter

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## a. DIAMETERS CONTINUED

## SPROCKET DIAMETER TOLERANCES AND MAXIMUM HUB DIAMETERS

Tolerance for Outside Diameters of sprockets with square top teeth = +0.000; -0.050 x pitch (in.).  
 Tolerance for Guide Groove Diameter "G" = +0.000; - 0.031 (in.).  
 Tolerance for Maximum Eccentricity (total indicator reading) Pitch Diameter with respect to Bore = 0.001 x PD (in.) but not less than 0.006 nor more than 0.032.

TABLE XIV. Over pin diameter tolerances (inches).

(All tolerances are negative. Tolerance =  $(0.004 + 0.001 P \sqrt{N})$ , Where P = Chain Pitch, N = Number of Teeth.)

Pitch	Up to 15	16-24	25-35	36-48	49-63	64-80	81-99	100-120	121-143	144 up
0.375	0.005	0.005	0.005	0.006	0.006	0.007	0.007	0.007	0.008	0.008
0.050	0.005	0.006	0.006	0.007	0.007	0.008	0.008	0.009	0.009	0.010
0.625	0.006	0.006	0.007	0.008	0.009	0.010	0.010	0.010	0.011	0.012
0.750	0.006	0.007	0.008	0.009	0.010	0.011	0.011	0.012	0.013	0.014
1.00	0.007	0.008	0.009	0.010	0.011	0.012	0.013	0.014	0.015	0.016
1.250	0.008	0.009	0.010	0.011	0.013	0.014	0.015	0.017	0.018	0.019
1.500	0.008	0.010	0.011	0.013	0.014	0.016	0.017	0.019	0.020	0.022
2.00	0.010	0.012	0.014	0.016	0.018	0.020	0.022	0.024	0.026	0.028

## FORMULAS FOR CALCULATING MAXIMUM HUB DIAMETERS (MHD):

MHD (For Hobbed Teeth) =  $P \left( \cot \frac{180^\circ}{N} - 1.33 \right)$

MHD (For Straddle Cut Teeth) =  $P \left( \cot \frac{180^\circ}{N} - 1.25 \right)$

MHD for other methods of cutting teeth may differ from the above.

TABLE XV. Maximum hub diameter (inches) 1 inch pitch silent chain.

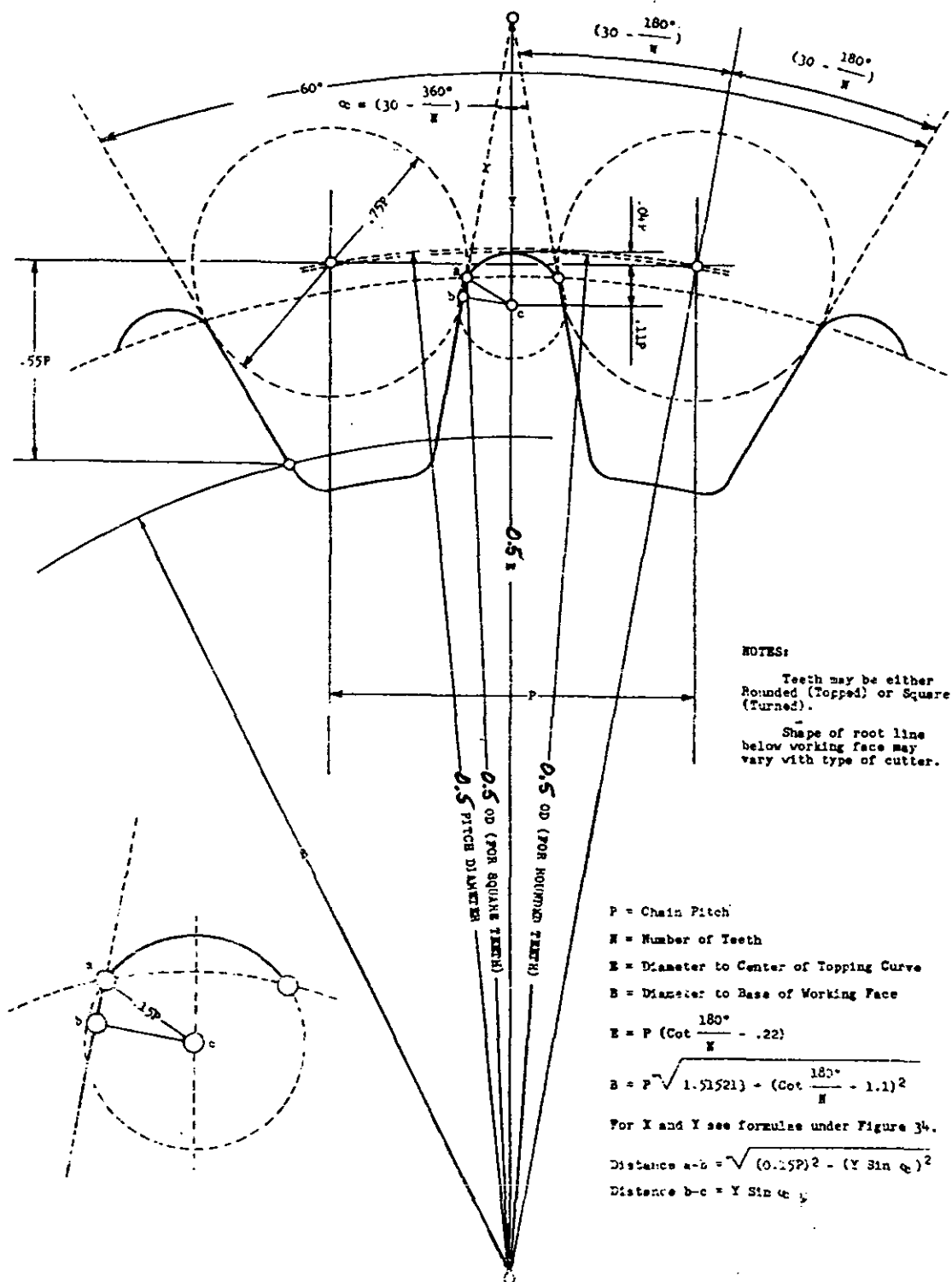
(For other chain pitches (0.375 pitch and larger) multiply these values by chain pitch.)

No. Teeth	Hub Cut	Straddle Cut	No. Teeth	Hub Cut	Straddle Cut	No. Teeth	Hub Cut	Straddle Cut
17	4.019	4.099	22	5.626	5.706	27	7.226	7.306
18	4.341	4.421	23	5.946	6.026	28	7.546	7.626
19	4.662	4.742	24	6.265	6.345	29	7.865	7.945
20	4.983	5.063	25	6.586	6.666	30	8.185	8.265
21	5.304	5.384	26	6.905	6.985	31	8.503	8.583

Teeth of sprockets up to and including 31 teeth should have a Rockwell hardness of not less than C50.



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FIGURE 35. Sprocket tooth form.

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TABLE XVI. Standard diameters of sprockets, 1 inch pitch silent chain.

For other pitches (0.375 pitch and larger) multiply these values by pitch.

(For tolerances, see table XIV.)

No. Teeth	Pitch Diameter	Outside Diameter		Over-Pin Dia.	Max Guide Groove Dia.	Gage Pin Dia.
		Rounded*	Square**			
17	5.442	5.429	5.298	5.669	4.189	0.625
18	5.759	5.751	5.623	6.018	4.511	0.625
19	6.076	6.072	5.947	6.324	4.832	0.625
20	6.393	6.393	6.271	6.669	5.153	0.625
21	6.710	6.714	6.595	6.974	5.474	0.625
22	7.027	7.036	6.919	7.315	5.796	0.625
23	7.344	7.356	7.243	7.621	6.116	0.625
24	7.661	7.675	7.568	7.960	6.435	0.625
25	7.979	7.996	7.890	8.266	6.756	0.625
26	8.296	8.315	8.213	8.602	7.075	0.625
27	8.614	8.636	8.536	8.909	7.396	0.625
28	8.932	8.956	8.859	9.244	7.716	0.625
29	9.249	9.275	9.181	9.551	8.035	0.625
30	9.567	9.595	9.504	9.884	8.355	0.625
31	9.885	9.913	9.828	10.192	8.673	0.625
32	10.202	10.233	10.150	10.524	8.993	0.625
33	10.520	10.553	10.471	10.833	9.313	0.625
34	10.838	10.872	10.793	11.164	9.632	0.625
35	11.156	11.191	11.115	11.472	9.951	0.625
36	11.474	11.510	11.437	11.803	10.270	0.625
37	11.792	11.829	11.757	12.112	10.589	0.625
38	12.110	12.149	12.077	12.442	10.909	0.625
39	12.428	12.468	12.397	12.751	11.228	0.625
40	12.746	12.787	12.717	13.080	11.547	0.625
41	13.064	13.106	13.037	13.390	11.866	0.625
42	13.382	13.425	13.357	13.718	12.185	0.625
43	13.700	13.743	13.677	14.028	12.503	0.625
44	14.018	14.062	13.997	14.356	12.822	0.625

\* Blank diameters shall be 0.020 larger than finished diameters tabulated above.

\*\* Diameters given are maximum; all tolerances must be negative.

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TABLE XVI. Standard diameters of sprockets, 1 inch pitch silent chain,  
continued.

