



PRECISION CHAINS

Precision Chains Ltd.

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AMUSEMENT PARK CHAINS, SPROCKETS AND ACCESSORIES



60 YEARS OF MANUFACTURING EXCELLENCE



JOHN KING
GROUP COMPANY

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Over **65 years** of high quality British manufacturing and Engineering expertise. For assurance of best performance make the **Precision decision.**

FOR GUARANTEED QUALITY AND ASSURANCE IN PERFORMANCE **THE PERFECT DECISION IS PRECISION.**



Precision Chains Ltd have been producing Heavy Series and Special purpose chains **since 1957**. During this extended period the business has developed unrivalled experience in the manufacture and supply of chain solutions for amusement parks. From Roller Coasters to Water Rides Precision Chains offer a full spectrum of amusement Parks ride chains designed to minimise downtime and maximise safety.

Precision Chains have earned the best reputation for the production of chains employing best material specifications, heat treatment conditions and optimum construction. Precision Chains as a result offer unrivalled toughness, excellent fatigue life, best impact resistance and superior wear performance. It is fair to conclude that for guaranteed quality and assurance in performance **the perfect decision is Precision.**

Precision Chains, operating from Dudley in the heart of the United Kingdom operate best manufacturing techniques to maintain a balance between high quality and cost effectiveness. Precision Chains are the **only British manufacturer** producing Amusement park chains in the United Kingdom, thus maintaining total control of all aspects of production within the dictates of the company quality management system.

- ✓ BS ISO 9001:2015 certified.
- ✓ Ongoing tensile and proof-testing of chains conducted in-house with periodical testing by independent NAMAS approved laboratories.
- ✓ Chains calibrated to guarantee pitch tolerances are maintained. An essential consideration in twin strand operation.
- ✓ Consistency assured with ongoing material and heat treatment verification in our in house laboratory.
- ✓ Highly respected documentation procedures for verifying raw material quality, dimensional consistency and ongoing heat treatment conformity.
- ✓ In-house and independent periodical calibration of measuring equipment.
- ✓ Best manufacturing techniques for high speed and accurate component production.
- ✓ Standard production specifications are uprated to surpass all competitor's premier standards or enhanced breaking load chains.
- ✓ Precision technicians are on hand to advise on chain selections for uprating chain performance in existing and new applications.

The acquisition of Precision Chains by the John King group in 2021 brought together two World leaders in chain manufacturing to create a unique capability in delivering cost effective solutions through innovation, proficiency, reliability, best service and customer care. To secure optimum performance and cost effective solutions **the perfect decision is Precision.**



WELDED STEEL TYPE LIFT CHAINS



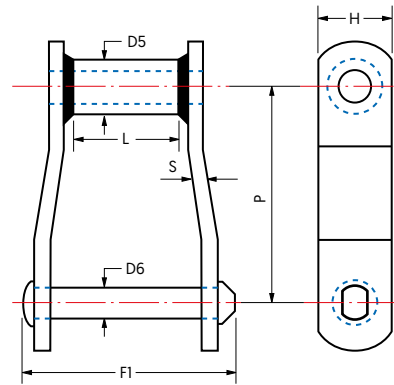
LUBRICANTS THAT CAN BE USED



JK G1315M
Assembly Grease

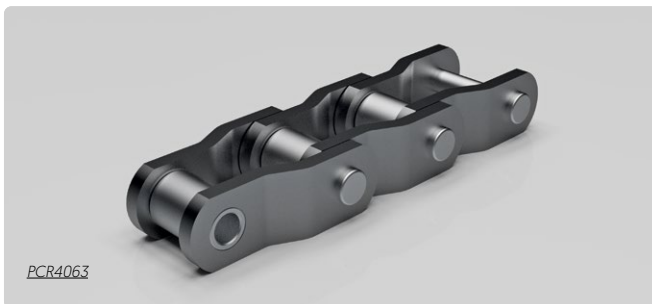


JK O1419
High Load Chain Oil



Chain Number	P Pitch [inches]	D5 Bushings Outside Diameter [inches]	D6 Pins Diameter [inches]	F1 Pins Length [inches]	L Between Sidebars [inches]	S Sidebars Thickness [inches]	H Sidebars Height [inches]	Working Load [lbs]	Average Tensile Strength [lbs]	Average Weight [lbs/ft]
WH82/R	3.075	1.219	0.563	3.219	1.750	0.250	1.250	4,400	37,500	5.60
WH124/R	4.000	1.438	0.750	4.188	2.063	0.375	1.500	7,350	60,000	8.50
WH124/HD/R	4.063	1.625	0.875	4.670	2.000	0.500	2.000	9,150	114,500	13.64
WH126/R	4.080	1.750	1.000	4.703	2.000	0.500	2.000	10,500	101,000	14.30
WH126/HD/R	4.080	1.750	1.000	4.578	2.000	0.500	2.250	10,500	140,000	15.60
WH132/R	6.050	1.750	1.000	5.953	3.375	0.500	2.000	14,500	100,000	13.50
WH132/HD/R	6.050	1.750	1.000	6.172	3.375	0.500	2.000	15,300	138,500	13.50
WH855/HD/R	6.050	1.750	1.125	6.156	3.313	0.563	2.500	17,450	205,000	14.50

