

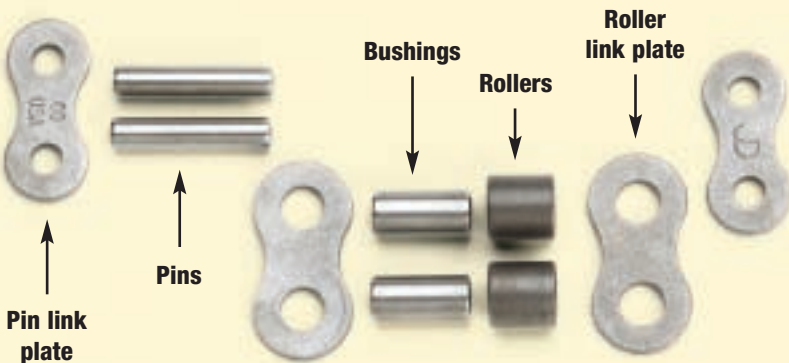
BULK ROLLER CHAIN AND ACCESSORIES



JOHN DEERE
Genuine Parts and Service

John Deere — your solution center for quality-made, bulk roller chain.

Quality, performance, and reliability. That's what you've come to expect from John Deere. And John Deere bulk roller chain is no exception. John Deere U.S.-made, bulk roller chain provides longer wear life than most competitive chain, and requires less maintenance. It's John Deere branded, and guaranteed to meet or exceed ANSI standard B29.1.



John Deere bulk roller chain is compatible with all makes of equipment and a variety of applications — agricultural, commercial, industrial, lawn and garden, and more.

Stop in today to find out more about our competitively priced bulk roller chain — we'll custom-make your chain while you wait!

Think all roller chain is the same? Think again!

For longer wear life and minimal maintenance, choose only John Deere U.S.-made, bulk roller chain.

Wide waist

The wide-waist design of 60H and larger chain resists bending and increases fatigue strength.



Factory preloading

Preloading during assembly seats the chain components, minimizing initial elongation of the chain.

Heat treatment

All chain components are heat-treated for maximum toughness and wear resistance.

Solid rollers

Rollers are solid, not seamed, allowing smooth rotation on the bushing and minimizing impact load as the chain engages the sprocket tooth.



Pre-lubrication

Chain is dipped in a 230-degree lubricant that protects all load-bearing surfaces from metal-to-metal contact.

Re-punched holes

Holes are punched twice for maximum press-fit and improved fatigue strength. Re-punched holes eliminate the “tapered” effect caused by the single-punch process.



Shot-peened parts

All rollers and link plates have dimples on the surface — a result of the shot-peening process that provides greater fatigue strength.



High press-fits

High press-fits provide greater loading capacity and increased fatigue strength.

Roller chain installation

For maximum performance and optimum service life, the following steps should be taken when installing chain.

Speed ratio and chain wrap

The speed ratio of roller chain can range up to 7:1 under normal operating conditions. If operating speed is slow, a speed ratio of 10:1 is possible. Chain wrap on the small sprocket must be at least 120 degrees.

Distance between shafts

Sprockets can be separated by any distance, as long as their teeth do not touch. Optimum distance is 30 to 50 times the pitch of the chain. In cases where there is a pulsating load, the distance should be up to 20 times the pitch of the chain.

Position

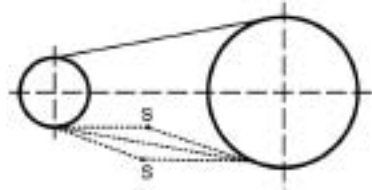
Roller chain should ideally be installed in a horizontal position. If the chain drive must be in a vertical position, the wear life of the chain will be reduced due to the effects of gravity.

Slack

The slack of a roller chain should generally be on the lower side (Fig. A). Adequate slack is four percent of the span for normal drives. In the following cases, slack should be about two percent of the span:

- Vertical drive or close to vertical drive
- Center distance between two shafts is greater than three feet
- Chain is operated under heavy load and high frequency of on and off drive
- Direction of the drive is often changed

Fig. A



Position of sprocket

The two shafts should be parallel and preferably in a horizontal position. Sprockets should be firmly installed (Fig. B and C). Use a straightedge to ensure that the two sprockets are installed along the same horizontal plane.