No. Teeth	Pitch Diameter	Outside Diameter		Over-Pin Dia.	Max Guide Groove Dia.	Gage Pin Dia.
		Rounded*	Square**			
45	14.336	14.381	14.317	14.667	13.141	0.625
46	14.654	14.700	14.637	14.994	13.460	0.625
47	14.972	15.018	14.957	15.305	13.778	0.625
48	15.290	15.337	15.277	15.632	14.097	0.625
49	15.608	15.656	15.597	15.943	14.416	0.625
50	15.926	15.975	15.917	16.270	14.735	0.625
51	16.244	16.293	16.236	16.581	15.053	0.625
52	16.562	16.612	16.556	16.907	15.372	0.625
53	16.880	16.930	16.876	17.218	15.690	0.625
54	17.198	17.249	17.196	17.544	16.009	0.625
55	17.517	17.568	17.515	17.857	16.328	0.625
56	17.835	17.887	17.834	18.183	16.647	0.625
57	18.153	18.205	18.154	18.494	16.965	0.625
58	18.471	18.524	18.473	18.820	17.284	0.625
59	18.789	18.842	18.793	19.131	17.602	0.625
60	19.107	19.161	19.112	19.457	17.921	0.625
61	19.426	19.480	19.431	19.769	18.240	0.625
62	19.744	19.799	19.750	20.095	18.559	0.625
63	20.062	20.117	20.070	20.407	18.877	0.625
64	20.380	20.435	20.388	20.731	19.195	0.625
65	20.698	20.754	20.708	21.044	19.514	0.625
66	21.016	21.072	21.027	21.368	19.832	0.625
67	21.335	21.391	21.346	21.682	20.151	0.625
68	21.653	21.710	21.665	22.006	20.470	0.625
69	21.971	22.028	21.984	22.319	20.788	0.625
70	22.289	22.347	22.303	22.643	21.107	0.625
71	22.607	22.665	22.622	22.955	21.425	0.625
72	22.926	22.984	22.941	23.280	21.744	0.625
73	23.244	23.302	23.259	23.593	22.062	0.625
74	23.562	23.621	23.578	23.917	22.381	0.625

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TABLE XVI. Standard diameters of sprockets, 1 inch pitch silent chain, continued.

No. Teeth	Pitch Diameter	Outside Diameter		Over-Pin Dia.	Max Guide Groove Dia.	Gage Pin Dia.
		Rounded*	Square**			
75	23.880	23.939	23.897	24.230	22.699	0.625
76	24.198	24.257	24.216	24.553	23.017	0.625
77	24.517	24.577	24.535	24.868	23.337	0.625
78	24.835	24.895	24.853	25.191	23.655	0.625
79	25.153	25.213	25.172	25.504	23.973	0.625
80	25.471	25.531	25.491	25.828	24.291	0.625
81	25.790	25.851	25.809	26.141	24.611	0.625
82	26.108	26.169	26.128	26.465	24.929	0.625
83	26.426	26.487	26.447	26.778	25.247	0.625
84	26.744	26.805	26.766	27.101	25.565	0.625
85	27.063	27.125	27.084	27.415	25.885	0.625
86	27.381	27.443	27.403	27.739	26.203	0.625
87	27.699	27.761	27.722	28.052	26.521	0.625
88	28.017	28.070	28.040	28.375	26.839	0.625
89	28.335	28.397	28.359	28.689	27.157	0.625
90	28.654	28.716	28.678	29.013	27.476	0.625
91	28.972	29.035	28.997	29.327	27.795	0.625
92	29.290	29.353	29.315	29.649	28.113	0.625
93	29.608	29.671	29.634	29.963	28.431	0.625
94	29.926	29.989	29.953	30.285	28.749	0.625
95	30.245	30.308	30.271	30.601	29.068	0.625
96	30.563	30.627	30.590	30.923	29.387	0.625
97	30.881	30.945	30.909	31.237	29.705	0.625
98	31.199	31.263	31.228	31.559	30.023	0.625
99	31.518	31.582	31.546	31.874	30.342	0.625
100	31.836	31.900	31.865	32.196	30.660	0.625
101	32.154	32.218	32.183	32.511	30.978	0.625
102	32.473	32.537	32.502	32.834	31.297	0.625
103	32.791	32.856	32.820	33.148	31.616	0.625
104	33.109	33.174	33.139	33.470	31.934	0.625

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TABLE XVI. Standard diameters of sprockets, 1 inch pitch silent chain,  
continued.

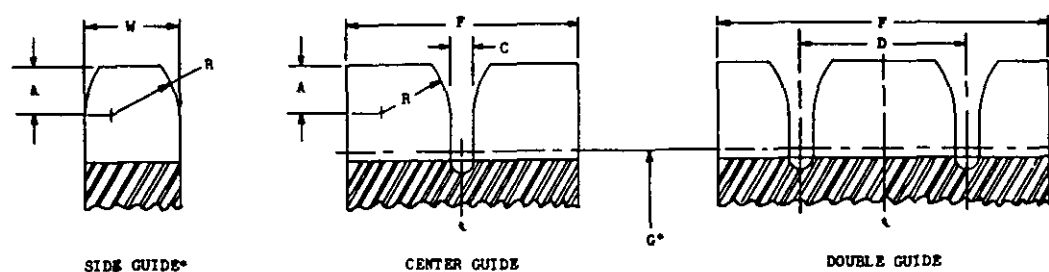
No. Teeth	Pitch Diameter	Outside Diameter		Over-Pin Dia.	Max Guide Groove Dia.	Gage Pin Dia.
		Rounded*	Square**			
105	33.427	33.492	33.457	33.784	32.252	0.625
106	33.746	33.811	33.776	34.107	32.571	0.625
107	34.064	34.129	34.094	34.422	32.889	0.625
108	34.382	34.447	34.413	34.744	33.207	0.625
109	34.701	34.767	34.731	35.059	33.527	0.625
110	35.019	35.084	35.050	35.381	33.844	0.625
111	35.337	35.403	35.368	35.695	34.163	0.625
112	35.655	35.721	35.687	36.017	34.481	0.625
113	35.974	36.040	36.005	36.333	34.800	0.625
114	36.292	36.358	36.324	36.654	35.118	0.625
115	36.610	36.676	36.642	36.969	35.436	0.625
116	36.929	36.995	36.961	37.292	35.755	0.625
117	37.247	37.313	37.279	37.606	36.073	0.625
118	37.565	37.632	37.598	37.928	36.392	0.625
119	37.883	37.950	37.916	38.243	36.710	0.625
120	38.201	38.268	38.235	38.564	37.028	0.625
121	38.519	38.586	38.553	38.879	37.346	0.625
122	38.837	38.904	38.872	39.200	37.664	0.625
123	39.156	39.223	39.190	39.516	37.983	0.625
124	39.475	39.542	39.508	39.839	38.302	0.625
125	39.794	39.861	39.827	40.154	38.621	0.625
126	40.112	40.180	40.145	40.476	38.940	0.625
127	40.430	40.497	40.464	40.790	39.257	0.625
128	40.748	40.816	40.782	41.112	39.576	0.625
129	41.066	41.134	41.100	41.427	39.894	0.625
130	41.384	41.452	41.419	41.748	40.212	0.625
131	41.702	41.770	41.738	42.063	40.530	0.625
132	42.020	42.088	42.056	42.384	40.848	0.625
133	42.338	42.406	42.374	42.699	41.166	0.625
134	42.656	42.724	42.693	43.020	41.484	0.625

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TABLE XVI. Standard diameters of sprockets, 1 inch pitch silent chain, continued.

No. Teeth	Pitch Diameter	Outside Diameter		Over-Pin Dia.	Max Guide Groove Dia.	Gage Pin Dia.
		Rounded* Teeth	Square** Teeth			
135	42.975	43.043	43.011	43.336	41.803	0.625
136	43.293	43.362	43.329	43.657	42.122	0.625
137	43.611	43.679	43.647	43.972	42.439	0.625
138	43.930	43.998	43.966	44.295	42.758	0.625
139	44.242	44.317	44.284	44.611	43.077	0.625
140	44.567	44.636	44.603	44.932	43.396	0.625
141	44.885	44.954	44.922	45.247	43.714	0.625
142	45.203	45.271	45.240	45.562	44.031	0.625
143	45.521	45.590	45.558	45.883	44.350	0.625
144	45.840	45.909	45.877	46.205	44.669	0.625
145	46.158	46.227	46.195	46.520	44.987	0.625
146	46.477	46.546	46.514	46.842	45.306	0.625
147	46.796	46.865	46.832	47.159	45.625	0.625
148	47.114	47.183	47.151	47.479	45.943	0.625
149	47.432	47.501	47.469	47.795	46.201	0.625
150	47.750	47.819	47.787	48.116	46.579	0.625

## c. Sprocket face profiles.



Grooving tool may be either square or round end but groove must be full width down to diameter G. For values of G see table XVI

All sprockets shall be marked with complete chain number and number of teeth. Example: SC304-25.

FIGURE 36. Sprocket profiles.

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TABLE XVII. Sprocket face dimensions.

Chain No.	Chain Pitch	Type	A	C +0.005	D +0.010	F +0.125 -0.000	R +0.003	W +0.010 -0.000
SC302	0.375	Side Guide	0.133	...	...	...	0.200	0.410
SC303	0.375	Center Guide	0.133	0.100	...	0.750	0.200	...
SC304	0.375	Center Guide	0.133	0.100	...	1.000	0.200	...
SC305	0.375	Center Guide	0.133	0.100	...	1.250	0.200	...
SC306	0.375	Center Guide	0.133	0.100	...	1.500	0.200	...
SC307	0.375	Center Guide	0.133	0.100	...	1.750	0.200	...
SC308	0.375	Center Guide	0.133	0.100	...	2.000	0.200	...
SC309	0.375	Center Guide	0.133	0.100	...	2.250	0.200	...
SC310	0.375	Center Guide	0.133	0.100	...	2.500	0.200	...
SC312	0.375	Double Guide	0.133	0.100	1.000	3.000	0.200	...
SC316	0.375	Double Guide	0.133	0.100	1.000	4.000	0.200	...
SC320	0.375	Double Guide	0.133	0.100	1.000	5.000	0.200	...
SC324	0.375	Double Guide	0.133	0.100	1.000	6.000	0.200	...
SC402	0.500	Side Guide	0.133	...	...	...	0.200	0.410
SC403	0.500	Center Guide	0.133	0.100	...	0.750	0.200	...
SC404	0.500	Center Guide	0.133	0.100	...	1.000	0.200	...
SC405	0.500	Center Guide	0.133	0.100	...	1.250	0.200	...
SC406	0.500	Center Guide	0.133	0.100	...	1.500	0.200	...
SC407	0.500	Center Guide	0.133	0.100	...	1.750	0.200	...
SC408	0.500	Center Guide	0.133	0.100	...	2.000	0.200	...
SC409	0.500*	Center Guide	0.133	0.100	...	2.250	0.200	...
SC410	0.500	Center Guide	0.133	0.100	...	2.500	0.200	...
SC411	0.500	Center Guide	0.133	0.100	...	2.750	0.200	...
SC412	0.500	Center Guide	0.133	0.100	...	3.000	0.200	...