CRANK LINK ROLLER LIFT CHAINS



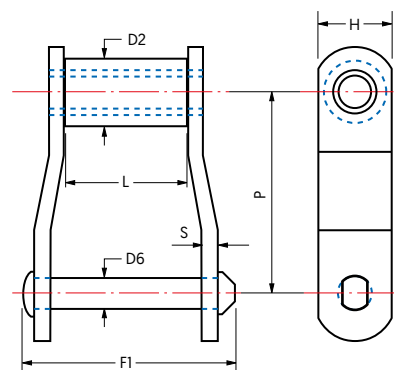
LUBRICANTS THAT CAN BE USED



JK G1315M
Assembly Grease



JK O1419
High Load Chain Oil

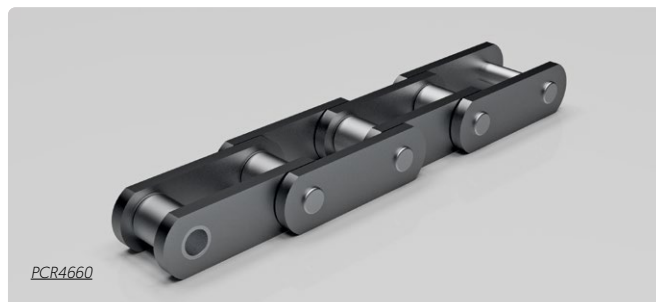


Chain Number	P Pitch [inches]	D2 Roller Outside Diameter [inches]	D6 Pins Diameter [inches]	F1 Pins Length [inches]	L Between Sidebars [inches]	S Sidebars Thickness [inches]	H Sidebars Height [inches]	Working Load [lbs]	Average Tensile Strength [lbs]	Average Weight [lbs/ft]
PCR4063	4.063	1.750	0.875	4.453	1.938	0.500	2.250	9,000	150,000	15.40
PCR4073	4.073	1.781	0.938	4.590	2.062	0.500	2.375	10,500	170,000	15.60
PCR4080	4.080	1.750	0.875	4.710	1.938	0.500	2.250	9,000	140,000	15.50
PCR6050	6.050	1.750	0.875	6.047	3.375	0.500	2.000	13,400	110,000	15.50

Option oil hole through chain bushing available as special production.
Suffix references with OH [oil hole].

Optional grease lubrication facility available as special production.
Suffix reference with GL [grease lubrication].

STRAIGHT SIDEBAR ROLLER LIFT CHAINS



PCR4660

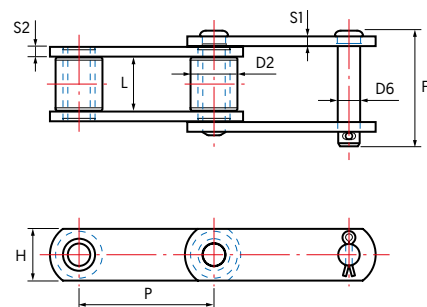
LUBRICANTS THAT CAN BE USED



JK G1315M
Assembly Grease



JK O1419
High Load Chain Oil



Chain Number	P Pitch [inches]	D2 Roller Outside Diameter [inches]	D6 Pins Diameter [inches]	F1 Pins Length [inches]	L Between Sidebars [inches]	S1 Sidebars Thickness [inches]	S2 Sidebars Thickness [inches]	H Sidebars Height [inches]	Working Load [lbs]	Average Tensile Strength [lbs]	Average Weight [lbs/ft]
PCR4660	4.760	1.750	0.948	4.484	1.950	0.551	0.500	2.374	14,450	170,000	15.65
PCR4769	6.300	1.500	1.750	8.071	3.000	0.750	NA	4.750	48,000	385,000	54.25

Optional grease lubrication facility available as special production.
Suffix reference with GL (grease lubrication).

