

# **TSUBAKI** **Screw Lock Link™** Connecting Links for Large Size Conveyor Chain



Reduce chain maintenance time.

# Screw Lock Link™ allows

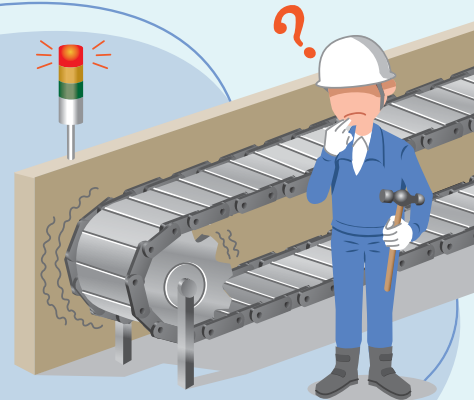


Clang clang!



Using a hammer is dangerous.

The outer plate pushing in too far results in poor articulation.



Connection/disconnection on large size conveyor chains requires significant labor.



Chain can't be repaired quickly if there's a problem.

Requires a lot of tools and jigs.



Screw Lock Link™ can solve these issues.

**Makes work safe**

No hammering required.

**Reduces production loss**

As long as you have spare parts on hand, restoration is fast.



**Prevents improper installation**

Avoid problems such as poor articulation due to the outer plate pushing in too far.

**Easy installation**

Reduces labor: the only tool needed is a torque wrench.

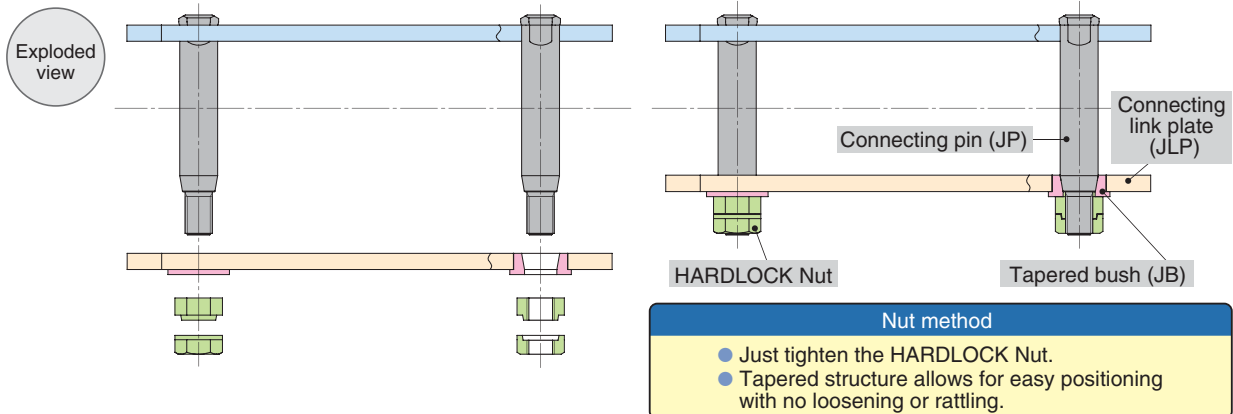
Same maximum allowable load as the  
base chain links.

No reduction in strength.

# safe and fast replacement.

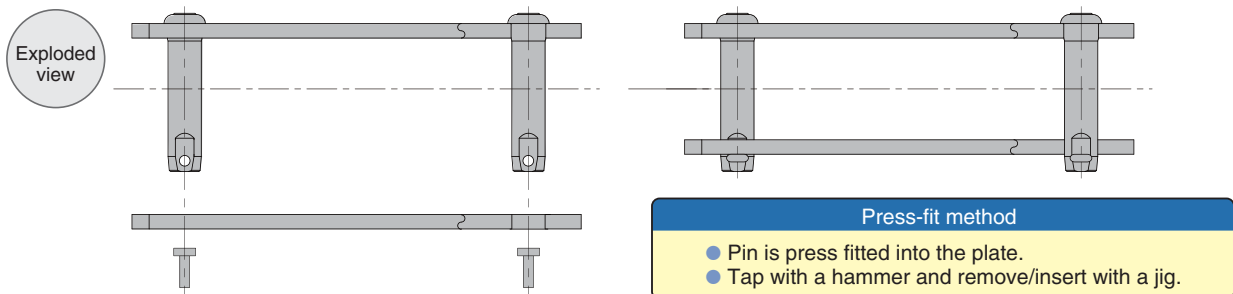
## Structural comparison

### Screw Lock Link



The nut method uses longer pins. Make sure there is no contact with equipment.