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TABLE XVII. Sprocket face dimensions, continued.

Chain No.	Chain Pitch	Type	A	C +0.005	D +0.010	F +0.125 -0.000	R +0.003	W +0.010 -0.000
SC414	0.500	Center Guide	0.133	0.100	...	3.500	0.200	...
SC416	0.500	Double Guide	0.133	0.100	1.000	4.000	0.200	...
SC420	0.500	Double Guide	0.133	0.100	1.000	5.000	0.200	...
SC424	0.500	Double Guide	0.133	0.100	1.000	6.000	0.200	...
SC432	0.500	Double Guide	0.133	0.100	1.000	8.000	0.200	...
SC504	0.625	Center Guide	0.177	0.125	...	1.000	0.250	...
SC505	0.625	Center Guide	0.177	0.125	...	1.250	0.250	...
SC506	0.625	Center Guide	0.177	0.125	...	1.500	0.250	...
SC507	0.625	Center Guide	0.177	0.125	...	1.750	0.250	...
SC508	0.625	Center Guide	0.177	0.125	...	2.000	0.250	...
SC510	0.625	Center Guide	0.177	0.125	...	2.500	0.250	...
SC512	0.625	Center Guide	0.177	0.125	...	3.000	0.250	...
SC516	0.625	Center Guide	0.177	0.125	...	4.000	0.250	...
SC520	0.625	Double Guide	0.177	0.125	2.000	5.000	0.250	...
SC524	0.625	Double Guide	0.177	0.125	2.000	6.000	0.250	...
SC528	0.625	Double Guide	0.177	0.125	2.000	7.000	0.250	...
SC532	0.625	Double Guide	0.177	0.125	2.000	8.000	0.250	...
SC540	0.625	Double Guide	0.177	0.125	2.000	10.000	0.250	...
SC604	0.750	Center Guide	0.274	0.180	...	1.000	0.360	...
SC605	0.750	Center Guide	0.274	0.180	...	1.250	0.360	...
SC606	0.750	Center Guide	0.274	0.180	...	1.500	0.360	...
SC608	0.750	Center Guide	0.274	0.180	...	2.000	0.360	...
SC610	0.750	Center Guide	0.274	0.180	...	2.500	0.360	...



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TABLE XVII. Sprocket face dimensions, continued.

Chain No.	Chain Pitch	Type	A	C +0.005	D +0.010	F +0.125 -0.000	R +0.003	W +0.010 -0.000
SC612	0.750	Center Guide	0.274	0.180	...	3.000	0.360	...
SC614	0.750	Center Guide	0.274	0.180	...	3.500	0.360	...
SC616	0.750	Center Guide	0.274	0.180	...	4.000	0.360	...
SC620	0.750	Center Guide	0.274	0.180	...	5.000	0.360	...
SC624	0.750	Center Guide	0.274	0.180	...	6.000	0.360	...
SC628	0.750	Double Guide	0.274	0.180	4.000	7.000	0.360	...
SC632	0.750	Double Guide	0.274	0.180	4.000	8.000	0.360	...
SC636	0.750	Double Guide	0.274	0.180	4.000	9.000	0.360	...
SC640	0.750	Double Guide	0.274	0.180	4.000	10.000	0.360	...
SC648	0.750	Double Guide	0.274	0.180	4.000	12.000	0.360	...
SC808	1.00	Center Guide	0.274	0.180	...	2.000	0.360	...
SC810	1.00	Center Guide	0.274	0.180	...	2.500	0.360	...
SC812	1.00	Center Guide	0.274	0.180	...	3.000	0.360	...
SC816	1.00	Center Guide	0.274	0.180	...	4.000	0.360	...
SC820	1.00	Center Guide	0.274	0.180	...	5.000	0.360	...
SC824	1.00	Center Guide	0.274	0.180	...	6.000	0.360	...
SC828	1.00	Double Guide	0.274	0.180	4.000	7.000	0.360	...
SC832	1.00	Double Guide	0.274	0.180	4.000	8.000	0.360	...
SC836	1.00	Double Guide	0.274	0.180	4.000	9.000	0.360	...
SC840	1.00	Double Guide	0.274	0.180	4.000	10.000	0.360	...
SC848	1.00	Double Guide	0.274	0.180	4.000	12.000	0.360	...
SC856	1.00	Double Guide	0.274	0.180	4.000	14.000	0.360	...
SC864	1.00	Double Guide	0.274	0.180	4.000	16.000	0.360	...

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TABLE XVII. Sprocket face dimensions, continued.

Chain No.	Chain Pitch	Type	A	C +0.005 _	D +0.010 _	F +0.125 -0.000	R +0.003 _	W +0.010 -0.000
SC1010	1.250	Center Guide	0.274	0.180	...	2.500	0.360	...
SC1012	1.250	Center Guide	0.274	0.180	...	3.000	0.360	...
SC1016	1.250	Center Guide	0.274	0.180	...	4.000	0.360	...
SC1020	1.250	Center Guide	0.274	0.180	...	5.000	0.360	...
SC1024	1.250	Center Guide	0.274	0.180	...	6.000	0.360	...
SC1028	1.250	Center Guide	0.274	0.180	...	7.000	0.360	...
SC1032	1.250	Double Guide	0.274	0.180	4.000	8.000	0.360	...
SC1036	1.250	Double Guide	0.274	0.180	4.000	9.000	0.360	...
SC1040	1.250	Double Guide	0.274	0.180	4.000	10.000	0.360	...
SC1048	1.250	Double Guide	0.274	0.180	4.000	12.000	0.360	...
SC1056	1.250	Double Guide	0.274	0.180	4.000	14.000	0.360	...
SC1064	1.250	Double Guide	0.274	0.180	4.000	16.000	0.360	...
SC1072	1.250	Double Guide	0.274	0.180	4.000	18.000	0.360	...
SC1080	1.250	Double Guide	0.274	0.180	4.000	20.000	0.360	...
SC1212	1.500	Center Guide	0.274	0.180	...	3.000	0.360	...
SC1216	1.500	Center Guide	0.274	0.180	...	4.000	0.360	...
SC1220	1.500	Center Guide	0.274	0.180	...	5.000	0.360	...
SC1224	1.500	Center Guide	0.274	0.180	...	6.000	0.360	...
SC1228	1.500	Center Guide	0.274	0.180	...	7.000	0.360	...
SC1232	1.500	Double Guide	0.274	0.180	4.000	8.000	0.360	...
SC1236	1.500	Double Guide	0.274	0.180	4.000	9.000	0.360	...
SC1240	1.500	Double Guide	0.274	0.180	4.000	10.000	0.360	...
SC1248	1.500	Double Guide	0.274	0.180	4.000	12.000	0.360	...
SC1256	1.500	Double Guide	0.274	0.180	4.000	14.000	0.360	...

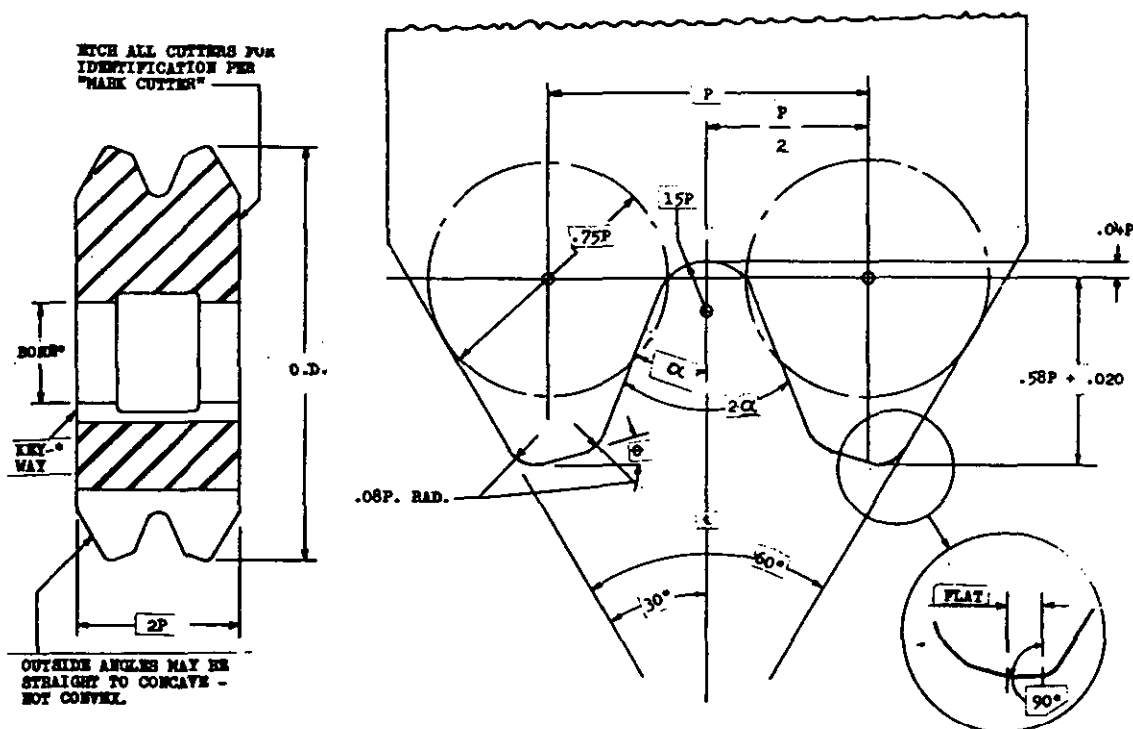
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TABLE XVII. Sprocket face dimensions, continued.