Fig. B

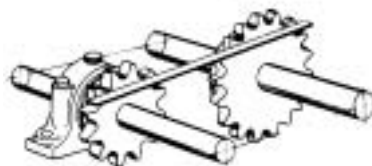


Fig. C

Roller chain maintenance

Proper lubrication and maintenance is critical to the performance and service life of chain. Drives should be inspected after initial operation, and again after the first 100 hours of operation. After these preliminary examinations, drives should be inspected at the beginning and end of each season. Drives that are subject to severe operating conditions and shock loads should be inspected every 200 hours. A thorough examination should include the following inspection points:

- 1. Check lubrication.** On slow-speed drives where *manual lubrication* is used, be sure to follow the lubrication schedule. If the chain is covered with dirt and debris, clean the chain with kerosene and re-lubricate. If *drip lubrication* is used, check for adequate oil flow and proper application. With *bath or pump lubrication*, check oil level and add oil if needed. Also check for contamination and change oil if necessary. If *pump lubrication* is used, check each orifice to be sure it is clear and properly directing oil to the chain.
- 2. Check chain tension.** Adjust as needed to maintain proper sag in the slack span. If elongation exceeds the available adjustment, remove two pitches and reconnect the chain.
- 3. Check chain wear.** If chain elongation exceeds functional limits or is greater than 3 percent (0.36 inches in one foot), replace the entire chain. A chain worn beyond 3 percent will not properly engage the sprockets and may cause damage to the sprockets.
- 4. Check sprocket tooth wear.** Inspect sprocket teeth for reduced tooth sections and hooked tooth tips. Also check for roughness or binding when the chain engages or disengages from the sprocket. If any of these conditions exist, the sprocket should be replaced.
- 5. Check sprocket alignment.** If there is noticeable wear on the inside surface of the chain roller link plates, the sprockets may be misaligned. Realign the sprockets to prevent further wear.
- 6. Check for drive interference.** If there is obstruction between the drive and any other parts, correct it immediately. Check for and eliminate any buildup of debris or foreign material between the chain and sprockets.
- 7. Check for failure.** If the chain is cracked, broken, or deformed, replace the entire chain — even if portions of the chain appear to be in good condition.

U.S.-made and import bulk roller chain

- U.S.-made bulk roller chain provides longer wear life and requires minimal maintenance
- John Deere branded
- Meets or exceeds ANSI standard B29.1
- Compatible with all makes of equipment
- Available for a variety of applications — agricultural, commercial, industrial, lawn and garden, and more
- New everyday competitive pricing
- Now offering chain up to 240 pitch



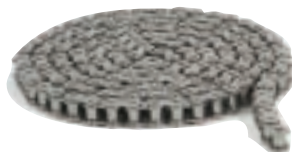
Corrosion- and moisture-resistant chain

Stainless steel chain

Stainless steel offers the greatest resistance to corrosion and temperature extremes, but is less wear resistant than carbon steel. 300-Series roller chains, available in the most commonly used sizes, have very low magnetic permeability — essentially non-magnetic and, when used in conjunction with

300-Series sprockets, can be considered non-sparking:

- Provides corrosion resistance superior to either nickel-plated or -coated series chains
- Provides operating temperature ranges above and below where carbon steel base chains can operate
- Available in a variety of grades depending on the specific application's requirements
- 300-Series chains are considered to be non-magnetic



Nickel-plated chain

Nickel-plated chains are designed to resist incidental contact or exposure to water or water-based wash-down operations. Electroless nickel plating applied to the component parts prior to assembly ensures complete coverage of all exposed carbon material. Special attention is placed on the after-plating processes to virtually remove the possibility of hydrogen embrittlement — a common occurrence in lesser quality chains:

- Equal in strength to carbon steel chains
- Equal in wear life to carbon steel chains
- Electroless nickel-plated parts for uniform and complete protection
- Resists rust from incidental exposure to water or water vapor
- Nickel plating applied prior to assembly



Silvershield CR™ Series chains

Silvershield CR chains are available for applications in mildly caustic or acidic environments. These chains consist of standard carbon steel components, which are specifically coated with a zinc-aluminum compound. This compound, combined with a polymer-based resin, tightly adheres to the components during a high-temperature baking process. This combination provides the best alternative to stainless steel in applications where stainless steel has historically been the only option:

- Equal in strength to carbon steel chains
- Equal in wear life to carbon steel chains
- Protective coating is applied to individual parts for uniform and complete protection
- Silvershield CR coating developed specifically for corrosion resistance in caustic or acidic environments
- Silvershield CR coating is applied prior to assembly



Roller chain tools and accessories

EZ Breaker® roller chain breaker — TY16437

Compact, easy-to-use tool for cutting roller chain. Built to meet the demands of the shop, farm, or field truck.