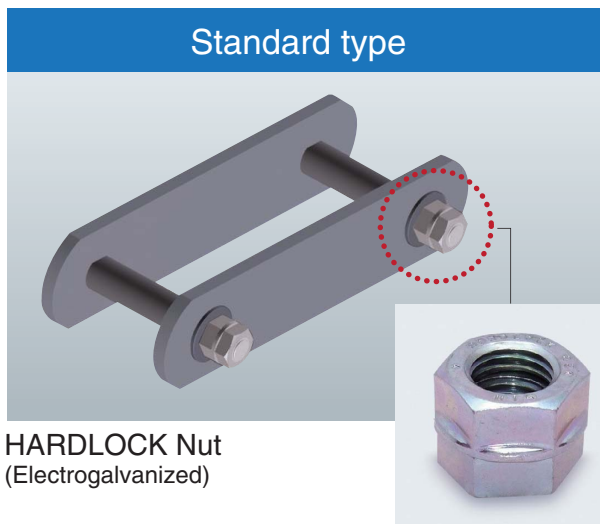
### Standard outer link



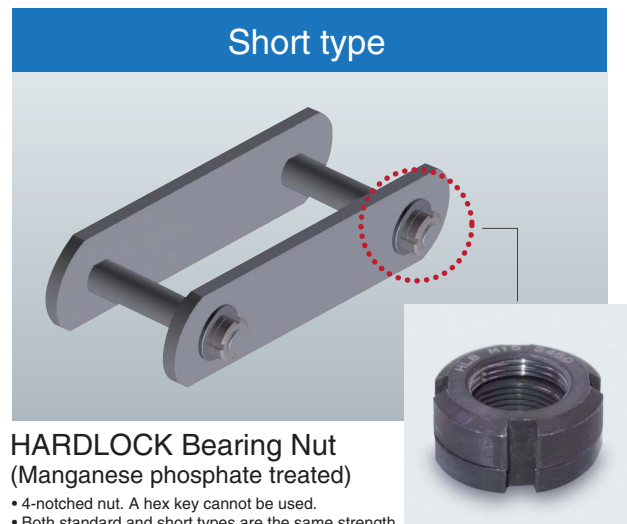
## 2 types of nuts available

A short type with a minimized pin length is also available.

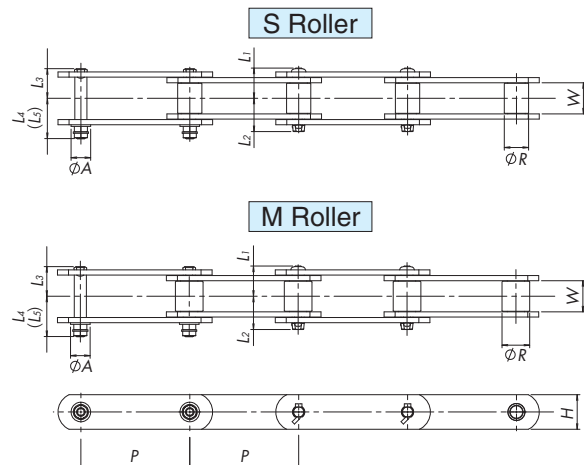
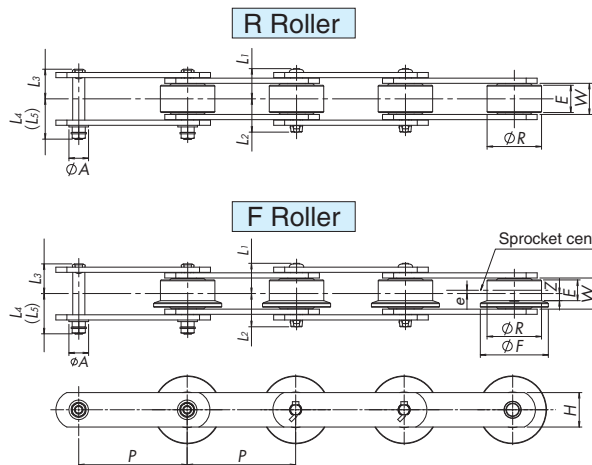
### Standard type



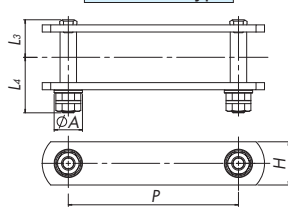
### Short type



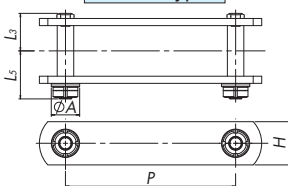
Note: Hardlock is a trademark of Hardlock Industry Co., Ltd.