STEEL BUSHED LIFT CHAINS



JKB100

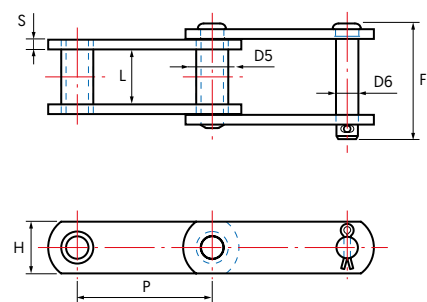
LUBRICANTS THAT CAN BE USED



JK G1315M
Assembly Grease



JK O1419
High Load Chain Oil



Chain Number	P Pitch [inches]	D5 Bushing Outside Diameter [inches]	D6 Pins Diameter [inches]	F1 Pins Length [inches]	L Between Sidebars [inches]	S Sidebars Thickness [inches]	H Sidebars Height [inches]	Working Load [lbs]	Average Tensile Strength [lbs]	Average Weight [lbs/ft]
JKB102 1/2	4.040	1.375	0.750	4.313	2.188	0.375	1.750	7,900	70,000	9.200
JKB2589	4.040	1.500	1.000	4.055	2.283	0.350	2.560	7,900	70,000	13.650
JKB6099	4.040	1.375	0.875	4.270	2.250	0.375	2.000	9,200	72,000	10.700
JKB100	4.040	1.375	0.875	4.125	2.250	0.375	2.250	9,200	110,000	12.170
JKB440	4.040	1.500	1.000	3.188	1.375	0.375	2.500	7,400	97,000	12.300
JKB111	4.760	1.438	0.750	4.660	2.620	0.375	2.000	9,300	50,000	11.200
JKB4711	5.906	2.376	1.500	7.000	3.874	0.787	3.543	25,000	250,000	34.66
JKB6050	6.050	1.750	1.000	5.703	3.125	0.500	3.000	14,400	177,000	19.400

Optional oil hole through the bushing alternatively grease lubrication facility available as special production.
Suffix reference with OH (oil hole) alternatively GL (grease lubrication).

STEEL BUSHED WATER RIDE CHAINS

Continuous operation in water requires special considerations in order to combat the impact of chain operation in corrosive environments. The Ivanhoe water ride series chain has been developed to enhance performance in this challenging environment to overcome the impact of corrosion, chain seizure and component wear.

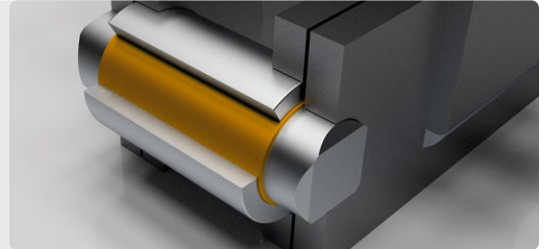
CORROSION

In considering constant exposure to water with chemical addition for algal control, corrosion is an issue on water ride chains. With the benefit of long experience Precision chains has developed a dual process surface treatment to increase corrosion resistance.

The zinc based high integrity coating offers superior protection combined with PC802 topcoat designed to enhance the anticorrosion properties of trivalent chromium passivates on zinc and zinc alloys in submerged water environments. Even when the coating is penetrated, the treatment continues to offer superior corrosion resistance.

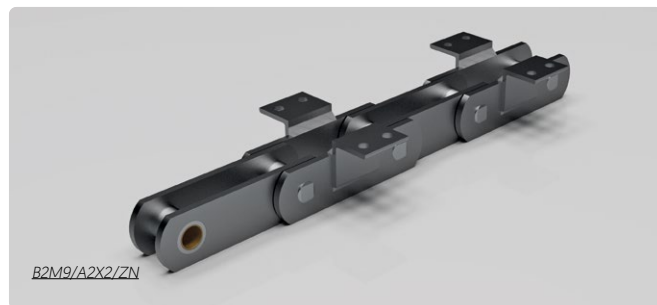
ELIMINATING SEIZURE

The challenging environment encountered in Transfer and Lift chain on rides can create pin and bush seizure which in turn significantly shortens the life of the chain. Long experience has seen the development of a polymeric sleeve to act as a low friction and lubrication free bearing element thus eliminating metal to metal contact.



REDUCING WEAR

The water ride chains conform to British Standard series BS4116 which has traditionally employed a thin walled bush. Recognising that the component could be improved Precision Chains have introduced a heavy wall bush design which overcomes premature wear and failure.