Features:

- Cuts ANSI roller chain (sizes 35 through 100 and 2040 through 2060) with a simple pull of the handle:
 - No more grinding off pinheads
 - No more hammers and punches
 - No more ruined chain
- Precision die sets for each chain size are easily interchangeable — changing from one die set to another can be accomplished in just a few seconds

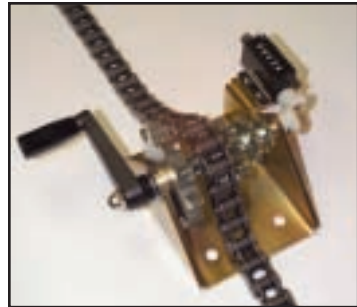


EZ Counter® roller chain link counter — PM55160

Count chain links the easy way with the EZ Counter roller chain link counter. Counts links on chain sizes from 35 to 80, including double strand. For extended pitch chain, divide the counter reading by two.

Features:

- Counts forward and reverse
- Adjustable tension for different chains
- May be mounted in a variety of positions
- Works with EZ Breaker roller chain breaker



Bulk chain EZ dispenser rack — TY26366

- Organizes chain inventory in your parts department or customer shops
- Easy accessibility — each reel rolls around to bench height
- Easy loading and unloading of chain reels
- Bulk chain rolls are placed on square bars with inside clutches so the bulk chain rolls do not unroll themselves
- Saves time



Roller chain extractor — AH19087, AH19088

- Easily detaches the required number of links from a roll of chain
- Prevents damage to the links



Pintle chain repair tool — TY3742

Quickly and easily repair pintle chain with pin widths ranging from 1 $\frac{1}{8}$ to 2 $\frac{1}{2}$ inches.

Features:

- Tool body is made of ductile iron, then heat-treated for extra strength
- Punches are made of alloy steel, then hardened for durability
- Remaining parts are made of high-carbon steel for toughness
- Assures proper alignment and gradual pressure on the pin, eliminating the possibility of damage to adjacent links
- Clamping cylinder serves as a portable vise to securely hold the pintle chain in position, while the connecting pin is centered directly under the long, hardened-steel punch of the tool — with just a few turns of the screw punch, the connecting pin can be pushed out completely



Steel chain detacher — J1480H

- Detaches the required number of links from a roll of chain
- Fits all sizes of steel chain
- Easily removes chain from implement while chain is still on the sprocket



U.S.-made bulk roller chain

Part number	Description	Pitch in. (mm)	Roller width in. (mm)
SW35X10US	35-1R coil, 10 ft. (3.05 m)	3/8 (9.53)	3/16 (4.76)
SW41X10US	41-1R coil, 10 ft. (3.05 m)	1/2 (12.70)	1/4 (6.35)
SW41X50US	41-1R reel, 50 ft. (15.24 m)	1/2 (12.70)	1/4 (6.35)
SW40X10US	40-1R coil, 10 ft. (3.05 m)	1/2 (12.70)	5/16 (7.94)
SW40X50US	40-1R, reel, 50 ft. (15.24 m)	1/2 (12.70)	5/16 (7.94)
SW40X100US	40-1R reel, 100 ft. (30.48 m)	1/2 (12.70)	5/16 (7.94)
SW50X10US	50-1R coil, 10 ft. (3.05 m)	5/8 (15.88)	3/8 (9.53)
SW50X50US	50-1R reel, 50 ft. (15.24 m)	5/8 (15.88)	3/8 (9.53)
SW50X100US	50-1R reel, 100 ft. (30.48 m)	5/8 (15.88)	3/8 (9.53)
SW50DX10US	50-2R coil, 10 ft. (3.05 m)	5/8 (15.88)	3/8 (9.53)
SW60X10US	60-1R coil, 10 ft. (3.05 m)	3/4 (19.05)	1/2 (12.70)
SW60X50US	60-1R reel, 50 ft. (15.24 m)	3/4 (19.05)	1/2 (12.70)
SW60X100US	60-1R reel, 100 ft. (30.48 m)	3/4 (19.05)	1/2 (12.70)
SW60DX10US	60-2R coil, 10 ft. (3.05 m)	3/4 (19.05)	1/2 (12.70)
SW60HX10US	60H-1R coil, 10 ft. (3.05 m)	3/4 (19.05)	1/2 (12.70)
SW60HX50US	60H-1R reel, 50 ft. (15.24 m)	3/4 (19.05)	1/2 (12.70)
SW60HX100US	60H-1R reel, 100 ft. (30.48 m)	3/4 (19.05)	1/2 (12.70)
SW60HDX10US	60H-2R coil, 10 ft. (3.05 m)	3/4 (19.05)	1/2 (12.70)
SW80X10US	80-1R coil, 10 ft. (3.05 m)	1 (25.40)	5/8 (15.88)
SW80X50US	80-1R reel, 50 ft. (15.24 m)	1 (25.40)	5/8 (15.88)
SW80DX10US	80-2R coil, 10 ft. (3.05 m)	1 (25.40)	5/8 (15.88)
SW80HX10US	80H-1R coil, 10 ft. (3.05 m)	1 (25.40)	5/8 (15.88)
SW80HDX10US	80H-2R coil, 10 ft. (3.05 m)	1 (25.40)	5/8 (15.88)
SW100X10US	100-1R coil, 10 ft. (3.05 m)	1 1/4 (31.75)	5/8 (15.88)
SW2040X10US	A2040 coil, 10 ft. (3.05 m)	1 (25.40)	5/8 (15.88)
SW2040X50US	A2040 reel, 50 ft. (15.24 m)	1 (25.40)	5/8 (15.88)
SW2050X10US	A2050 coil, 10 ft. (3.05 m)	1 1/4 (31.75)	5/8 (15.88)
SW2050X50US	A2050 reel, 50 ft. (15.24 m)	1 1/4 (31.75)	5/8 (15.88)