Standard Type



Short Type



■ Connecting Link Dimensions

| Size    | Max. Allowable Load |             | Min. Tensile Strength |             | Pitch P | Pin            |                              |                           | Nut Size      |            | Connecting Bush Flange Dia. | Approx. Additional Mass (kg/each) |               |
|---------|---------------------|-------------|-----------------------|-------------|---------|----------------|------------------------------|---------------------------|---------------|------------|-----------------------------|-----------------------------------|---------------|
|         |                     |             |                       |             |         | Connecting Pin |                              |                           |               |            |                             |                                   |               |
|         | DT kN(kgf)          | AT kN(kgf)  | DT kN(kgf)            | AT kN(kgf)  |         | L <sub>3</sub> | Standard Type L <sub>4</sub> | Short Type L <sub>5</sub> | Standard Type | Short Type |                             | A                                 | Standard Type |
| RF10100 |                     |             |                       |             | 100     | 33             | 48.5                         | 42                        | M12           | M12        | 25                          | 0.13                              | 0.08          |
| RF10125 | 17.6 {1790}         | 32.3 {3290} | 107 {11000}           | 169 {17000} | 125     |                |                              |                           |               |            |                             |                                   |               |
| RF10150 |                     |             |                       |             | 150     |                |                              |                           |               |            |                             |                                   |               |
| RF12200 | 26.6 {2710}         | 39.9 {4060} | 160 {16500}           | 249 {25500} | 200     | 40.5           | 55.5                         | 49                        | M12           | M12        | 28                          | 0.17                              | 0.11          |
| RF12250 |                     |             |                       |             | 250     |                |                              |                           |               |            |                             |                                   |               |
| RF17200 |                     |             |                       |             | 200     | 51.5           | 69.5                         | 61.5                      | M14           | M15        | 32                          | 0.25                              | 0.14          |
| RF17250 | 35.0 {3570}         | 55.3 {5640} | 213 {22000}           | 336 {34000} | 250     |                |                              |                           |               |            |                             |                                   |               |
| RF17300 |                     |             |                       |             | 300     |                |                              |                           |               |            |                             |                                   |               |
| RF26200 |                     |             |                       |             | 200     | 55.5           | 74                           | 64                        | M16           | M17        | 36                          | 0.33                              | 0.17          |
| RF26250 | 44.9 {4570}         | 74.3 {7580} | 285 {29000}           | 448 {45500} | 250     |                |                              |                           |               |            |                             |                                   |               |
| RF26300 |                     |             |                       |             | 300     |                |                              |                           |               |            |                             |                                   |               |
| RF26450 |                     |             |                       |             | 450     |                |                              |                           |               |            |                             |                                   |               |

■ Base Chain Dimensions

| Size    | Roller Type | Inner Link Inner Width <i>W</i> | Plate Width <i>H</i> | Pin                   |                       | Roller        |                        |               |                      |                        |                     |          |      | S Roller Dia. <i>R</i> | M Roller Dia. <i>R</i> |
|---------|-------------|---------------------------------|----------------------|-----------------------|-----------------------|---------------|------------------------|---------------|----------------------|------------------------|---------------------|----------|------|------------------------|------------------------|
|         |             |                                 |                      | Cotter Pin            |                       | R Roller      |                        | F Roller      |                      |                        |                     |          |      |                        |                        |
|         |             |                                 |                      | <i>L</i> <sub>1</sub> | <i>L</i> <sub>2</sub> | Dia. <i>R</i> | Contact Width <i>E</i> | Dia. <i>R</i> | Flange Dia. <i>F</i> | Contact Width <i>E</i> | Off-center <i>e</i> | <i>Z</i> |      |                        |                        |
| RF10100 | R/S/M       | 30                              | 38.1                 | 33                    | 36                    | 50.8          | 27                     | —             |                      |                        |                     |          | 29   | 31.8                   |                        |
| RF10125 | R/F/S/M     |                                 |                      |                       |                       |               |                        | 50.8          | 65                   | 20                     | 3                   | 7        |      |                        |                        |
| RF10150 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |
| RF12200 | R/F/S/M     | 37.1                            | 44.5                 | 40.5                  | 43                    | 65            | 32                     | 65            | 80                   | 24                     | 4                   | 8        | 34.9 | 38.1                   |                        |
| RF12250 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |
| RF17200 | R/F/S/M     | 51.4                            | 50.8                 | 51.5                  | 58                    | 80            | 44                     | 80            | 100                  | 34                     | 5                   | 12       | 40.1 | 44.5                   |                        |
| RF17250 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |
| RF17300 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |
| RF26200 | S/M         | 57.2                            | 63.5                 | 55.5                  | 61                    | 100           | 50                     | 100           | 125                  | 38                     | 6                   | 13       | 44.5 | 50.8                   |                        |
| RF26250 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |
| RF26300 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |
| RF26450 |             |                                 |                      |                       |                       |               |                        |               |                      |                        |                     |          |      |                        |                        |

Note: 1. Operating temperature range is -20°C to 150°C. Contact a Tsubaki representative for use outside this range.