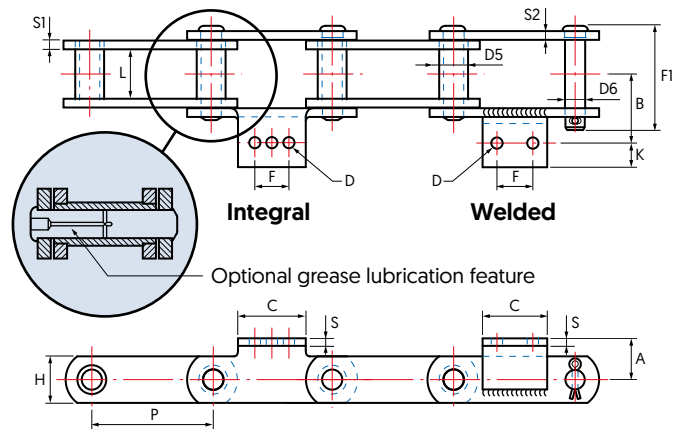


LUBRICANTS THAT CAN BE USED



JKG1436M

Long Life Grease with Moly
USED IN CONJUNCTION WITH GREASE LUBRICATION FACILITY

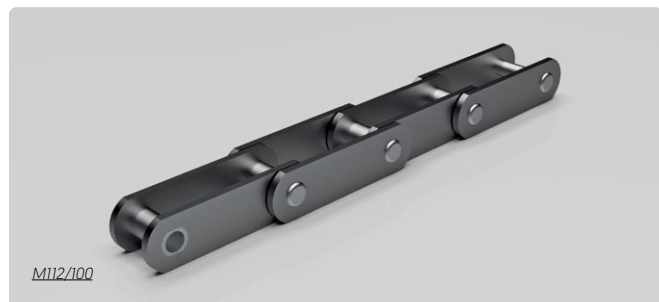


Chain Number	P Pitch [inches]	D5 Bushings Outside Diameter [inches]	D6 Pins Diameter [inches]	F1 Pins Length [inches]	L Between Sidebars [inches]	S1 Sidebars Thickness [inches]	S2 Sidebars Thickness [inches]	H Sidebars Height [inches]	Working Load [lbs]	Average Tensile Strength [lbs]	Average Weight [lbs/ft]
B16G9/A3X2/ZN	4.000	0.940	0.750	2.330	0.830	0.190	0.190	1.500	3,400	16,000	4.800
B2M9/A2X2/ZN	6.000	1.500	1.000	4.280	1.500	0.375	0.375	2.500	8,350	55,000	12.100
B24M9/A2X2/ZN	6.000	1.500	1.000	4.172	1.500	0.500	0.375	2.500	9,200	116,000	14.200
PC4665/A2X2/ZN	6.300	1.732	1.260	6.378	2.795	0.472	0.472	2.756	13,700	137,000	21.000

Chain Number	Attachment	B [inches]	K [inches]	S [inches]	D [inches]	A [inches]	F [inches]	C [inches]
B16G9/A3X2/ZN	Integral	1.750	0.730	0.190	0.420	1.250	1.250	2.620
B2M9/A2X2/ZN	Welded	2.870	0.730	0.375	0.546	2.000	1.500	2.750
B24M9/A2X2/ZN	Welded	3.375	1.328	0.375	0.781	2.250	1.750	3.500
PC4665/A2X2/ZN	Welded	3.700	1.831	0.394	0.512	2.560	6.378	4.331

EUROPEAN STANDARD LIFT CHAINS

ISO 1977 (M SERIES) DIN 8167



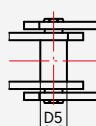
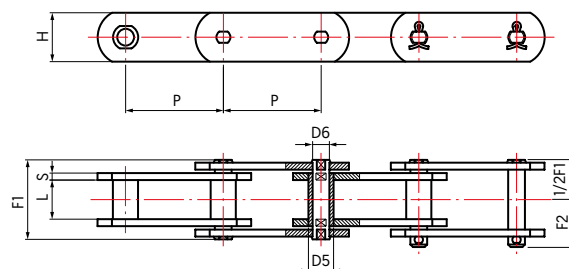
LUBRICANTS THAT CAN BE USED