Chain No.	Chain Pitch	Type	A	C +0.005	D +0.010	F +0.125 -0.000	R +0.003	W +0.010 -0.000
SC1264	1.500	Double Guide	0.274	0.180	4.000	16.000	0.360	...
SC1272	1.500	Double Guide	0.274	0.180	4.000	18.000	0.360	...
SC1280	1.500	Double Guide	0.274	0.180	4.000	20.000	0.360	...
SC1288	1.500	Double Guide	0.274	0.180	4.000	22.000	0.360	...
SC1296	1.500	Double Guide	0.274	0.180	4.000	24.000	0.360	...
SC1616	2.00	Center Guide	0.274	0.218	...	4.000	0.360	...
SC1620	2.00	Center Guide	0.274	0.218	...	5.000	0.360	...
SC1624	2.00	Center Guide	0.274	0.218	...	6.000	0.360	...
SC1628	2.00	Center Guide	0.274	0.218	...	7.000	0.360	...
SC1632	2.00	Double Guide	0.274	0.218	4.000	8.000	0.360	...
SC1640	2.00	Double Guide	0.274	0.218	4.000	10.000	0.360	...
SC1648	2.00	Double Guide	0.274	0.218	4.000	12.000	0.360	...
SC1656	2.00	Double Guide	0.274	0.218	4.000	14.000	0.360	...
SC1664	2.00	Double Guide	0.274	0.218	4.000	16.000	0.360	...
SC1672	2.00	Double Guide	0.274	0.218	4.000	18.000	0.360	...
SC1680	2.00	Double Guide	0.274	0.218	4.000	20.000	0.360	...
SC1688	2.00	Double Guide	0.274	0.218	4.000	22.000	0.360	...
SC1696	2.00	Double Guide	0.274	0.218	4.000	24.000	0.360	...
SC16120	2.00	Double Guide	0.274	0.218	4.000	30.000	0.360	...

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## 7. ANSI Standard inverted tooth (silent) chain sprocket cutter design.

FIGURE 37. Cutter form.TABLE XVIII. Cutter data.

Chain Pitch P	Mark * Cutter	Outside Dia.	.75P	$\alpha$	$\phi$	Bore**
0.375	SC3-15 thru 35 SC3-36 up	3.625	0.2813	22°-30' 27°-30'	12° 5°	1.250
0.500	SC4-15 thru 35 SC4-36 up	3.875	0.3750	22°-30' 27°-30'	12° 5°	1.250

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TABLE XVIII. Cutter data, continued.

Chain Pitch P	Mark * Cutter	Outside Dia.	.75P			Bore**
0.625	SC5-15 thru 35 SC5-36 up	4.250	0.4688	22°-30' 27°-30'	12° 5°	1.250
0.750	SC6-15 thru 35 SC6-36 up	4.625	0.5625	22°-30' 27°-30'	12° 5°	1.250
1.000	SC8-15 thru 35 SC8-36 up	5.250	0.7500	22°-30' 27°-30'	12° 5°	1.500
1.250	SC10-15 thru 35 SC10-36 up	5.750	0.9375	22°-30' 27°-30'	12° 5°	1.500
1.500	SC12-15 thru 35 SC12-36 up	6.250	1.1250	22°-30' 27°-30'	12° 5°	1.750
2.000	SC16-15 thru 35 SC16-36 up	6.500	1.5000	22°-30' 27°-30'	12° 5°	1.750

\* Range of teeth is indicated in the cutter marking.

\*\* Bores other than standard must be specified.

TABLE XIX. Generating data.

Chain Pitch	Hob Number	Basic Number of Teeth	Tooth Range of Hob	Generating Diameter
SC3 = .375	1	20	17 - 23	2.311
	2	28	24 - 32	3.247
	3	38	33 - 43	4.428
	4	51	44 - 58	5.971
	5	69	59 - 79	8.114
	6	95	80 - 110	11.212
	7	130	111 - 150	15.385

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TABLE XIX. Generating data, continued.

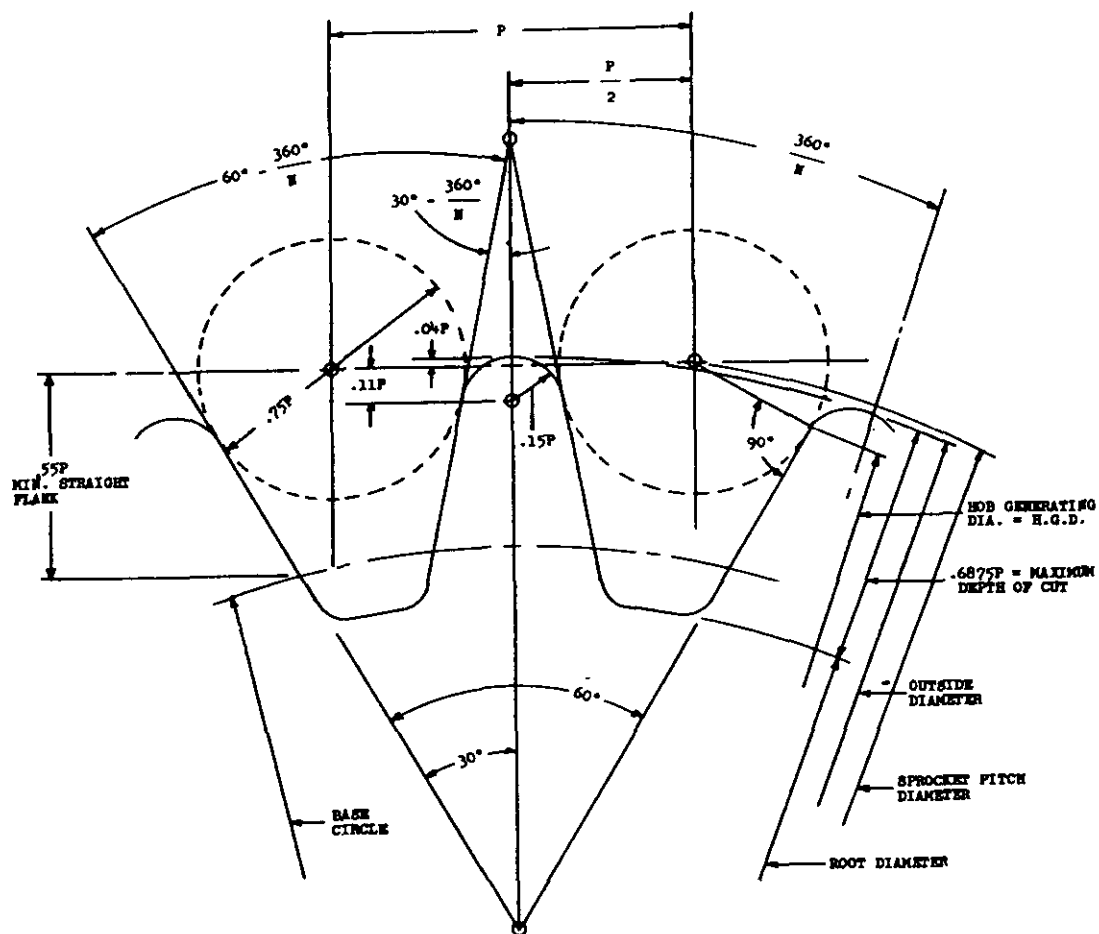
Chain Pitch	Hob Number	Basic Number of Teeth	Tooth Range of Hob	Generating Diameter
SC4 = .500	1	20	17 - 23	3.082
	2	28	24 - 32	4.329
	3	38	33 - 43	5.904
	4	51	44 - 58	7.962
	5	69	59 - 79	10.818
	6	95	80 - 110	14.950
	7	130	111 - 150	20.513
SC5 = .625	1	20	17 - 23	3.852
	2	28	24 - 32	5.412
	3	38	33 - 43	7.381
	4	51	44 - 58	9.952
	5	69	59 - 79	13.522
	6	95	80 - 110	18.687
	7	130	111 - 150	25.641
SC6 = .750	1	20	17 - 23	4.623
	2	28	24 - 32	6.494
	3	38	33 - 43	8.857
	4	51	44 - 58	11.943
	5	69	59 - 79	16.227
	6	95	80 - 110	22.424
	7	130	111 - 150	30.770
SC8 = 1.000	1	20	17 - 23	6.163
	2	28	24 - 32	8.659
	3	38	33 - 43	11.809
	4	51	44 - 58	15.924
	5	69	59 - 79	21.636
	6	95	80 - 110	29.899
	7	130	111 - 150	41.026
SC10 = 1.250	1	20	17 - 23	7.704
	2	28	24 - 32	10.823
	3	38	33 - 43	14.761
	4	51	44 - 58	19.905
	5	69	59 - 79	27.045
	6	95	80 - 110	37.374
	7	130	111 - 150	51.283

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TABLE XIX. Generating data, continued.