2. L<sub>4</sub> and L<sub>5</sub> are longer pin lengths than L<sub>2</sub>. Make sure there is no contact with equipment.

3. Regarding selection and usage, see Screw Lock Link Handling Instructions on page 5, and the Tsubaki Large Size Conveyor Chains & Sprockets catalog.

4. To tighten the short-type nut, use a hook spanner or socket wrench.

5. For attachment type, see the Tsubaki Large Size Conveyor Chains & Sprockets catalog.

6. Sizes (e.g. in inches) and specifications (e.g. stainless steel) other than those in the table above may also be manufactured. Contact a Tsubaki representative.

## Model Numbering Example

### Connecting Link

**RF12200 - DT - A2 - LNJL 8K**

Size      Series      Attachment type      Part name      Quantity/unit (piece)

LNJL: Standard type  
LSJL: Short type

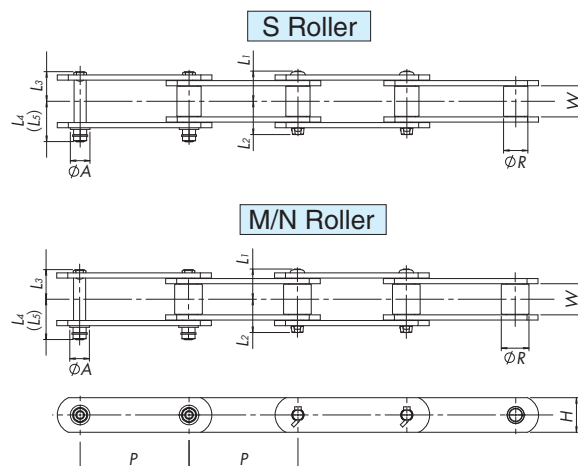
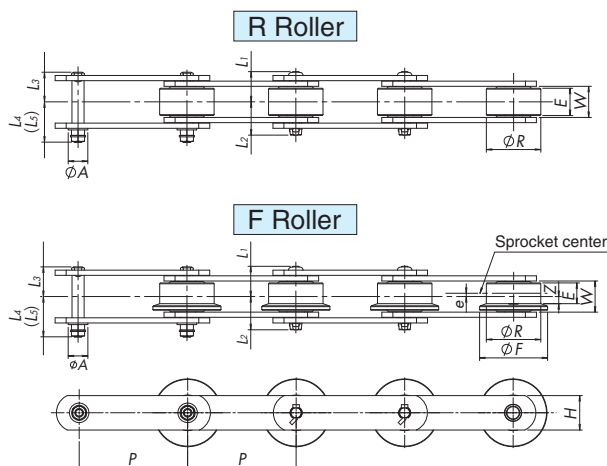
### Assembly Chain

**RF12200 R - AT - 2LK2 + 140L - LNJR 2H**

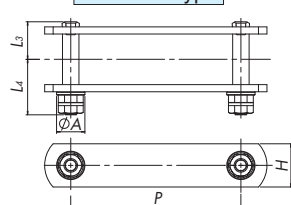
Size      Roller type      Series      Attachment spacing/type      No. of links      End link      Quantity/unit (strand)

Packing ▶ 14L (link) × 20H (strand) Total 140L (link) × 2H (strand)

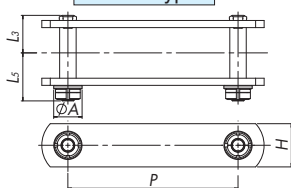
Note: A Screw Lock Link is attached to one end of the 14th link.