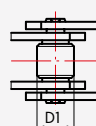
JK G1315M
Assembly Grease



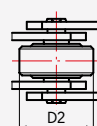
JK O1419
High Load Chain Oil



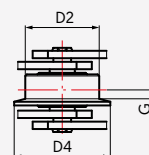
Type A



Type B



Type C



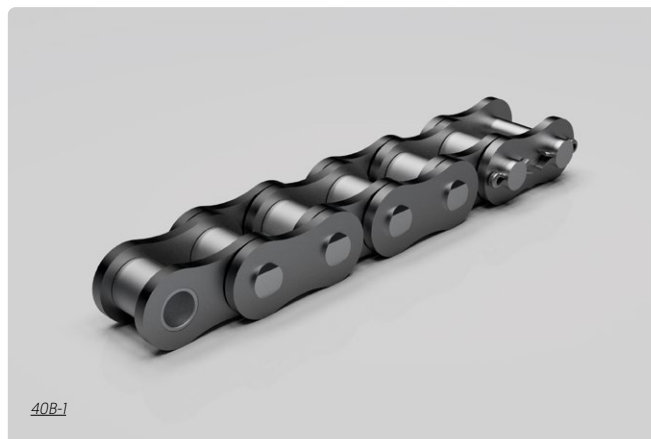
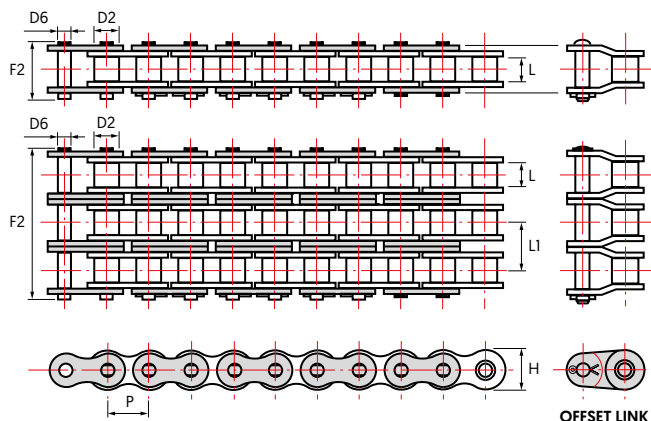
Type D



Chain Number	P Pitch	D1 Rollers Type B	D2 Rollers Type C	D4 Rollers Type D	G Flange thickness	D5 Bushings Diameter	D6 Pins	F1 Over All Pin & Cotter	F2	L Between Sidebars	S Sidebars Thickness	H Sidebars Height	Breaking Load DIN standard	Breaking Load Precision Chains*
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[kN]	[kN]
M112	80	30	60	75	7.5	21	15	66	35	32	6	40	112	175
M112	100	30	60	75	7.5	21	15	66	35	32	6	40	112	175
M112	125	30	60	75	7.5	21	15	66	35	32	6	40	112	175
M112	160	30	60	75	7.5	21	15	66	35	32	6	40	112	175
M112	200	30	60	75	7.5	21	15	66	35	32	6	40	112	175
M160	100	36	70	90	8.5	25	18	72	43	37	7	50	160	260
M160	125	36	70	90	8.5	25	18	72	43	37	7	50	160	260
M160	160	36	70	90	8.5	25	18	72	43	37	7	50	160	260
M160	200	36	70	90	8.5	25	18	72	43	37	7	50	160	260
M160	250	36	70	90	8.5	25	18	72	43	37	7	50	160	260
M224	125	42	85	100	10	30	21	88	47	43	8	60	224	340
M224	160	42	85	100	10	30	21	88	47	43	8	60	224	340
M224	200	42	85	100	10	30	21	88	47	43	8	60	224	340
M224	250	42	85	100	10	30	21	88	47	43	8	60	224	340
M224	315	42	85	100	10	30	21	88	47	43	8	60	224	340
M315	160	50	100	120	12	36	25	102	55	48	10	70	315	520
M315	200	50	100	120	12	36	25	102	55	48	10	70	315	520
M135	250	50	100	120	12	36	25	102	55	48	10	70	315	520
M315	315	50	100	120	12	36	25	102	55	48	10	70	315	520
M315	400	50	100	120	12	36	25	102	55	48	10	70	315	520

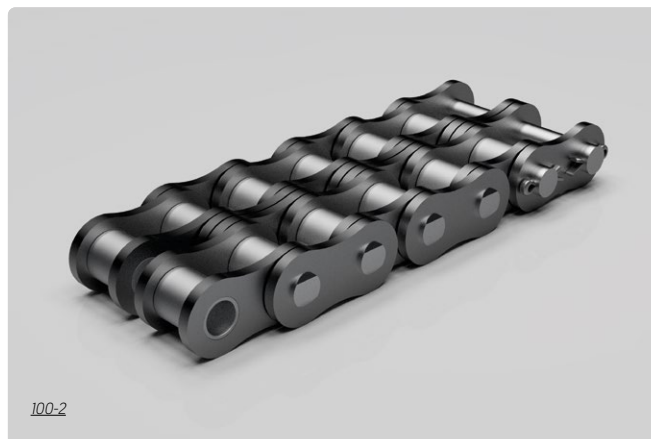
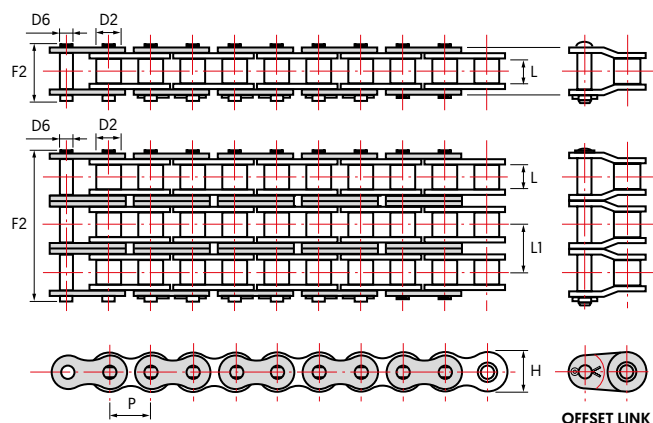
* Breaking Load with heat treated Plates.
This is for guidance Only. Additional sizes according to FV standard DIN8165 and variations on both series are available.
Contact Precision Chain Technical for further clarification.

