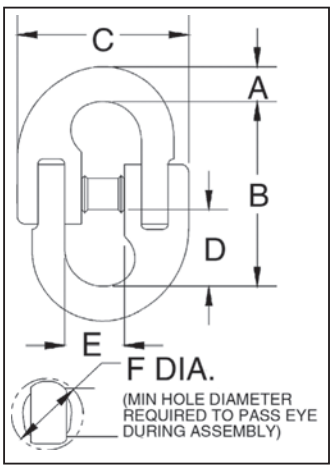
Crosby® Connecting Links

A-336
Connecting Link

- Forged Alloy Steel - Quenched and Tempered.
- Individually Proof Tested at 2-1/2 times the Working Load Limit with certification.
- Easy to assemble - see instructions on page 276.



A-336 LOK-A-LOY® 6 Connecting Link

Chain Size (in.)	A-336 Stock No.	Working Load Limit (lbs.)*	Weight Each (lbs.)	Dimensions (in.)					Diameter of Hole to Accept Link (in.)
				A	B	C	D	E	
1/4	1014397	3250	.24	.31	2.06	1.69	.78	.78	.50
3/8	1014413	6600	.58	.45	2.72	2.31	1.06	1.09	.66
1/2	1014431	11300	1.20	.58	3.34	3.16	1.28	1.41	.88
5/8	1014459	16500	2.42	.78	3.91	3.94	1.56	1.69	1.06
3/4	1014477	23000	3.89	.89	4.84	4.44	1.97	2.00	1.19
7/8	1014495	28750	6.08	1.00	5.81	5.31	2.38	2.12	1.38
1	1014510	38750	7.03	1.08	6.48	6.07	2.84	2.55	1.47
1-1/4	1014538	57500	13.20	1.38	8.48	7.65	3.77	3.77	1.73

* Ultimate Load is 4 times the Working Load Limit.

The WLL of the A-336 is less than Grade 80 chain ratings. When using in Grade 80 chain slings, ASME B30.9c requires that the Working Load Limit of a sling must not exceed the lowest Working Load Limit of the components in the system.

Alloy Fittings Application and Information

HOW TO ASSEMBLE AN S-1325 COUPLER LINK ONTO MASTER LINK

1. Slide Coupler Link over Engineered Flat of Master Link.

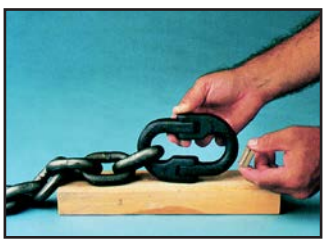
2. Rotate Coupler Link so that clevis fitting is to the outside of Master Link and attach to chain sling.

HOW TO ASSEMBLE A CROSBY CLEVIS TYPE FITTING

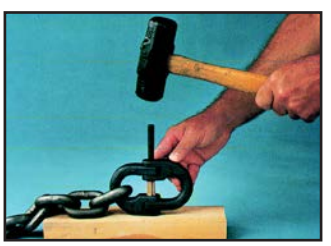
1. Place chain link into clevis of chain coupler. Insert pin fully into the clevis ears.

2. Place the coupler link on its side and using a hammer, drive the locking pin into the clevis ear until it is flush with the outside surface.

HOW TO ASSEMBLE A LOK-A-LOY® CONNECTING LINK



1. Place the locking sleeve between the assembled half link forgings.



2. Drive the pin through the assembled link ends and sleeve until the end of the pin is flush with the outside of the connecting link halves.

HOW TO ASSEMBLE LOAD PIN IN CROSBY ELIMINATOR® FITTINGS

1. Place both chain links into clevis slots of fitting, insert pin fully into the two-leg clevis.

2. Place Eliminator assembly on a firm surface. Using a hammer, drive the locking pin into the two-leg clevis until it is flush with the top of the hole.

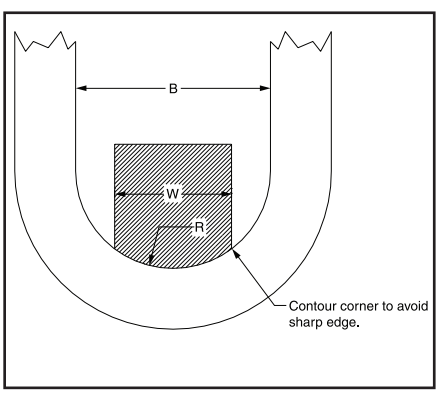


Figure 1

Crosby master links and master link assemblies are proof tested with special fixtures in accordance with ASTM A952. While other specifications such as EN 1677-4 and AWRF Recommended Guideline for Proof Test Procedures for Slings related to master link and master link assemblies also allow for the use of special fixtures when proof testing, Crosby follows the guidelines set forth in ASTM A952. The purpose of the special fixture is to prevent localized point loading during the proof test. Point loading at the proof test load may result in permanent deformation. The proof test fixture per ASTM A952 allows for a maximum fixture width (W) of 60% of the inside width (B) of the master link. The radius of the fixture (R) is one-half of inside width of the master link. A sketch showing an example of the special fixture is shown in Figure 1. Note that the corner of the fixture should be contoured so that a sharp edge does not make contact with the master link during the loaded condition.

Over the years some master links and master link assemblies have changed dimensions and working load limits. Special consideration should be given to the actual inside width of the master link being tested and its correct allowable proof load value. If the correct allowable proof load value is in question, then Crosby Engineering should be consulted for the appropriate proof load value.