Standard Type



Short Type



■ Connecting Link Dimensions

| Size    | Max. Allowable Load |             | Min. Tensile Strength |               | Pitch P | Pin            |                              |                           | Nut Size      |            | Connecting Bush Flange Dia. | Approx. Additional Mass (kg/each) |               |
|---------|---------------------|-------------|-----------------------|---------------|---------|----------------|------------------------------|---------------------------|---------------|------------|-----------------------------|-----------------------------------|---------------|
|         |                     |             |                       |               |         | Connecting Pin |                              |                           |               |            |                             |                                   |               |
|         | DT kN(kgf)          | AT kN(kgf)  | DT kN(kgf)            | AT kN(kgf)    |         | L <sub>3</sub> | Standard Type L <sub>4</sub> | Short Type L <sub>5</sub> | Standard Type | Short Type |                             | A                                 | Standard Type |
| RF36250 |                     |             |                       |               | 250     | 66             | 91.5                         | 78.5                      | M20           | M20        | 42                          | 0.55                              | 0.26          |
| RF36300 | 68.0 {6930}         | 97.4 {9930} | 457 {46500}           | 614 {62500}   | 300     |                |                              |                           |               |            |                             |                                   |               |
| RF36450 |                     |             |                       |               | 450     |                |                              |                           |               |            |                             |                                   |               |
| RF36600 |                     |             |                       |               | 600     |                |                              |                           |               |            |                             |                                   |               |
| RF52300 |                     |             |                       |               | 300     | 79             | 110                          | 93.5                      | M24           | M25        | 48                          | 0.85                              | 0.39          |
| RF52450 | 71.4 {7280}         | 147 {15000} | 481 {49000}           | 953 {97000}   | 450     |                |                              |                           |               |            |                             |                                   |               |
| RF52600 |                     |             |                       |               | 600     |                |                              |                           |               |            |                             |                                   |               |
| RF60300 |                     |             |                       |               | 300     | 72.5           | 104                          | 86.5                      | M27           | M30        | 55                          | 1.18                              | 0.53          |
| RF60350 | 71.4 {7280}         | 149 {15200} | 479 {49000}           | 1010 {103000} | 350     |                |                              |                           |               |            |                             |                                   |               |
| RF60400 |                     |             |                       |               | 400     |                |                              |                           |               |            |                             |                                   |               |
| RF90350 |                     |             |                       |               | 350     | 85.5           | 120.5                        | 102                       | M30           | M35        | 65                          | 1.85                              | 0.88          |
| RF90400 | 113 {11500}         | 233 {23700} | 754 {77000}           | 1600 {163000} | 400     |                |                              |                           |               |            |                             |                                   |               |
| RF90500 |                     |             |                       |               | 500     |                |                              |                           |               |            |                             |                                   |               |

■ Base Chain Dimensions

| Size    | Roller Type | Inner Link Inner Width W | Plate Width H | Pin            |                | Roller   |                 |          |               |                 |              |      |      | S Roller Dia. R | M Roller Dia. R |
|---------|-------------|--------------------------|---------------|----------------|----------------|----------|-----------------|----------|---------------|-----------------|--------------|------|------|-----------------|-----------------|
|         |             |                          |               | Cotter Pin     |                | R Roller |                 | F Roller |               |                 |              |      |      |                 |                 |
|         |             |                          |               | L <sub>1</sub> | L <sub>2</sub> | Dia. R   | Contact Width E | Dia. R   | Flange Dia. F | Contact Width E | Off-center e | Z    |      |                 |                 |
| RF36250 | S/M         | 66.7                     | 76.2          | 68             | 78             | 125      | 56              | 125      | 150           | 42              | 7            | 14   | 50.8 | 57.2            |                 |
| RF36300 | R/F/S/M     |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF36450 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF36600 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF52300 | R/F/S       | 77                       | 76.2          | 82             | 90             | 140      | 65              | 140      | 170           | 49              | 8            | 16.5 | 57.2 | —               |                 |
| RF52450 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF52600 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF60300 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF60350 | R/F/N       | 77                       | 90            | 77             | 83.5           | 140      | 65              | 140      | 170           | 49              | 8            | 16.5 | —    | 70              |                 |
| RF60400 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF90350 | N           | 88                       | 110           | 89.5           | 95.5           | —        |                 |          |               |                 |              |      | —    | 85              |                 |
| RF90400 | R/F/N       |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |
| RF90500 |             |                          |               |                |                |          |                 |          |               |                 |              |      |      |                 |                 |

Note: 1. Operating temperature range is -20°C to 150°C. Contact a Tsubaki representative for use outside this range.

2. L4 and L5 are longer pin lengths than L2. Make sure there is no contact with equipment.

3. Regarding selection and usage, see Screw Lock Link Handling Instructions on page 5, and the Tsubaki Large Size Conveyor Chains & Sprockets catalog.

4. To tighten the short-type nut, use a hook spanner or socket wrench.

5. For attachment type, see the Tsubaki Large Size Conveyor Chains & Sprockets catalog.

6. Sizes (e.g. in inches) and specifications (e.g. stainless steel) other than those in the table above may also be manufactured. Contact a Tsubaki representative.

