OCM Roller Chain Checkpoints

1. Checkpoints

Condition	Checkpoints
Check the operating condition visually and make sure there is no abnormal condition	1. Abnormal noise 2. Chain vibration 3. Chain riding on the sprocket 4. Chain winding around the sprocket 5. Kinks or stiff bending of chain 6. Amount and state of lubrication 7. Contact between chain and case
Stop operation and check each portion of chain and sprocket in details	1. Chain appearance. Check for dirt, corrosion damage on the outside surface of the roller, contact marks, etc. Also check the inside edge and surfaces of the link plates and the surface edges of the pins 2. Damage on the sprocket tooth surfaces a inside surface teeth and engaging areas 3. Check scratch, crack or bending of plates as needed 4. Check scratch, crack or abnormal rotation of roller as needed 5. Remove connecting link and check appearance and wear condition as needed 6. Measure the wear stretch of roller chain

2. Maintenance process

- Maintenance shall be conducted with roller chain stretched for some level in order to remove the play of overall chain.
- Check both edge (on same side) of pin.
- Consider to check multiple strands of chain as same as single strand.
- Usable limit due to stretched chain varies depending on the number of tooth of sprocket, but as a protection the limit is 1.5% against standard length. If the number of tooth is large, use following corrective limit.
  Number of tooth of large sprocket : 60 to 80T, Stretch limit - 1.2%
  Number of tooth of large sprocket : 81 to 100T, Stretch limit - 1.0%
  Number of tooth of large sprocket : Over 101T, Stretch limit - 0.8%
- Calculate the judgement length (L) upon measuring inside (L1) and outside (L2) between rollers of the measuring number of links.