U.S.-made bulk roller chain

Part number	Description	Part number	Description
SW35X10US	35-1R, 10 ft.-coil	SW80X10US	80-1R, 10-ft. coil
SW35X50US	35-1R, 50 ft.-coil	SW80X50US	80-1R, 50-ft. reel
SW35COUS	35-1 S/C CO link	SW80COUS	80-1 S/C CO link
SW35OLUS	35-1 D/off link	SW80OLUS	80-1 D/off link
SW35RLUS	35 roller link	SW80RLUS	80 roller link
SW40X10US	40-1R coil, 10 ft. (3.05 m)	SW80DX10US	80-2R, 10-ft. coil
SW40X50US	40-1R reel, 50 ft. (15.24 m)	SW80DCOUS	80-2 S/C CO link
SW40X100US	40-1R, 100-ft. reel	SW80DOLUS	80-2 D/off link
SW40COUS	40-1 connector link	SW80HX10US	80H-1R, 10-ft. coil
SW40OLUS	40-1 offset link	SW80HCOUS	80H-1, S/C CO link
SW40RLUS	40 roller link	SW80HOLUS	80H-1 D/off link
SW41X10US	41-1R, 10-ft. coil	SW80HRLUS	80H roller link
SW41X50US	41-1R, 50-ft. reel	SW80HDX10US	80H-2R, 10-ft. coil
SW41COUS	41-1 S/C CO link	SW80HDOLUS	80H-2 D/off link
SW41OLUS	41-1 D/off link	SW80HDCOUS	80H-2 S/C CO link
SW41RLUS	41 roller link	SW100X10US	100-1R, 10-ft. coil
SW50X10US	50-1R, 10-ft. coil	SW100COUS	100H-1 S/C CO link
SW50X50US	50-1R, 50-ft. reel	SW100OLUS	100-1 D/off link
SW50X100US	50-1R, 100-ft. reel	SW120X10US	120-1R, 10-ft. coil
SW50COUS	50-1 S/C CO link	SW120COUS	120H-1 S/C CO link
SW50OLUS	50-1 D/off link	SW120OLUS	120-1 D/off link
SW50RLUS	50 roller link	SW120HX10US	120H-1R, 10-ft. coil
SW50DX10US	50-2R, 10-ft.coil	SW120HCOUS	120H-1 cottered CO link
SW50DX50US	50-2R, 10-ft. coil	SW120HOLUS	120H-1 D/off link
SW50DCOUS	50-2 S/C CO link	SW140X10US	140-1R, 10-ft. coil
SW50DOLUS	50-2 D/off link	SW140COUS	140-1 cottered CO link
SW60X10US	60-1R, 10-ft. coil	SW140OLUS	140-1 D/off link
SW60X50US	60-1R, 50-ft. reel	SW140HX10US	140H-1R, 10-ft. coil
SW60X100US	60-1R, 100-ft. reel	SW140HCOUS	140H-1 cottered CO link
SW60COUS	60-1 S/C CO link	SW140HOLUS	140H-1 D/off link
SW60OLUS	60-1 D/off link	SW160X10US	160-1R, 10-ft. coil
SW60RLUS	60 roller link	SW160COUS	160-1 cottered CO link
SW60DX10US	60-2R, 10-ft. coil	SW160OLUS	160-1 D/off link
SW60DCOUS	60-2 S/C CO link	SW160HX10US	160H-1R, 10-ft. coil
SW60DOLUS	60-2 D/off link	SW160HCOUS	160H-1 cottered CO link
SW60HX10US	60H-1R, 10-ft. coil	SW160HOLUS	160H-1 D/off link
SW60HX50US	60H-1R, 50-ft. reel	SW180X10US	180-1C, 10-ft. coil
SW60HX100US	60H-1R, 100-ft. reel	SW180COUS	180-1 cottered CO link
SW60HOLUS	60H-1 D/off link	SW180OLUS	180-1 D/off link
SW60HCOUS	60H-1 S/C CO link	SW200X10US	200-1C, 10-ft. coil
SW60HRLUS	60H roller link	SW200COUS	200-1 cottered CO link
SW60HDX10US	60H-2R, 10-ft. coil	SW200OLUS	200-1 D/off link
SW60HDOLUS	60H-2 D/off link	SW240X10US	240-1C, 10-ft. coil
SW60HDCOUS	60H-2 S/C CO link	SW240COUS	240-1 cottered CO link
		SW240OLUS	240-1 D/off link

