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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 24815-2009

**Short link chain for lifting purposes -- Grade 6, non-calibrated,
for chain slings etc.**

起重用短环链 吊链等用6级普通精度链

(English Translation)

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GB/T 24815-2009/ISO 3075.

Foreword

This standard is identical with ISO 3075. 1980 "Short link chain hoists lifting chain with S (6) ordinary level precision chain" (in English).

This standard is equivalent translation ISO 3075. 1980.

For ease of use, this standard made the following editorial changes.

--- "This International Standard" be replaced by "this standard";

"," --- With a decimal point instead of a comma as the decimal point, "";

--- Delete foreword international standards;

--- Removed has been revoked ISO/R388;

--- Other international standards referenced with the international standard has been adopted as the standard instead of the corresponding country.

Appendix A of this standard is a normative appendix.

The standard proposed by China Machinery Industry Federation.

This standard by the National Standardization Technical Committee crane (SAC/TC227) centralized.

1 Scope

This standard specifies the use of cranes and slings and general lifting six ordinary precision chain. The chain is the result of insufficient heat Round welded management and test a short chain and comply with GB/T 20946 stipulated acceptance General.

This standard applies to nominal size of 5mm ~ 45mm chain, the appendix also gives 6mm ~ 30mm chain with additional temporary Nominal size.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 702 hot-rolled steel bars - Dimensions, shape, weight and tolerances (GB/T 702-2008, ISO 1035-1 ~ 1035-4. 1980, MOD) GB/T 6394-2002 average grain size metal assay (ASTME112-96, MOD) GB/T 20946-2007 Short link chain for lifting acceptance General (ISO 1834:1999, IDT)

3 Terms and Definitions

Terms and definitions GB/T 20946 apply to this standard established.

4 Acceptance General

The chain should be consistent with GB/T 20946 and the requirements of this standard.

5.1 Nominal size (see GB/T 20946-2007 of 3.1)

Chain preferred nominal size should be consistent with Table 1 a. The nominal and manufacturing chain with wire or rod (GB/T 702) with a diameter correspond.

Note: The size of the control wire or rod used in the manufacturing chain is important. However, this standard refers to the finished product chain must be noted that test may not have the opportunity to retroactively original Test results of material size. Size chain manufacturers of raw materials should be controlled within the allowable tolerances.

5.2.1 Material diameter tolerance

Should exceed the nominal diameter of + 2-6%.

Deviation shall not exceed $\pm 5\%$ of the nominal diameter.

5.2.2 Weld tolerances

--- Type 1. On any cross section of 10% of the nominal diameter;

--- Type 2. 20% of the chain ring nominal diameter of the cross section perpendicular to the plane, on the other plane is 35%.

Note: type 1 chain by welding tolerance limit of 10% in nominal inside diameter to avoid kinking or jamming problems; type 2 chain links in certain areas only allow welding Ultra seam difference exceeds 10% of a specified type (see FIG. 1), in order to provide the necessary clearance to ensure no kinks and jamming problems.

GB/T 24815-2009/ISO 3075. 1980