Chain Pitch	Hob Number	Basic Number of Teeth	Tooth Range of Hob	Generating Diameter
SC12 = 1.500	1	20	17 - 23	9.245
	2	28	24 - 32	12.988
	3	38	33 - 43	17.713
	4	51	44 - 58	23.886
	5	69	59 - 79	32.454
	6	95	80 - 110	44.849
	7	130	111 - 150	61.539
SC16 = 2.000	1	20	17 - 23	12.327
	2	28	24 - 32	17.317
	3	38	33 - 43	23.618
	4	51	44 - 58	31.848
	5	69	59 - 79	43.272
	6	95	80 - 110	59.798
	7	130	111 - 150	82.052

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P = Chain Pitch

N = Number Teeth

$$HGD = P \sqrt{\frac{1}{\sin^2 \frac{180^\circ}{N}} + .5625 - \frac{1.5 \sin (30 - \frac{180}{N})^\circ}{\sin \frac{180^\circ}{N}}}$$

FIGURE 38. HOB generating criteria.



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ALL HOBS MUST BE ETCHED FOR  
IDENTIFICATION AS SHOWN IN THE EXAMPLES

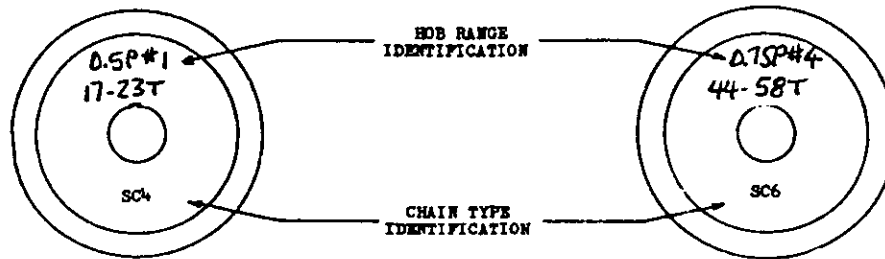


FIGURE 39. HOB identification.

8. ANSI Standard roller chain sprocket cutter designs.

Three kinds of sprocket cutters are used in cutting sprocket teeth for ANSI chains B29.1, B29.3 and B29.4, namely:

- a. SPACE CUTTERS, of which five will be required to cut from 7 teeth up for any given roller diameter. The ranges are respectively 7-8 teeth, 9-11 teeth, 12-17 teeth, 18-34 teeth, 35 teeth and over. Single-purpose cutters of this type are necessary for fewer than 7 teeth.
- b. HOBS, of which only one will be required, if non-topping, to cut any number of teeth for a given pitch and roller diameter. Refer to cutter manufacturer for cutter form.
- c. FELLOWS CUTTERS, for use on the Fellows gear shaper, of which only one will be required, if non-topping, to cut 12 teeth and over for a given pitch and roller diameter. When sprockets of less than 12 teeth are to be produced on Fellows equipment consult the cutter manufacturer.

a. Standard space cutter design.

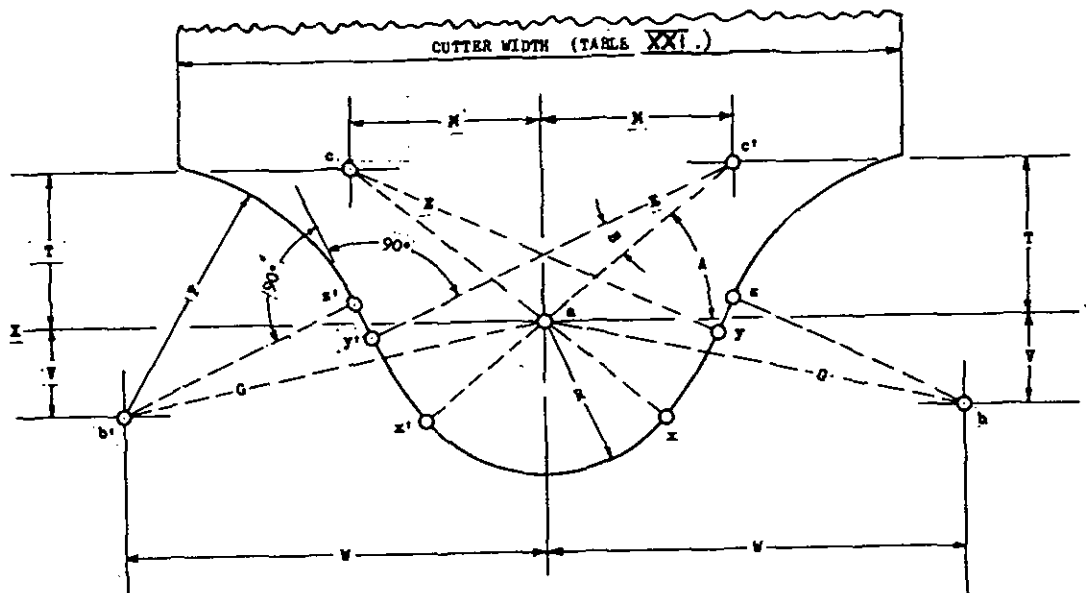
Space cutters are made for the following ranges of teeth: 7-8, 9-11, 12-17, 18-34, 35 and over. The lowest number of teeth in any group is designated by  $N_1$  and the highest by  $N_2$ .

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The cutters are based on an intermediate number of teeth,  $N_a$  equal to  $2N_1 (N_2)$  divided by  $(N_1 + N_2)$ : but the topping curve radius ( $F$ ) is designed to produce adequate tooth height on a sprocket of  $N_2$  teeth with

$$OD = P(0.7 + \cot \frac{180^\circ}{N_2}).$$

The values of  $N_a$  for the several cutters are 7.47, 9.9, 14.07, 23.54 and 56.



NOTE:  $D_r = D$  = Roller Diameter

CONSTRUCTION REFERENCE: TABLES I AND XX.

FIGURE 40. Space cutter layout.

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The angle  $Y_{ab}$  is  $180^\circ/N$  when the cutter is made for a specific number of teeth, but it has values (determined by layout of a sprocket of  $N_2$  teeth with

$$OD = P(0.7 = \cot \frac{180^\circ}{N_2}), \text{ as given in Table XX for cutters}$$

covering a range of teeth as here designed. The following formulas are special for cutters covering the standard ranges of teeth ( $N_a$  = intermediate values from above):

$$W = 1.4D_r \cos Y_{ab}; \quad V = 1.4D_r \sin Y_{ab}.$$

$$yz = D_r \left[ 1.4 \sin \left( 17^\circ + \frac{116^\circ}{N_a} - Y_{ab} \right) - 0.8 \sin \left( 18^\circ - \frac{56^\circ}{N_a} \right) \right]$$

$$F = D_r \left[ 0.8 \cos \left( 18^\circ - \frac{56^\circ}{N_a} \right) - 1.4 \cos \left( 17^\circ + \frac{116^\circ}{N_a} - Y_{ab} \right) - 1.3025 \right] - 0.0015.$$

For other points use the value of  $N_a$  for  $N$  in the standard formulas for Standard tooth form (refer to tables XXI and XXII as needed.)

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TABLE XX. Construction data for space cutter layout.

Teeth Range	M	T	W	V	F	Chord xy	yz	Angle Yab
7-8	0.5848D <sub>r</sub>	0.5459D <sub>r</sub>	1.2790D <sub>r</sub>	0.5694D <sub>r</sub>	0.8686D <sub>r</sub> -0.0015	0.2384D <sub>r</sub> +0.0003	0.0618D <sub>r</sub>	24°
9-11	0.6032D <sub>r</sub>	0.5255D <sub>r</sub>	1.3302D <sub>r</sub>	0.4365D <sub>r</sub>	0.8554D <sub>r</sub> -0.0015	0.28D <sub>r</sub> +0.0003	0.0853D <sub>r</sub>	18° 10'
12-27	0.6194D <sub>r</sub>	0.5063D <sub>r</sub>	1.3694D <sub>r</sub>	0.2911D <sub>r</sub>	0.8364D <sub>r</sub> -0.0015	0.3181D <sub>r</sub> +0.0004	0.1269D <sub>r</sub>	12°
18-34	0.6343D <sub>r</sub>	0.4875D <sub>r</sub>	1.3947D <sub>r</sub>	0.1220D <sub>r</sub>	0.8073D <sub>r</sub> -0.0015	0.354D <sub>r</sub> +0.0004	0.1922D <sub>r</sub>	5°
35 up	0.6466D <sub>r</sub>	0.4710D <sub>r</sub>	1.4000D <sub>r</sub>	0	0.7857D <sub>r</sub> -0.0015	0.385D <sub>r</sub> +0.0004	0.2235D <sub>r</sub>	0°

E (same for all ranges) = 1.3025 D<sub>r</sub> + 0.0015.G (same for all ranges) = 1.4 D<sub>r</sub>.