## End Links

| End Link Code | One End                       | Other End                     |
|---------------|-------------------------------|-------------------------------|
| LNJ R         | Screw Lock Link standard type | Inner link                    |
| LSJ R         | Screw Lock Link short type    | Inner link                    |
| LNJ LNJ       | Screw Lock Link standard type | Screw Lock Link standard type |
| LSJ LSJ       | Screw Lock Link short type    | Screw Lock Link short type    |

Note: The Screw Lock Link (connecting link) is shipped with its lower nut tightened at the prescribed torque and its upper nut lightly tightened to prevent it from getting lost.

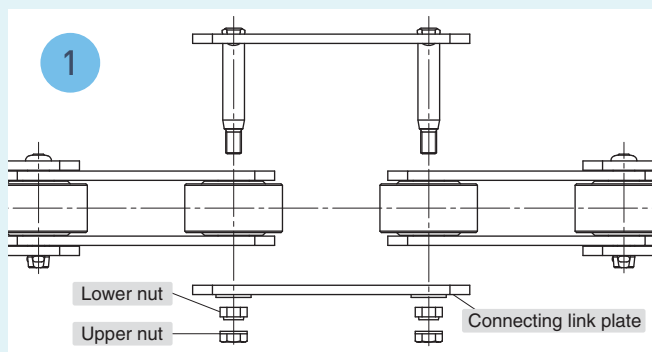
# Screw Lock Link Handling Instructions



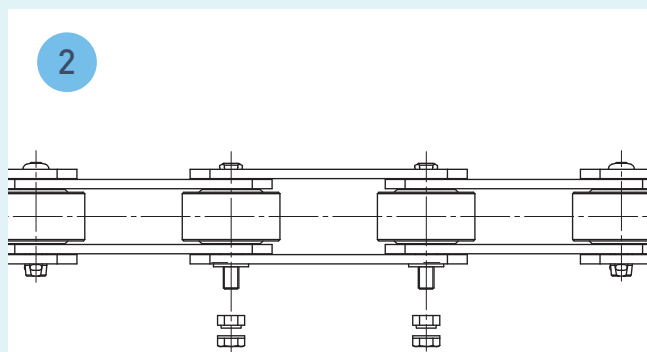
## Caution

Whether the conveyor is parallel, slanted, or vertical, always attach a chain block or piano wire to the area to be connected/disconnected to ensure there is no tension on the chain.

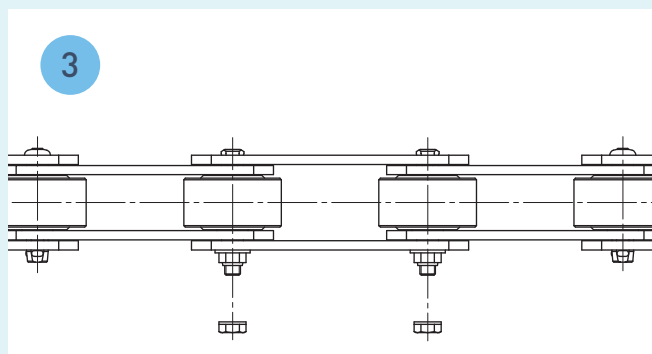
## ■ Connecting



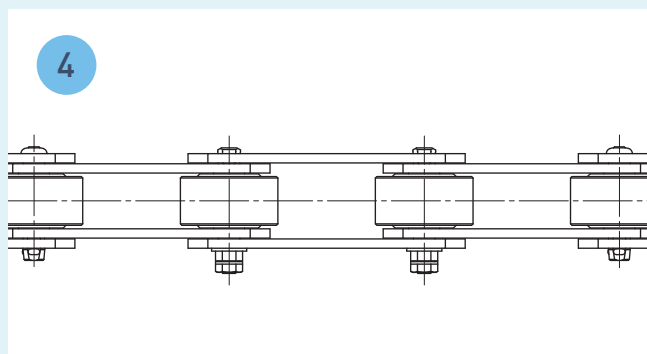
Remove the nuts and the connecting link plate.



Pull both ends of the chain together, insert the connecting link into the joints of the inner link, and place the connecting link plate over the pin ends.



Tighten the lower nut at the torque prescribed below. Before tightening the nut, remove oil and other substances from the screw threads using a cloth.



Tighten the upper nut at the torque prescribed below to complete connection.

## ■ Disconnecting

1

Remove the upper nut, then the lower nut.

2

Remove the connecting link plate, then remove the connecting link from the inner link.

Note: Nuts may be difficult to remove due to things like residue from conveyed items or corrosion.