U.S.-made nickel-plated bulk roller chain

Part number	Description
SW40N10US	40-1R, 10-ft. coil
SW40NCOUS	40-1 S/C CO link
SW40NOLUS	40-1 D/off link
SW50N10US	50-1R, 10-ft. coil
SW50NCOUS	50-1 S/C CO link
SW50NOLUS	50-1 D/off link
SW60N10US	60-1R, 10-ft. coil
SW60NCOUS	60-1 S/C CO link
SW60NOLUS	60-1 D/off link
SW80N10US	80-1R, 10-ft. coil
SW80NCOUS	80-1 cottered CO link
SW80NOLUS	80-1 D/off link
SW2040N10US	C2040, 10-ft. coil
SW2040NCOUS	C2040 S/C CO link
SW2040NOLUS	C2040 D/off link
SW2050N10US	C2050, 10-ft. coil
SW2050NCOUS	C2050 S/C CO link
SW2050NOLUS	C2050 D/off link
SW2060HN10US	C2060H, 10-ft. coil
SW2060HNCOUS	C2060H S/C CO link
SW2060HNOLUS	C2060H D/off link
SW2080HN10US	C2080H, 10-ft. coil
SW2080HNCOUS	C2080H cottered CO link
SW2080HNOLUS	C2080H D/off link

U.S.-made Silvershield CR bulk roller chain

Part number	Description
SW40C10US	40-1R, 10-ft. coil
SW40CCOUS	40-1 S/C CO link
SW40COLUS	40-1 D/off link
SW50C10US	50-1R, 10-ft. coil
SW50CCOUS	50-1 S/C CO link
SW50COLUS	50-1 D/off link
SW60C10US	60-1R, 10-ft. coil
SW60CCOUS	60-1 S/C CO link
SW60COLUS	60-1 D/off link
SW80C10US	80-1R, 10-ft. coil
SW80CCOUS	80-1 cotted CO link
SW80COLUS	80-1 D/off link
SW2040C10US	C2040, 10-ft. coil
SW2040CCOUS	C2040 S/C CO link
SW2040COLUS	C2040 D/off link
SW2050C10US	C2050, 10-ft. coil
SW2050CCOUS	C2050 S/C CO link
SW2050COLUS	C2050 D/off link
SW2060HC10US	C2060H, 10-ft. coil
SW2060HCCOUS	C2060H S/C CO link
SW2060HCOLUS	C2060H D/off link
SW2080HC10US	C2080H, 10-ft. coil
SW2080HCCOUS	C2080H cotted CO link
SW2080HCOLUS	C2080H D/off link

