

FIGURE 1 - ASME CHAIN DIMENSIONAL DATA

CSP DASH NO.	STD ROLLER CHAIN NO ASME B29.1M	CHAIN PROOF LOAD (LBS) 5	D NOM	E DIA NOM	G MAX	H NOM	P PITCH	W NOM
CSP180-25	ASME 25	275	0.130	0.091	0.238	0.32	0.250	0.125
CSP180-35	ASME 35	615	0.200	0.141	0.356	0.48	0.375	0.187
CSP180-40	ASME 40	1095	0.312	0.156	0.475	0.66	0.500	0.312
CSP180-41	ASME 41	525	0.306	0.141	0.390	0.56	0.500	0.250
CSP180-50	ASME 50	1710	0.400	0.200	0.594	0.82	0.625	0.375
CSP180-60	ASME 60	2470	0.469	0.234	0.712	1.15	0.750	0.500
CSP180-80	ASME 80	4375	0.625	0.312	0.950	1.43	1.000	0.625

Table 1: ASME CHAIN PROOF LOAD & DIMENSIONAL DATA

Ⓛ INACTIVE FOR NEW DESIGN - REFER TO DSC552

LIST OF CURRENT SHEETS				
SHEET	1	2	3	
REV	L	D	A	

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

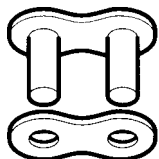
DRAWN	D. SHAW	CHAIN, ROLLER	CSP 180
CHECKED	D. BINNINGTON		
STRESSED	J. THOMPSON		SHEET: 1
APPROVED	D. BINNINGTON		

Ⓛ DSC552 WAS DSC532

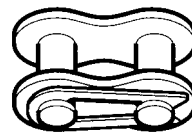
REV: 25 APR 97
REV: G - 31 JUL 86
REV: H - 12 MAR 87
REV: J - 24 OCT 97
REV: K - 10 JUL 98
REV: L - 12 JUL 00

NOTES:

- ① **CSP180 IS INACTIVE FOR NEW DESIGN AS OF JULY 1998. REFER TO DSC552 FOR MIL-STD-421 QUALIFIED AIRCRAFT CHAIN.**
2. MATERIAL: CARBON AND LOW ALLOY STEEL AS PER MIL-STD-421B, GRADE A. ALL CHAINS CONFORM TO ASME (ANSI, ASA) B29.1M*
- 3.* **ASA** - AMERICAN STANDARDS ASSOCIATION HAS BEEN REPLACED BY **ANSI** - AMERICAN NATIONAL STANDARDS INSTITUTE WHICH HAS BEEN REPLACED BY **ASME** (AMERICAN SOCIETY OF MECHANICAL ENGINEERS) STANDARD B29.1M
4. a) CSP180 CHAIN ASSEMBLIES COME WITH PIN (RIVET) TYPE CONNECTING LINKS. RIVETED PIN TYPE LINKS CAN BE USED TO CONNECT CHAIN ENDS TOGETHER OR TO CONNECT TERMINALS TO CHAIN. IF TWO CONNECTING LINKS ARE REQUIRED (AS IN THE CASE OF TERMINALS TO CHAIN ENDS) ADD A PREFIX "L" TO THE FIRST DASH NUMBER. IF NO PIN TYPE CONNECTING LINK IS REQUIRED, (AS WHEN USING A DETACHABLE CONNECTING LINK) ADD A PREFIX "N" TO THE FIRST DASH NUMBER. PINS MUST BE RIVETED TO PPS 2.06.
4. b) WHERE CHAIN ASSEMBLIES MUST BE CONNECTED ON INSTALLATION IN AIRCRAFT, A DETACHABLE CONNECTING LINK MUST BE USED. DETACHABLE LINKS USE SPRING CLIPS FOR CHAIN SIZES -25 TO -80.
- SPECIFY CONNECTING LINK ON DRAWING, EXAMPLE; **"ASME 25 SPRING TYPE CONNECTING LINK"**.