# Maintenance and Inspection

Nuts may come loose or fall off depending on usage environment and conditions. Periodically check for loosening of the nuts.  
(Making matchmarks on the nuts makes it easier to check them.)

Refer to the *Tsubaki Large Size Conveyor Chains & Sprockets* catalogue for maintenance and inspection.

## ■ Nut Tightening Torque (N·m)\*1

|               |           | RF10      | RF12      | RF17     | RF26     | RF36     | RF52     | RF60     | RF90     |
|---------------|-----------|-----------|-----------|----------|----------|----------|----------|----------|----------|
| Standard Type | Nut Size  | M12×P1.75 | M12×P1.75 | M14×P2.0 | M16×P2.0 | M20×P2.5 | M24×P3.0 | M27×P3.0 | M30×P3.5 |
|               | Lower Nut | 27–32     | 28–33     | 46–55    | 72–82    | 120–130  | 218–228  | 250–260  | 367–377  |
|               | Upper Nut | 27–32     | 28–33     | 46–55    | 72–82    | 120–130  | 218–228  | 250–260  | 367–377  |
| Short Type*2  | Nut Size  | M12×P1.0  | M12×P1.0  | M15×P1.0 | M17×P1.0 | M20×P1.0 | M25×P1.5 | M30×P1.5 | M35×P1.5 |
|               | Lower Nut | 23–27     | 28–33     | 49–58    | 76–86    | 117–127  | 227–237  | 254–264  | 428–438  |
|               | Upper Nut | 16–19     | 16–19     | 28–33    | 37–44    | 55–65    | 80–90    | 115–125  | 130–140  |

\*1 The tightening torque in the above table is for steel nuts. Contact a Tsubaki representative regarding stainless steel nuts.

\*2 The short type is a 4-notched nut. Use a hook spanner or socket wrench.

# For Safe Use



## Warning

Observe the following points to prevent hazardous situations.

- Do not use chains or accessories (peripheral devices and parts) for anything other than their original purpose.
- Never perform additional work on the chain.
  - Do not anneal the various parts of the chain.
  - Do not clean the chain with acids or alkalis, as they may cause cracking.
  - Never electroplate the chain or its parts, as this may cause cracking due to hydrogen embrittlement.
  - Do not weld the chain, as the heat may cause cracking or a reduction in strength.
  - When heating or cutting the chain with a torch, remove the links immediately adjacent and do not use them again.
- When there is a need to replace a damaged (fractured) portion of a chain, always replace the whole chain with a new product rather than replacing only the damaged or fractured portion.
- Immediately stop using the chain if it comes into contact with a substance that can cause embrittlement cracking (acid, strong alkali, battery fluid, etc.) and replace with a new chain.
- When using the chain on suspension equipment, establish a safety fence and strictly prevent entry to the area directly below the suspended object.
- Always install hazard protection devices (safety covers, etc.) for the chain and sprocket.
- Strictly observe the rules and regulations concerning occupational safety and health in your region/country.
- When installing, removing, inspecting, maintaining, and lubricating the chain:
  - Perform the work as instructed in the manual, catalog, or other documentation that was provided with the product.
  - Always turn off the power switch to the equipment beforehand and make sure that it cannot be turned on accidentally.
  - Secure the chain and parts so that they cannot move freely.
  - Use a press or other special tool to cut and connect chain, and cut and connect using the proper procedures.
  - Remove and insert pins and rivets in the correct direction.
  - Wear clothing and protective gear (safety glasses, gloves, safety shoes, etc.) that are appropriate for the work.
  - Only experienced personnel should replace chains and sprockets.



## Caution

Observe the following points to prevent accidents.

- Only handle chains and sprockets after thoroughly understanding their structure and specifications.
- When installing chains and sprockets, inspect them in advance to confirm that they have not been damaged in transport.
- Always regularly inspect and maintain your chains and sprockets.
- Chain strength varies according to manufacturer. When selecting a chain based on a Tsubaki catalog always use the corresponding Tsubaki product.
- Minimum tensile strength refers to the failure point when a load is applied to the chain once and does not refer to the allowable operational load.

## Warranty

### 1. Warranty Period

Products manufactured by Tsubakimoto Chain Co. ("Products") are warranted against defects in materials and workmanship for eighteen (18) months from the date of shipment from the factory or twelve (12) months from the date the Products are first placed into operation (calculated from the date the Products have been installed on the customer's equipment), whichever comes first.