U.S.-made stainless steel bulk roller chain

Part number	Description
SW40S10US	40-1R, 10-ft. coil
SW40SCOUS	40-1 S/C CO link
SW40SOLUS	40-1 D/off link
SW50S10US	50-1R, 10-ft. coil
SW50SCOUS	50-1 S/C CO link
SW50SOLUS	50-1 D/off link
SW60S10US	60-1R, 10-ft. coil 304
SW60SCOUS	60-1 S/C CO link 304
SW60SOLUS	60-1 D/off link
SW80S10US	80-1R, 10-ft. coil
SW80SCOUS	80-1 cottered CO link
SW80SOLUS	80-1 D/off link
SW2040S10US	C2040, 10-ft. coil
SW2040SCOUS	C2040 S/C CO link
SW2040SOLUS	C2040 D/off link
SW2050S10US	C2050, 10-ft. coil
SW2050SCOUS	C2050 S/C CO link
SW2050SOLUS	C2050 D/off link
SW2060HS10US	C2060H, 10-ft. coil
SW2060HSCOUS	C2060H S/C CO link
SW2060HSOLUS	C2060H D/off link
SW2080HS10US	C2080H, 10-ft. coil
SW2080HSCOUS	C2080H cottered CO link
SW2080HSOLUS	C2080H D/off link

Imported bulk roller chain

Part number	Description
SWC35X10	35 roller chain, 10 ft.
SWC35X50	35 roller chain, 50 ft.
SWC35X100	35 roller chain, 100 ft.
SWC35CO	35 connector link
SWC35OL	35 offset link
SWC40X10	40 roller chain, 10 ft.
SWC40X50	40 roller chain, 50 ft.
SWC40X100	40 roller chain, 100 ft.
SWC40CO	40 connector link
SWC40OL	40 offset link
SWC40DX10	40 double-roller chain, 10 ft.
SWC40DCO	40 double-connector link
SWC40DOL	40 double-offset link
SWC41X10	41 roller chain, 10 ft.
SWC41X50	41 roller chain, 50 ft.
SWC41CO	41 connector link
SWC41OL	41 offset link
SWC50X10	50 roller chain, 10 ft.
SWC50X50	50 roller chain, 50 ft.
SWC50X100	50 roller chain, 100 ft.
SWC50CO	50 connector link
SWC50OL	50 offset link
SWC50DX10	50 double-roller chain, 10 ft.
SWC50DCO	50 double-connector link
SWC50DOL	50 double-offset link
SWC50HX10	50 heavy-roller chain, 10 ft.
SWC50HCO	50 heavy-connector link
SWC50HOL	50 heavy-offset link
SWC60X10	60 roller chain, 10 ft.
SWC60X50	60 roller chain, 50 ft.
SWC60X100	60 roller chain, 100 ft.
SWC60CO	60 connector link
SWC60OL	60 offset link
SWC60DX10	60 double-roller chain, 10 ft.
SWC60DX50	60 double-roller chain, 50 ft.
SWC60DCO	60 double-connector link
SWC60DOL	60 double-offset link
SWC60HX10	60 heavy-roller chain, 10 ft.
SWC60HX50	60 heavy-roller chain, 50 ft.
SWC60HCO	60 heavy-connector link
SWC60HOL	60 heavy-offset link

Part number	Description
SWC80X10	80 roller chain, 10 ft.
SWC80X50	80 roller chain, 50 ft.
SWC80CO	80 connector link
SWC80OL	80 offset link
SWC80DX10	80 double-roller chain, 10 ft.
SWC80DCO	80 double-connector link
SWC80DOL	80 double-offset link
SWC80HX10	80 heavy-roller chain, 10 ft.
SWC80HCO	80 heavy-connector link
SWC80HOL	80 heavy-offset link
SWC100X10	100 roller chain, 10 ft.
SWC100CO	100 connector link
SWC100OL	100 offset link
SWC2040X10	2040 extended-pitch roller chain, 10 ft.
SWC2040X50	2040 extended-pitch roller chain, 50 ft.
SWC2040X100	2040 extended-pitch roller chain, 100 ft.
SWC2040CO	2040 extended-pitch connector link
SWC2040OL	2040 extended-pitch offset link
SWC2050X10	2050 extended-pitch roller chain, 10 ft.
SWC2050X50	2050 extended-pitch roller chain, 50 ft.
SWC2050X100	2050 extended-pitch roller chain, 100 ft.
SWC2050CO	2050 extended-pitch connector link
SWC2050OL	2050 extended-pitch offset link
SWC2060X10	2060 extended-pitch roller chain, 10 ft.
SWC2060CO	2060 extended-pitch connector link
SWC2060OL	2060 extended-pitch offset link



JOHN DEERE
Genuine Parts and Service