BRITISH STANDARD ROLLER CHAINS



Chain Number	P Pitch [mm]	D2 Rollers Outside Diameter [mm]	D6 Pins Diameter [mm]	F2 Over All Pin & Cotter [mm]	H Sidebars Height [mm]	L Between Sidebars [mm]	L1 Transverse pitch [mm]	Tensile Strength [N]	Weight [kg/m]
04B-1	6.00	4.00	1.85	10.30	5.00	2.80	—	3,000	0.12
05B-1	8.00	5.00	2.31	11.70	7.10	3.00	—	5,000	0.10
06B-1*	9.53	6.35	3.26	16.78	8.26	5.72	—	8,940	0.45
06B-2*	9.53	6.35	3.26	27.10	8.26	5.72	10.24	16,946	0.80
06B-3*	9.53	6.35	3.26	37.31	8.26	5.72	10.24	24,908	1.18
08B-1	12.70	8.51	4.45	20.90	11.80	7.75	—	17,836	0.68
08B-2	12.70	8.51	4.45	34.90	11.80	7.75	13.92	31,180	1.31
08B-3	12.70	8.51	4.45	47.80	11.80	7.75	13.92	44,524	1.94
81-1	12.70	7.75	3.64	11.70	9.91	3.30	—	8,000	0.28
83-1	12.70	7.75	3.64	13.10	9.91	4.88	—	8,000	0.38
10B-1	15.87	10.20	5.08	23.70	14.70	9.65	—	22,240	0.95
10B-2	15.87	10.20	5.08	40.30	14.70	9.65	16.60	44,524	1.87
10B-3	15.87	10.20	5.08	56.90	14.70	9.65	16.60	66,764	2.80
12B-1	19.05	12.07	5.72	27.31	16.10	11.68	—	28,912	1.19
12B-2	19.05	12.07	5.72	46.31	16.10	11.68	19.50	57,868	2.34
12B-3	19.05	12.07	5.72	66.29	16.10	11.68	19.50	86,780	3.47
16B-1	25.40	15.88	8.28	41.50	21.10	17.02	—	56,889	2.72
16B-2	25.40	15.88	8.28	73.41	21.10	17.02	31.88	113,735	5.37
16B-3	25.40	15.88	8.28	105.30	21.10	17.02	31.88	170,625	8.02
20B-1	31.75	19.05	10.19	49.30	26.42	19.56	—	93,141	3.88
20B-2	31.75	19.05	10.19	85.80	26.42	19.56	36.45	176,496	7.66
20B-3	31.75	19.05	10.19	122.20	26.42	19.56	36.45	264,744	11.44
24B-1	38.10	25.40	14.60	59.99	33.40	25.40	—	166,711	6.85
24B-2	38.10	25.40	14.60	108.40	33.40	25.40	48.36	317,721	13.87
24B-3	38.10	25.40	14.60	156.80	33.40	25.40	48.36	475,580	20.89
28B-1	44.45	27.94	15.90	65.10	37.00	30.99	—	200,000	8.56
28B-2	44.45	27.94	15.90	124.70	37.00	30.99	59.56	360,000	16.96
28B-3	44.45	27.94	15.90	184.30	37.00	30.99	59.56	536,000	25.38
32B-1	50.80	29.21	17.80	67.40	42.20	30.99	—	250,000	9.49
32B-2	50.80	29.21	17.80	126.00	42.20	30.99	58.55	443,896	18.74
32B-3	50.80	29.21	17.80	184.50	42.20	30.99	58.55	670,000	28.04
40B-1	63.50	39.37	22.89	92.50	52.90	38.10	—	352,299	15.53
40B-2	63.50	39.37	22.89	151.21	52.90	38.10	72.29	630,000	30.72
40B-3	63.50	39.37	22.89	223.80	52.90	38.10	72.29	950,000	45.97
48B-1	76.20	48.26	29.24	98.88	64.00	45.72	—	560,000	24.45
48B-2	76.20	48.26	29.24	200.00	64.00	45.72	91.21	1,096,041	48.54
48B-3	76.20	48.26	29.24	291.00	64.00	45.72	91.21	1,500,000	72.67