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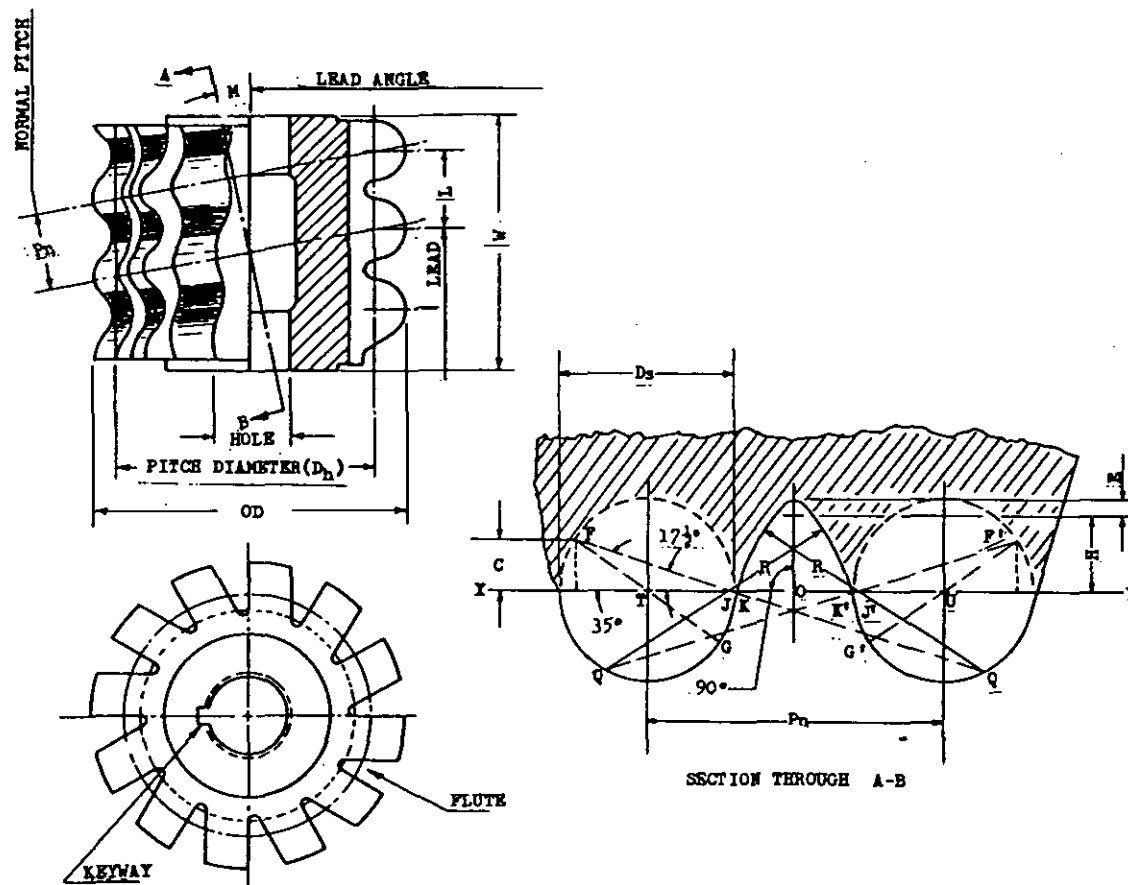
TABLE XXI. Recommended space cutter sizes for roller chain sprockets.

Chain Pitch	Roll Diam.	Cutter Diameter					Cutter Width					Dia. of Hole		
		6T	7-8T	9-11T	12-17T	18-34T	35+T	6T	7-8T	9-11T	12-17T		18-34T	35+T
0.250	0.130	2.750	2.750	2.750	2.750	2.750	2.750	0.312	0.312	0.312	0.312	0.281	0.281	1---
0.375	0.200	2.750	2.750	2.750	2.750	2.750	2.750	0.469	0.469	0.469	0.438	0.438	0.406	1---
0.500	0.313	3---	3---	3.125	3.125	3.125	3.125	0.750	0.750	0.750	0.750	0.438	0.406	1---
0.625	0.400	3.125	3.125	3.250	3.250	3.250	3.250	0.750	0.750	0.750	0.750	0.718	0.406	1---
0.750	0.469	3.250	3.250	3.375	3.375	3.375	3.375	0.906	0.906	0.906	0.875	0.844	0.813	1---
1---	0.625	3.875	4---	4.125	4.125	4.250	4.250	1.500	1.500	1.469	1.469	1.406	1.344	1.250
1.250	0.750	4.250	4.375	4.500	4.500	4.625	4.625	1.813	1.813	1.781	1.750	1.688	1.625	1.250
1.500	0.875	4.375	4.500	4.625	4.625	4.750	4.750	1.813	1.813	1.781	1.750	1.688	1.625	1.250
1.750	1.000	5---	5.125	5.250	5.375	5.500	5.500	2.094	2.094	2.063	2.031	1.969	1.875	1.500
2---	1.125	5.375	5.500	5.625	5.750	5.875	5.875	2.406	2.406	2.375	2.313	2.250	2.156	1.500
2.250	1.406	5.875	6---	6.250	6.375	6.500	6.500	2.688	2.688	2.656	2.594	2.469	2.406	1.500
2.500	1.563	6.375	6.625	6.750	6.875	7---	7.125	3---	3---	2.938	2.906	2.750	2.688	1.750
3---	1.875	7.500	7.750	7.875	8---	8---	8.250	3.594	3.594	3.531	3.469	3.343	3.219	2---

TABLE XXII. Roller chain sprocket hobs.

CHAIN		HOB (RECOMMENDED DIMENSIONS)										No. of Flutes
		No.	Pitch	Roller Diam.	Hob Pitch (Pn)	H	E	Outside Dia. (OD)	Width W	Bore	Keyway	
25	0.250	0.130	0.2527	0.0675	0.0075	2.625	2.500	1.250	.250 x .125	13		
35	0.375	0.200	0.379	0.101	0.012	3.125	2.500	1.250	.250 x .125	13		
40	0.500	0.313	0.506	0.135	0.015	3.375	2.500	1.250	.250 x .125	12		
50	0.625	0.400	0.632	0.170	0.018	3.625	2.500	1.250	.250 x .125	12		
60	0.750	0.469	0.759	0.202	0.023	3.750	2.875	1.250	.250 x .125	11		
80	1.000	0.625	1.011	0.270	0.030	4.375	3.750	1.250	.250 x .125	11		
100	1.250	0.750	1.264	0.337	0.038	4.750	4.500	1.250	.250 x .125	10		
120	1.500	0.875	1.517	0.405	0.046	5.375	5.250	1.250	.250 x .125	10		
140	1.750	1.000	1.770	0.472	0.053	6.375	6.000	1.500	.375 x .1875	9		
160	2.000	1.125	2.022	0.540	0.060	6.875	6.750	1.500	.375 x .1875	9		
180	2.250	1.406	2.275	0.607	0.068	8.000	8.500	1.750	.375 x .1875	8		
200	2.500	1.563	2.528	0.675	0.075	8.625	9.375	1.750	.375 x .1875	8		
240	3.000	1.875	3.033	0.810	0.090	9.750	11.250	2.000	.500 x .1875	8		

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FIGURE 41. Hob outline (reference tables I and XXII).b. Recommended hob design for roller chain sprockets.

Hobs designed for a given roller diameter ( $D_r$ ) and chain pitch ( $P$ ) will cut any number of teeth.

$P$  = Chain Pitch     $P_n$  = Normal Pitch of Hob =  $1.011 P$ .

$D_s$  = Minimum Diameter of Seating Curve =  $1.005 D_r = 0.003$ .

$F$  = Radius Center for Arc GK;     $TO = OU = \frac{P_n}{2}$

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$I = 0.27P$ ;       $E = 0.03P = \text{Radius of Fillet Circle}$

Q is located on line passing thru F and J.      Point J is intersection of line XY with circle of diameter  $D_s$ .

R is found by trial and is tangent to arc KG at K and to fillet radius.

OD is  $1.7 (\text{Bore} + D_r + 0.7 P)$  approximately.

$$D_h = OD - D_s; \quad M = \sin^{-1} \frac{P_n}{\pi D_h}; \quad L = \frac{P_n}{\cos M}$$

W = Not less than  $2 \times \text{bore}$ , or  $6 D_r$ , or  $3.2 P$ .

(Marking of Hobs: All hobs are to be marked with chain pitch, roller diameter, lead angle, and flute lead.)

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TABLE XXIII. Minus tolerances on the bottom or caliber diameters of sprockets (there are no plus tolerances).

Grade	Chain Pitch	Thru 15T	16-24 T	25-35 T	36-48 T	49-63 T	64-80 T	81-99 T	100-120 T	121-143 T	144 & Up T
A & B	0.25	0.004	0.004	0.004	0.005	0.005	0.005	0.005	0.006	0.006	0.006
A & B	0.375	0.004	0.004	0.004	0.005	0.005	0.006	0.006	0.006	0.007	0.007
A & B	0.500	0.004	0.005	0.0055	0.006	0.0065	0.007	0.0075	0.008	0.0085	0.009
A & B	0.675	0.005	0.0055	0.006	0.007	0.008	0.009	0.009	0.009	0.010	0.011
A & B	0.750	0.005	0.006	0.007	0.008	0.009	0.010	0.010	0.011	0.012	0.013
A & B	1.000	0.006	0.007	0.008	0.009	0.010	0.011	0.012	0.013	0.014	0.015
A & B	1.250	0.007	0.008	0.009	0.010	0.012	0.013	0.014	0.016	0.017	0.018
A & B	1.500	0.007	0.009	0.0105	0.012	0.013	0.015	0.016	0.018	0.019	0.021
C	1.500	0.093	0.093	0.093	0.093	0.125	-	-	-	-	-
C	1.654	0.093	0.093	0.093	0.093	0.125	-	-	-	-	-
A & B	1.750	0.008	0.010	0.012	0.013	0.015	0.017	0.019	0.020	0.022	0.024
C	1.750	0.093	0.093	0.093	0.125	0.125	-	-	-	-	-
A & B	2.000	0.009	0.011	0.013	0.015	0.017	0.019	0.021	0.023	0.025	0.027
C	2.000	0.093	0.093	0.093	0.125	0.125	0.187	0.187	-	-	-
A & B	2.500	0.010	0.013	0.015	0.018	0.020	0.023	0.025	0.028	0.030	0.033
C	2.500	0.093	0.093	0.125	0.125	0.187	0.187	0.187	-	-	-
C	2.609	0.093	0.093	0.125	0.125	0.187	-	-	-	-	-
A & B	3.000	0.012	0.015	0.018	0.021	0.024	0.027	0.030	0.033	0.036	0.039
C	3.067	0.093	0.093	0.125	0.187	0.187	0.187	0.250	-	-	-
C	3.075	0.093	0.093	0.125	0.187	0.187	-	-	-	-	-
C	3.500	0.093	0.125	0.125	0.187	0.187	-	-	-	-	-
C	4.063	0.093	0.125	0.125	0.187	0.187	-	-	-	-	-



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TABLE XXIII. Minus tolerances on the bottom or caliper diameters of sprockets (there are no plus tolerances), continued.