### 2. Scope of Warranty

During the warranty period, if defects arise in the Products when installed, used, and maintained correctly in accordance to Tsubakimoto Chain's catalogs, installation manuals (including any documents specially prepared and provided to the customer) and the like, Tsubakimoto Chain will repair or replace such defective Products thereof free of charge upon confirmation of said defect by Tsubakimoto Chain. This warranty shall only apply to Products received, and Tsubakimoto Chain shall not be liable for the following costs and/or damages (including installation manuals or other documents specially prepared and provided to the customer):

- (1) Costs required for removing the defective Products from or re-installing the replacement Products on the customer's equipment for replacement or repair of the defective Product, as well as any associated installation costs.
- (2) Costs required to transport the customer's equipment, if needed, to a repair shop or the like.
- (3) Any consequential or indirect damages or loss of profits or benefits the customer may incur due to the defects or repair of the Products.

### 3. Out of Warranty Service and Repair

Regardless of the warranty period, Tsubakimoto Chain will provide investigation, repair, and/or manufacture of the Products for a fee should the Products experience problems or anomalies under the following situations.

- (1) Placement, installation (including connecting and disconnecting), lubrication, or maintenance of the Products not in accordance with Tsubakimoto Chain's catalogs, installation manuals (including documents specially prepared and provided to the customer), or the like.
- (2) Use of the Products (including operating conditions, environment, and allowances) not in accordance with Tsubakimoto Chain's catalogs, installation manuals (including documents specially prepared and provided to the customer), or the like.
- (3) Inappropriate disassembly, modification, or processing of the Products by the customer.
- (4) Use of the Products with damaged or worn products.  
(Example: Use of the Products with a worn sprocket, drum, rail, or the like.)
- (5) When the operating conditions exceed the performance of the Products as selected using the Tsubakimoto Chain selection method.
- (6) Use of the Products in conditions other than what have been discussed.
- (7) When consumables such as bearings, oil seals, and lubricant in the Products deplete, wear, or degrade.
- (8) When secondary damage occurs to the Products due to initial or primary damage or failure to the customer's equipment.
- (9) Damage or failure of the Products due to forces majeure such as natural disasters.
- (10) Damage or failure of the Products due to unlawful conduct by third parties.
- (11) Damage or failure of the Products due to causes not attributable to Tsubakimoto Chain

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Tsubakimoto Chain Co.

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<https://tsubaki.ind.br/>

Canada

Tsubaki of Canada Limited

<https://tsubaki.ca/>

#### EUROPE

Netherlands

Tsubakimoto Europe B.V.

<https://tsubaki.eu/>

France

Kabelschlepp France S.A.R.L.

<https://tsubaki-kabelschlepp.com/fr-fr/>

Germany

Tsubaki Deutschland GmbH

<https://tsubaki.de/>

Tsubaki Kabelschlepp GmbH

<https://tsubaki-kabelschlepp.com/de-de/>

Italy

Kabelschlepp Italia S.R.L.

<https://tsubaki-kabelschlepp.com/it-it/>

Spain

Tsubaki Ibérica Power Transmission S.L.

<https://tsubaki.es/>

United Kingdom

Tsubakimoto UK Ltd.

<https://tsubaki.eu/>

Slovakia

Kabelschlepp-Systemtechnik, spol. s.r.o.

<https://tsubaki-kabelschlepp.com/sk-sk/>

Poland

Kabelschlepp Sp. z o.o.

<https://kabelschlepp.pl/>

#### INDIAN OCEAN RIM

Singapore

Tsubakimoto Singapore Pte. Ltd.

<https://tsubaki.sg/>

Australia

Tsubaki Australia Pty. Limited

<https://tsubaki.com.au/>

India

Tsubaki India Power Transmission Private Limited

<https://en.tsubaki.in/>

Indonesia

PT. Tsubaki Indonesia Trading

<https://tsubaki.id/>

Malaysia

Tsubaki Power Transmission (Malaysia) Sdn. Bhd.

<https://en.tsubaki.my/>

New Zealand

Tsubaki Australia Pty. Limited - New Zealand Branch

<https://tsubaki.com.au/>

Philippines

Tsubakimoto Philippines Corporation

<https://en.tsubaki.ph/>

Thailand

Tsubakimoto (Thailand) Co., Ltd.

<https://tsubaki.co.th/>

Vietnam

Tsubakimoto Vietnam Co., Ltd.

<https://tsubaki.net.vn/>

#### EAST ASIA

Republic of Korea

Tsubakimoto Korea Co., Ltd.

<https://tsubakimoto-tck.co.kr/>

Taiwan

Taiwan Tsubakimoto Trading Co., Ltd.

<https://tsubakimoto.tw/>

#### CHINA

China

Tsubakimoto Chain (Shanghai) Co., Ltd.

<https://www.tsubaki-sh.cn/>



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