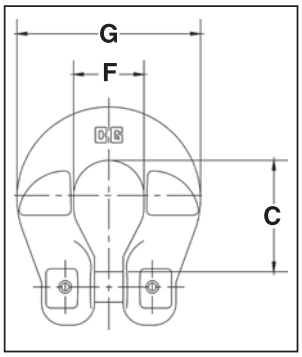
Crosby® Grade 100 Chain Fittings

S-1325A
Chain Coupler

- Designed to connect Grade 100 chain fittings produced with "Engineered Flat" to Grade 100 chain.
- Forged Alloy Steel - Quenched and Tempered.
- Suitable for use with Grade 100 and Grade 80 chain.
- Individually Proof Tested to 2-1/2 times the Working Load Limit with certification.
- Locking system that provides for simple assembly and disassembly – no special tools required.
- Fatigue rated at 1-1/2 times the Working Load Limit at 20,000 cycles.
- "Look for the Platinum Color – Crosby Grade 100 Alloy Products."



Crosby 8/10™ "QT" Fatigue Rated

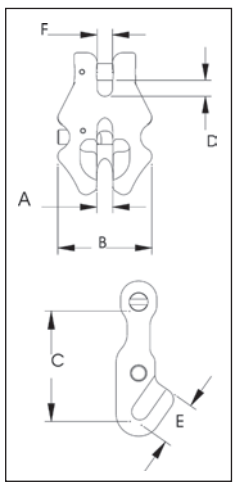
S-1325A Grade 100 Chain Coupler

Chain Size (in.)	Chain Size (mm)	S-1325A Stock No.	Working Load Limit (lbs.)*	Weight Each (lbs.)	Dimensions (in.) C	F	G
-	6	1098496	3200	.25	1.03	.74	1.74
1/4	7	1098500	4300	.50	1.41	.88	2.32
5/16	8	1098504	5700	.50	1.40	.88	2.32
3/8	10	1098508	8800	.80	1.84	1.18	2.72
1/2	13	1098512	15000	1.70	2.12	1.50	3.62
5/8	16	1098516	22600	1.90	2.84	1.96	4.40

* Minimum Ultimate Load is 4 times the Working Load Limit.

S-1311N
Chain Shortener Link

- Alloy Steel - Quenched and Tempered.
- Individually Proof Tested to 2-1/2 times the Working Load Limit with certification.
- Suitable for use with Grade 100 and Grade 80 chain.
- Spring loaded chain locking system keeps chain in place under slack conditions.
- The use of S-1311N Chain Shortener will allow 100 percent of the chain sling capacity.
- Fatigue rated at 1-1/2 times the Working Load Limit at 20,000 cycles.
- "Look for the Platinum Color - Crosby Grade 100 Alloy Products."



Crosby 8/10™ "QT" Fatigue Rated

S-1311N Grade 100 Chain Shortener Link

Chain Size (in.)	Chain Size (mm)	S-1311N Stock No.	Working Load Limit (lbs.)*	Weight Each (lbs.)	Dimensions (in.) A	B	C	D	E	F
-	6	1017860	3200	.49	.30	1.76	1.83	.29	.76	.29
1/4	7	1017869	4300	.84	.34	2.04	2.17	.34	.88	.33
5/16	8	1017878	5700	1.22	.40	2.36	2.53	.39	1.01	.38
3/8	10	1017897	8800	2.03	.48	2.84	3.07	.48	1.23	.46
1/2	13	1017906	15000	4.31	.62	3.56	3.77	.61	1.57	.59
5/8	16	1017915	22600	7.20	.73	4.24	4.64	.73	1.91	.70

* Minimum Ultimate Load is 4 times the Working Load Limit.

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.

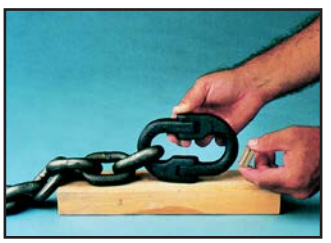
2. Rotate Coupler Link so that clevis fitting is to the outside of Master Link and attach to chain sling.

HOW TO ASSEMBLE A CROSBY CLEVIS TYPE FITTING

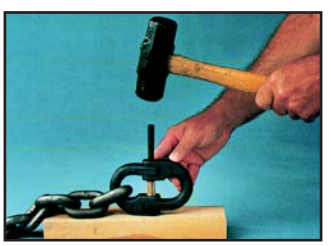
1. Place chain link into clevis of chain coupler. Insert pin fully into the clevis ears.

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.

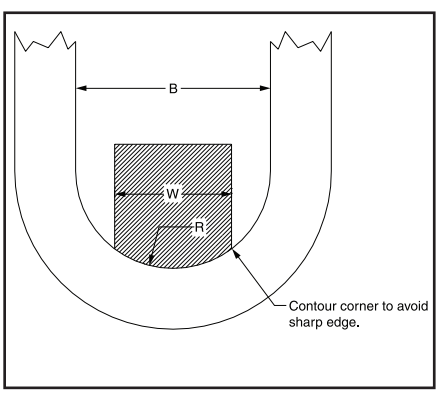


Figure 1

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.