AMERICAN STANDARD ROLLER CHAINS

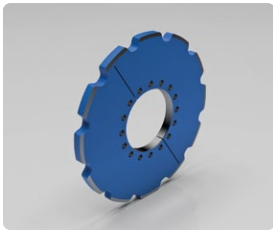


Chain Number	P Pitch [in]	D2 Rollers Outside Diameter [in]	D6 Pins Diameter [in]	F2 Over All Pin & Cotter [in]	H Sidebars Height [in]	L Between Sidebars [in]	L1 Transverse pitch [in]	Tensile Strength [N]	Weight [kg/m]
25-1*	0.250	0.130	0.090	0.370	0.236	0.125	–	3,892	0.13
25-2*	0.250	0.130	0.090	0.630	0.236	0.125	0.252	7,784	0.24
35-1*	0.375	0.200	0.141	0.560	0.354	0.188	–	9,341	0.31
35-2*	0.375	0.200	0.141	0.960	0.354	0.188	0.399	18,683	0.67
35-3*	0.375	0.200	0.141	1.360	0.354	0.188	0.399	28,024	1.01
40-1	0.500	0.312	0.156	0.720	0.472	0.313	–	17,792	0.61
40-2	0.500	0.312	0.156	1.290	0.472	0.313	0.566	35,584	1.19
40-3	0.500	0.312	0.156	1.850	0.472	0.313	0.566	56,376	1.79
41-1	0.500	0.306	0.141	0.650	0.390	0.250	–	10,675	0.39
50-1	0.625	0.400	0.200	0.890	0.594	0.375	–	29,356	1.01
50-2	0.625	0.400	0.200	1.600	0.594	0.375	0.713	58,713	1.96
50-3	0.625	0.400	0.200	2.310	0.594	0.375	0.713	88,070	2.95
50-4	0.625	0.400	0.200	3.030	0.594	0.375	0.713	117,427	3.93
60-1	0.750	0.469	0.234	1.110	0.709	0.500	–	37,808	1.47
60-2	0.750	0.469	0.234	2.010	0.709	0.500	0.897	75,616	2.9
60-3	0.750	0.469	0.234	2.910	0.709	0.500	0.897	113,424	4.29
60-4	0.750	0.469	0.234	3.810	0.709	0.500	0.897	151,232	5.8
80-1	1.000	0.625	0.312	1.440	0.945	0.625	–	64,446	2.57
80-2	1.000	0.625	0.312	2.590	0.945	0.625	1.153	128,992	5.04
80-3	1.000	0.625	0.312	3.740	0.945	0.625	1.153	193,488	7.47
100-1	1.250	0.750	0.375	1.730	1.181	0.750	–	106,752	3.73
100-2	1.250	0.750	0.375	3.140	1.181	0.750	1.408	213,504	7.31
100-3	1.250	0.750	0.375	4.560	1.181	0.750	1.408	320,256	11.01
120-1	1.500	0.875	0.437	2.140	1.406	1.000	–	151,232	5.49
120-2	1.500	0.875	0.437	3.930	1.406	1.000	1.789	302,464	10.94
120-3	1.500	0.875	0.437	5.720	1.406	1.000	1.789	453,696	16.52
140-1	1.750	1.000	0.500	2.310	1.663	1.000	–	172,400	7.450
140-2	1.750	1.000	0.500	4.240	1.663	1.000	1.924	344,800	14.390
140-3	1.750	1.000	0.500	6.160	1.663	1.000	1.924	517,200	21.320
160-1	2.000	1.125	0.562	2.730	1.899	1.250	–	226,800	9.740
160-2	2.000	1.125	0.562	5.040	1.899	1.250	2.305	453,600	19.120
160-3	2.000	1.125	0.562	7.350	1.899	1.250	2.305	680,400	28.370
180-1	2.250	1.406	0.687	3.150	2.132	1.406	–	280,200	13.510
180-2	2.250	1.406	0.687	5.750	2.132	1.406	2.592	560,500	26.340
200-1	2.500	1.562	0.781	3.440	2.312	1.500	–	353,800	15.880
200-2	2.500	1.562	0.781	6.260	2.312	1.500	2.817	707,600	32.050

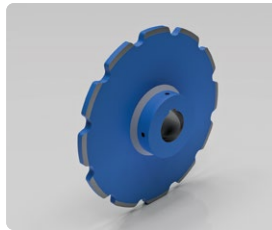
SPROCKETS

Tooth form incorporates John King's unique profile allowing for increased gap angle and bottom line clearance for smoother chain interaction and reduced wear.