Grade	Chain Pitch	Thru 15T	16-24 T	25-35 T	36-48 T	49-63 T	64-80 T	81-99 T	100-120 T	121-143 T	144 & Up T
C	4.073	0.093	0.125	0.125	0.187	0.187	-	-	-	-	-
C	4.500	0.093	0.125	0.187	0.187	0.187	-	-	-	-	-
C	5.000	0.093	0.125	0.187	0.187	0.250	-	-	-	-	-
C	6.000	0.125	0.187	0.187	0.250	0.250	-	-	-	-	-
C	7.000	0.125	0.187	0.187	0.250	0.312	-	-	-	-	-

Grade A: Precision sprockets with machine finished tooth forms and tooth profiles.

Grade B: Precision sprockets with machine finished tooth forms, but unmachined tooth profiles.

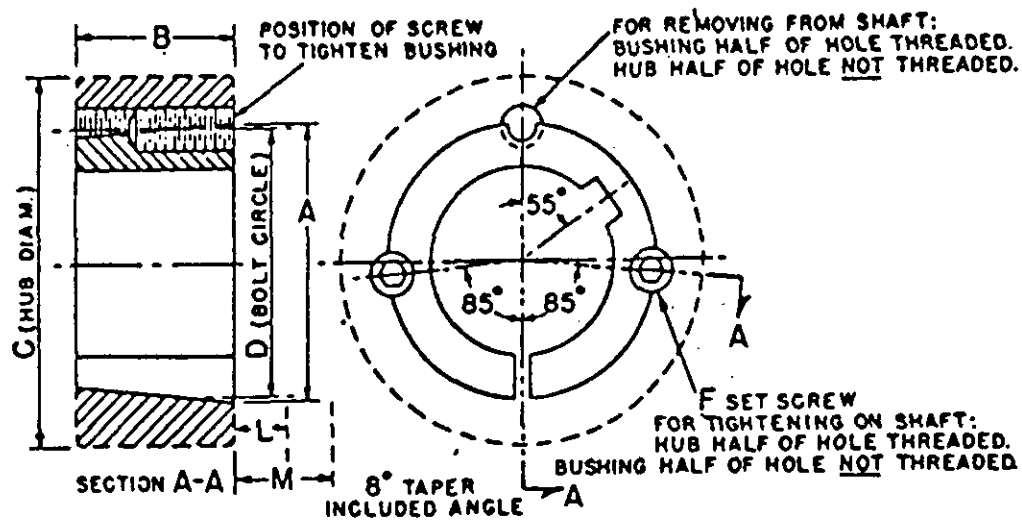
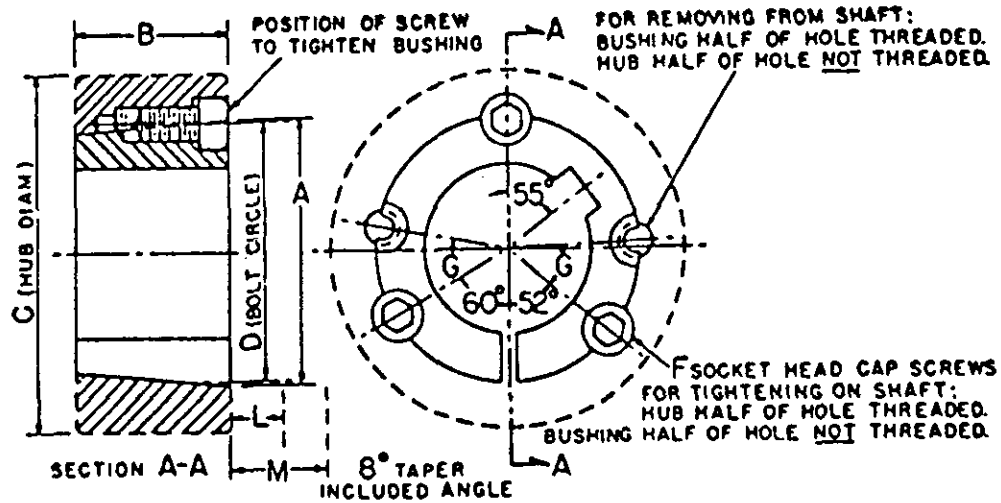
Grade C: Semi-precision sprockets with tooth form and tooth profile as cast, forged, flame-cut or rolled.

NOTE: For sprockets operating in environments in which foreign material tends to accumulate in the tooth pocket, such as propel drives on power shovels, the bottom diameters are frequently reduced by varying amounts to offset such material buildup. This reduction seldom exceeds 0.25 x chain pitch plus 0.005 x bottom diameter. This reduction is in addition to that obtained by using the above standard tolerances.

Allowance for foreign material buildup and its removal may also be accomplished by gashing the tooth pocket.

When either method is desired, the method should be specified on orders to manufacturers for sprockets.

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FIGURE 42. Taper-lock bushing (reference tables XXIV and XXV.)FIGURE 43. Taper-lock bushing (reference table XXVI.)

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TABLE XXIV. No. 1008 to 1615 taperlock bushings.

Bushing Number	Available Bore	A	B	Cast Iron	C (6)	Steel	D	F (3)	Bushing Keyseat	Shaft Keyseat	Wt. Lbs.	L (4) Std. Hex Key	Short Key (2)	M (5) Std. Hex Key	Short Key (2)
1008	0.500 to 0.5425 0.625 to 0.875 0.938 to 1.000	1.386	0.875	2.375	2.188	1.938	1.328	0.250 x 0.500	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.27 0.21 0.16	1.125	0.625	1.250	0.750
1108	0.500 to 0.563 0.625 to 0.875 0.938 to 1.000	1.511	0.875	2.500	2.313	2.063	1.433	0.250 x 0.500	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.33 0.27 0.22	1.125	0.625	1.250	0.750
1210	0.500 to 0.563 0.625 to 0.875 0.938 to 1.000	1.875	1.000	3.625	3.250	2.875	1.750	0.375 x 0.625	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.61 0.55 0.49	1.375	0.813	1.625	1.063
1215	0.500 to 0.563 0.625 to 0.875 0.938 to 1.000	1.875	1.500	3.125	2.875	2.625	1.750	0.375 x 0.625	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.80 0.70 0.60	1.375	0.813	1.625	1.063
1310	0.500 to 0.563 0.625 to 0.875 0.938 to 1.000	2.000	1.000	3.750	3.375	3.000	1.875	0.375 x 0.625	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.7 0.6 0.6	1.375	0.813	1.625	1.063
1410	0.500 to 0.563 0.625 to 0.875 0.938 to 1.000	2.250	1.000	4.000	3.625	3.250	2.125	0.125 x 0.625	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.9 0.8 0.7	1.375	0.813	1.625	1.063
1615	0.500 to 0.563 0.625 to 0.875 0.938 to 1.000	2.250	1.500	3.500	3.250	3.000	2.125	0.375 x 0.625	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	0.125 x 0.063 0.188 x 0.094 0.250 x 0.125	1.2 1.1 1.0	1.375	0.813	1.625	1.063

- (1) Key furnished for these sizes only.  
 (2) Standard hex key cut to minimum usable length.  
 (3) 2 or 3 screws depending upon bushing used. Use in positions shown for tightening bushing on shaft. In removing bushing from shaft, remove screws and use them in the other holes.  
 (4) Space required to tighten bushing. Also space required to loosen screws to permit removal of hub by puller.  
 (5) Space required to remove bushing using the screws as jackscrews - no puller required.  
 (6) For general reference. Severe conditions may require larger hub. Heavy well located web may permit smaller hub. Hub diameter required depends upon the particular application. Hub diameters shown are based on 20,000, 30,000 and 50,000 lb/in<sup>2</sup> minimum ultimate tensile strength respectively for cast iron, semi-steel and steel hubs.

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TABLE XXV. No. 2012 to 5050 taper-lock bushings.

Bushing Number	Available Bore	A	B	Cast Iron	Semi-Steel	C (6)	Steel	D	F (3)	Bushing Keyseat	Shaft Keyseat	Wt. Lbs.	L (4) Std. Hex Key (2)	Short Key (2)	M (5) Std. Hex Key	G
2012	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	1.7				
	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	1.6				
	0.938 to 1.250	2.750	1.250	4.750	4.375	3.875	2.625	0.438 x 0.875		0.250 x 0.125	0.250 x 0.125	1.5	1.563	0.938	2----	1.375
	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	1.4				
	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	1.2				
2517	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	1.0				
	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	1.0				
	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	3.5				
	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	3.4				
	0.938 to 1.250	3.375	1.750	5.500	4.875	4.375	3.250	0.500 x 1.00		0.250 x 0.125	0.250 x 0.125	3.3	1.625	1----	2.250	1.625
2525	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	3.2				
	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	3.0				
	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	2.4				
	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	2.4				
	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	1.9				
3020	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	4.9				
	0.938 to 1.250	3.375	2.500	4.750	4.500	4.250	3.250	0.500 x 1.00		0.250 x 0.125	0.250 x 0.125	4.7	1.625	1----	2.250	1.625
	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	4.5				
	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	4.2				
	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	3.3				
3030	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	2.5				
	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	6.5				
	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	6.3				
	0.938 to 1.250	4.250	2----	7----	6.250	5.625	4----	0.625 x 1.250		0.250 x 0.125	0.250 x 0.125	6.0	1.813	1.188	2.688	2.063
	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	5.3				
3030	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	4.5				
	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	3.3				
	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	3.3				
	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	9.2				
	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	8.9				
3535	0.938 to 1.250	4.250	3----	6.250	5.750	5.375	4----	0.625 x 1.250		0.250 x 0.125	0.250 x 0.125	8.6	1.813	1.188	2.688	2.063
	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	7.6				
	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	6.2				
	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	5.0				
	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	5.0				
4040	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	14				
	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	14				
	0.938 to 1.250	5----	3.500	7.750	7----	6.500	4.830	0.500 x 1.500		0.250 x 0.125	0.250 x 0.125	13	2----	1.313	3.375	2.688
	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	12				
	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	11				
4040	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	9				
	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	8				
	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	22				
	0.525 to 0.875									0.188 x 0.094	0.188 x 0.094	21				
	0.938 to 1.250	5.750	4----	9.500	8.500	7.750	5.540	0.625 x 1.750		0.250 x 0.125	0.250 x 0.125	19	2.375	1.625	4.125	3.375
4040	1.313 to 1.375									0.313 x 0.156	0.313 x 0.156	17				
	1.438 to 1.750									0.375 x 0.188	0.375 x 0.188	15				
	1.813 to 1.875									0.500 x 0.250	0.500 x 0.250	14				
	1.938 to 2----									0.500 x 0.250	0.500 x 0.250	14				
	0.500 to 0.513									0.125 x 0.063	0.125 x 0.063	13				

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TABLE XXV. No. 2012 to 5050 taper-lock bushings, continued.