PIN (RIVETED) TYPE
CONNECTING LINK



DETACHABLE (SPRING CLIP)
TYPE CONNECTING LINK

FIGURE 2- CHAIN CONNECTING LINKS

- 4.c) IN ORDER THAT CSP180 CHAIN ASSEMBLIES CAN BE FORMED INTO A COMPLETE LOOP, CHAIN MUST CONTAIN AN EVEN NUMBER OF PITCHES "P" INCLUDING THE CONNECTING LINK.
- WHERE CHAIN LENGTH CONTAINS AN ODD NUMBER OF PITCHES, A TWO (2) PITCH OFFSET CONNECTING LINK WILL REQUIRED TO FORM A COMPLETE LOOP. THESE CONNECTING LINKS CONSIST OF ONE ROLLER LINK AND AN OFFSET LINK RIVETED TOGETHER. 2 PITCH OFFSET LINKS MUST BE RIVETED TO PPS 2.06.
- SPECIFY CONNECTING LINK ON DRAWING, EXAMPLE; **"ASME 35 RIVET TYPE OFFSET LINK 2 PITCH"**.
- 5.a) CABLES AND TURNBUCKLES CAN BE ATTACHED TO CHAIN USING NAS 287 AND 288 TERMINALS. TERMINALS ARE CONNECTED USING PIN TYPE OR SPRING TYPE CONNECTING LINKS.
- 5.b) IF PLATES, FITTINGS ETC. ARE TO BE ATTACHED TO CHAIN, MS 20615 MONEL RIVETS CAN BE USED IN PLACE OF THE PINS INCLUDED IN THE CSP CHAIN ASSEMBLY.

① **INACTIVE FOR NEW DESIGN - REFER TO DSC552**

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	D. SHAW	CHAIN, ROLLER	CSP 180
CHECKED	D. BINNINGTON		
STRESSED	J. THOMPSON		SHEET: 2
APPROVED	D. BINNINGTON		

① DSC552 WAS DSC532

REV:

REV:

REV: D - 12 JUL 00

REV: C - 10 JUL 98

REV: B - 29 OCT 97

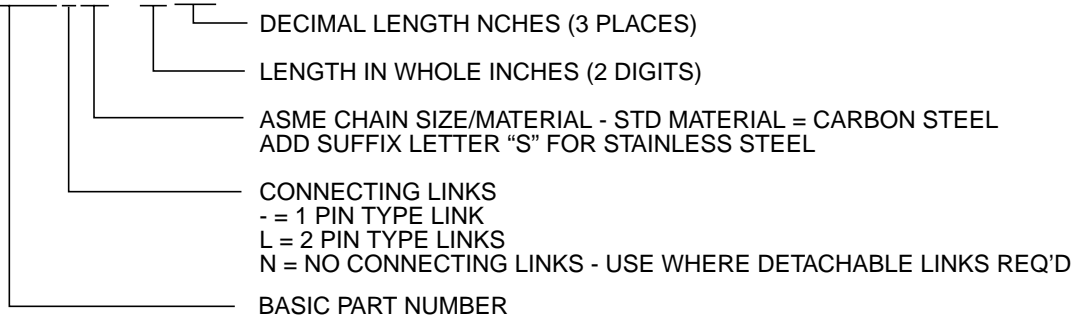
REV: A - 12 MAR 87

APPROVED: 25 NOV 86

6. CHAIN PROOF LOAD IS 35% OF ULTIMATE TENSILE STRENGTH
STAINLESS STEEL CHAINS HAVE ULTIMATE STRENGTH APPROX. 21% LESS THAN CARBON STEEL CHAIN, SEE MATERIALS TECHNOLOGY BEFORE USING
SPECIFY ON DRAWING "**PROOF LOAD CABLE/CHAIN ASSEMBLY TO (VALUE SHOWN IN TABLE 1) PER PPS 3.05**".

7. EXAMPLE OF PART NUMBER BREAKDOWN:

CSP180 - 25 - 14-250



- : **CSP180-25-14-250** = CARBON STEEL CHAIN ASSEMBLY, ASME 25 SIZE, (.250 PITCH), 14.25 IN. LONG, INCLUDING ONE (1) PIN TYPE CONNECTING LINK, (57 PITCHES)
- CSP180L35-14-625** = CARBON STEEL CHAIN ASSEMBLY, ASME 35 SIZE, (.375 PITCH), 14.625 IN. LONG INCLUDING TWO (2) PIN TYPE CONNECTING LINKS, (39 PITCHES))
- CSP180N35S-09-375** = STAINLESS STEEL CHAIN ASSEMBLY, ASME 35 SIZE (.375 PITCH), 9.375 IN. LONG, NO CONNECTING LINKS, (25 PITCHES)
8. CHAIN SIZE 25 AND 35 ARE ROLLERLESS. CHAIN SIZE 40 AND OVER ARE ROLLER TYPE

INACTIVE FOR NEW DESIGN - REFER TO DSC552

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	D. SHAW	CHAIN, ROLLER	CSP 180
CHECKED	D. BINNINGTON		
STRESSED	J. THOMPSON		SHEET: 3
APPROVED	D. BINNINGTON		