Material options: • BS970 080M40 [equivalent AISI1045] Carbon steel suitable • BS709M40 [equivalent AISI 4140] Alloy steel [Both options suitable for surface hardening to 550Bnh at a minimum effective depth of 3 mm] • BS EN 10025 S355J2 High strength steel • Other material options available on request.



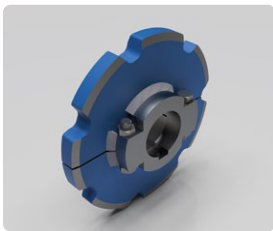
Type A – segmental construction



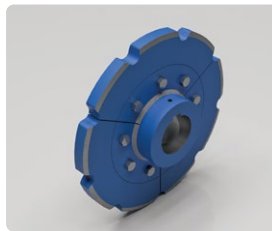
Type B – solid construction



Type C – solid construction



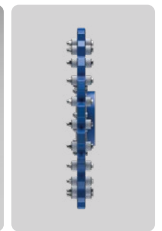
Type TS – split construction



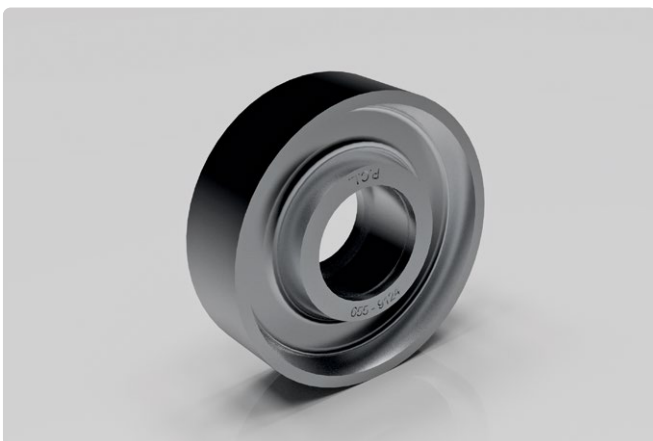
Type CS – segmental construction



Type NR – unique roller design for silent running



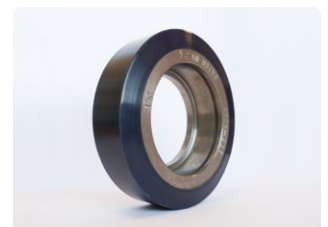
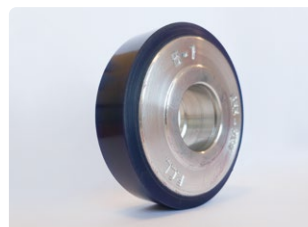
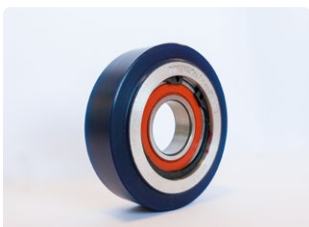
AMUSEMENT RIDE WHEELS



Precision have long experience in the manufacture and supply of wheels with polyurethane or plain treads. Optimum material selections ensure rollers withstand high loads and speeds. Superior abrasion and deformation resistance is ensured with a consistent hardness range of 80-95 shore.

This enables the Company to offer a comprehensive range of original equipment and replacement wheels within the Amusement parks including:

- ✓ Load wheels, ✓ Guide wheels,
- ✓ Upstop wheels, ✓ Flume wheels.





CERTIFICATE OF REGISTRATION

This is to certify that the management system of:

Precision Chains Ltd

Main Site: Clee Road, Dudley, West Midlands, DY2 0YG, United Kingdom

has been registered by Intertek as conforming to the requirements of:

ISO 9001:2015

The management system is applicable to:

The manufacture, procurement, inspection, re-conditioning and supply of conveying chains and their related supporting component, including other related processes of press work, manufacturing, machining, assembly, fabrication and inspection.

Certificate Number:

0156142

Initial Certification Date:

01 October 1993

Date of Certification Decision:

08 September 2023

Issuing Date:

08 September 2023

Valid Until:

30 September 2026



intertek



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Calin Moldovean

President, Business Assurance

Intertek Certification Limited, 10A Victory Park,
Victory Road, Derby DE24 8ZF, United Kingdom

Intertek Certification Limited is a UKAS
accredited body under schedule of
accreditation no. 014.



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THE PERFECT LINK



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