Bushing Number	Available Bore	A	B	Cast Iron	C(6) Semi-Steel	Steel	D	F(3)	Bushing Keyseat	Shaft Keyseat	Wt. Lbs.	L(4) Std. Hex Key (2)	Short Key (2)	M(5) Std. Hex Key	Short Key (2)	G
4545	1.938 to 2.250								0.500 x 0.250	0.500 x 0.250	30					
	2.313 to 2.750								0.625 x 0.313	0.625 x 0.313	28					
	2.813 to 3.250	6.375	4.500	10.500	9.500	8.750	6.130	0.750 x 2.250	0.750 x 0.375	0.750 x 0.375	26	2.625	1.938	4.750	4.063	40
	3.313 to 3.750								0.875 x 0.438	0.875 x 0.438	23					(1)
	3.813 to 4.250								1.250 x 0.500	1.250 x 0.500	20					
5050	4.063 to 4.500								1.250 x 0.500	1.250 x 0.500	18					
	4.563 to 5.000								0.625 x 0.313	0.625 x 0.313	38					
	5.063 to 5.500								0.750 x 0.375	0.750 x 0.375	35					
	5.563 to 6.000	7.500	5.500	11.500	10.500	9.500	6.720	0.875 x 2.250	0.875 x 0.438	0.875 x 0.438	32	2.813	2.313	5.250	4.813	37
	6.063 to 6.500								1.250 x 0.500	1.250 x 0.500	27					(1)
	6.563 to 7.000								1.250 x 0.625	1.250 x 0.625	24					

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TABLE XXVI. Slipping torque capacity of taper-lock bushings.

Bushing No.	Recommended Wrench Torque on Bushing Screws (Pound-Inches)	Shaft Diameter (Inches)	Average* Slipping Torque on Shafting Without Shaft Key (Pd-Ins)
1008	55	0.500	260
		0.750	450
		1.000	630
1108	55	0.500	250
		0.750	430
		1.125	710
1210 & 1215	175	0.625	730
		0.938	1240
		1.250	1750
1310	175	0.750	730
		0.938	1210
		1.375	1920
1610 & 1615	175	0.750	840
		1.188	1570
		1.625	2270
2012	280	1.000	1600
		1.438	2540
		1.938	3630
2517 & 2525	430	1.188	2360-
		1.938	4480
		2.438	6050
3020 & 3030	800	1.438	4520
		2.188	8020
		2.938	11300
3535	1000	1.688	9050
		2.438	17200
		3.438	22600
4040	1700	1.938	15600
		2.938	27800
		3.938	39100
4545	2450	2.188	22600
		3.438	41800
		4.438	56500
5050	3100	2.438	26200
		3.938	50800
		4.938	65500

\* Average values were based on tests with bushings installed per standard installation instructions.

When using this data for design purposes reducing factors should be applied depending on operating conditions.

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c. Sprocket selection. Tables XXVII and XXVIII may be used as a guide in the selection of sprockets with reference to environmental conditions, loading, chain speed in feet per minute and number of teeth on the sprocket.

TABLE XXVII. Precision sprockets.

Class of Service	Chain Speed in FPM	Number of Teeth on Sprocket	Material	Hardness of Tooth Face	Hardness of Body
Normal Operation; Uniform Load; Minor Shock	Up to 600	25 or less	Steel	131 BHN Min.	131 BHN Min.
		26 and up	Steel Iron	131 BHN Min. 149 BHN Min.	131 BHN Min. 149 BHN Min.
	600 to 3000	25 or less	Steel	R <sub>C</sub> 40 Min.	131 BHN Min.
		26 and up	Steel Iron	131 BHN Min. 149 BHN Min.	131 BHN Min. 149 BHN Min.
	Over 3000	25 or less	Steel	R <sub>C</sub> 40 Min.	131 BHN Min.
		26 and up	Steel Iron	R <sub>C</sub> 40 Min. R <sub>C</sub> 40 Min.	131 BHN Min. 170 BHN Min.
Severe Operation; Peak Loads; Major Shock	Up to 600	25 or less	Steel	R <sub>C</sub> 40 Min.	131 BHN Min.
		26 and up	Steel	R <sub>C</sub> 40 Min.	131 BHN Min.
	600 and over	25 or less	Steel	R <sub>C</sub> 40 Min.	131 BHN Min.
		26 and up	Steel	R <sub>C</sub> 40 Min.	131 BHN Min.

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TABLE XXVIII. Semi-precision sprockets.

Class of Service	Chain Speed in FPM	Number of Teeth on Sprocket	Material	Hardness of Tooth Face	Hardness of Body
Normal Duty (Steady Load & Relatively Clean)	Up to 100	15 or less	Iron Steel	BHN, Min 321 321	BHN, Min 131 131
		16 and up	Iron Steel	149 131	149 131
	101 to 250	15 or less	Iron Steel	321 321	131 131
		16 and up	Iron Steel	170 170	131 131
	251 to 1000	15 or less	Iron Steel	321 321	131 131
		16 and up	Iron Steel	207 207	131 131
Heavy Duty (Fluctuating Loads & Dusty & Dirty)	Up to 100	15 or less	Steel	321	269
		16 and up	Steel	321	269
	101 to 250	15 or less	Steel	415	269
		16 and up	Steel	321	269
	251 to 1000	15 or less	Steel	477	269
		16 and up	Steel	321	269

TABLE XXIX. Tolerances allowed on outside diameter of sprockets.

Grade	Description	Tolerances
A	Precision, cut-tooth	$\pm 0.031$ inch
B	Precision, cut-tooth	$\pm 0.031$ inch
C	Semi-precision, cast, forged, flame cut or rolled	$\pm 0.125$ inch



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## 6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Intended use. This design standard describes the various tooth forms for sprockets used with power transmissions and conveyor chains used by the military.

6.2 Issue of DODISS. When this standard is used in acquisition, the applicable issue of the DODISS must be cited in the solicitation (see 2.1).

6.3 Liability disclaimer. When Government drawings, specifications, or other data are used for any purpose other than in connection with a Government procurement, the United States Government incurs no responsibility nor any obligation whatsoever.

6.4 Metriation. Metric equivalents in accordance with FED-STD-376 are acceptable for use in this standard.

6.5 Subject term (keyword) listing.

Connecting links  
Gears, toothed  
Rollers, steel

6.6 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodian:

Army - MI  
Air Force - 99  
Navy - YD

Preparing activity:

Army - MI

Project No. 3020-0122

Review activity:

Air Force - 82

User activities:

Navy - MC, SH

# STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

## INSTRUCTIONS

1. The preparing activity must complete blocks 1, 2, 3, and 8. In block 1, both the document number and revision letter should be given.
2. The submitter of this form must complete blocks 4, 5, 6, and 7.
3. The preparing activity must provide a reply within 30 days from receipt of the form.

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<b>I RECOMMEND A CHANGE:</b>		<b>1. DOCUMENT NUMBER</b> MIL-STD-627A	<b>2. DOCUMENT DATE (YYMMDD)</b> 920911
<b>3. DOCUMENT TITLE</b> SPROCKET WHEELS FOR POWER TRANSMISSION AND CONVEYING CHAINS			
<b>4. NATURE OF CHANGE</b> (Identify paragraph number and include proposed rewrite, if possible. Attach extra sheets as needed.)			
<b>5. REASON FOR RECOMMENDATION</b>			
<b>6. SUBMITTER</b>			
<b>a. NAME</b> (Last, First, Middle Initial)		<b>b. ORGANIZATION</b>	
<b>c. ADDRESS</b> (Include Zip Code)		<b>d. TELEPHONE</b> (Include Area Code) (1) Commercial (2) AUTOVON (If applicable)	<b>7. DATE SUBMITTED</b> (YYMMDD)
<b>8. PREPARING ACTIVITY</b>			
<b>a. NAME</b> COMMANDER U.S. ARMY MISSILE COMMAND ATTN: AMSMI-RD-SE-TD-ST		<b>b. TELEPHONE</b> (Include Area Code) (1) Commercial (2) AUTOVON (205) 876-6980 746-6980	
<b>c. ADDRESS</b> (Include Zip Code) REDSTONE ARSENAL, AL 35898-5270		<b>IF YOU DO NOT RECEIVE A REPLY WITHIN 45 DAYS, CONTACT:</b> Defense Quality and Standardization Office 5203 Leesburg Pike, Suite 1403, Falls Church, VA 22041-3466 Telephone (703) 756-2340 AUTOVON 289-2340	