

# Grade 100 Alloy Chain



**Spectrum® 10**  
Grade 100  
Alloy Chain

- Alloy Steel.
- Heat Treated.
- 25% stronger than Grade 80 Alloy Chain.
- Permanently embossed with CG (Crosby Group) and 10 (Grade).
- Finish - Black rust preventative coating.
- Proof Tested at 2 times the Working Load Limit with certification.
- Standard container - fiber drum.

## Grade 100 Alloy Chain Recommended for overhead lifting applications

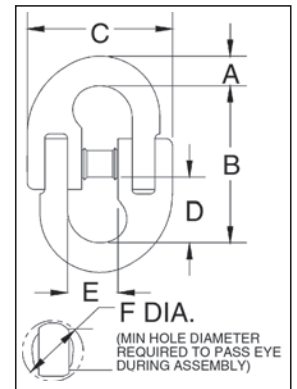
Chain Size		Gr. 100 Drum Stock No.	Feet Per Drum	Material Size (in.)	Working Load Limit (lbs.)*	Maximum Inside Length (in.)	Maximum Inside Width (in.)	Maximum Length 100 Links (in.)	Weight Per 100 Feet (lbs.)
(in.)	(mm)								
9/32 (1/4)	7	273710	500	.276	4300	.87	.42	90	75
5/16	8	273729	500	.343	5700	1.01	.49	100	113
3/8	10	273738	500	.394	8800	1.23	.58	125	148
1/2	13	273747	300	.512	15000	1.57	.77	164	249
5/8	16	273756	200	.630	22600	1.93	.90	202	378
3/4	20	273858	100	.787	35300	2.52	.98	252	590
7/8	22	273867	100	.866	42700	2.77	1.08	277	740
1	26	273876	75	1.02	59700	3.28	1.28	328	1010

\* Proof tested at 2 times Working Load Limit. Ultimate Load is 4 times the Working Load Limit.



**A-1337**  
10 Alloy  
Connecting Link

- Suitable for use with both Grade 80 and Grade 100 chain.
- Individually Proof Tested at 2-1/2 times Working Load Limit with certification.
- Locking system that provides for simple assembly and disassembly - no special tools needed.
- 25% stronger than Grade 80.
- Meets ASTM A-952-02 standards for Grade 100 chain fittings.
- Forged Alloy Steel - Quenched and Tempered.
- Sizes 9/32 through 1 inch are fatigue rated.
- "Look for the Platinum Color-Crosby Grade 100 Alloy Products."



Chain & Accessories

**Crosby 8/10™**



**Fatigue Rated™**

## LOK-A-LOY® 10 Alloy Connecting Link

Chain Size		A-1337 Stock No.	Pkg. Qty.	Weight Each (lbs.)	Working Load Limit (lbs.)*	Dimensions (in.)					
(in.)	(mm)					A	B	C	D	E	F
9/32 (1/4)	7	1015104	60	.26	4300	.38	1.94	1.90	.81	.69	.57
5/16	8	1015113	50	.35	5700	.37	2.35	2.07	.99	.72	.64
3/8	10	1015122	40	.75	8800	.48	2.70	2.47	1.12	.90	.78
1/2	13	1015136	12	1.60	15000	.68	3.45	3.31	1.44	1.12	.97
5/8	16	1015145	10	2.68	22600	.81	4.13	3.90	1.72	1.35	1.14
3/4	20	1015154	1	5.00	35300	.93	4.62	4.62	2.03	1.62	1.28
7/8	22	1015163	1	7.50	42700	1.06	5.46	5.46	2.27	2.00	1.49
1	25	1015172	1	11.03	59700	1.22	5.98	6.13	2.44	2.25	1.76
1-1/4	32	1015181	1	20.38	90400	1.50	7.43	7.59	3.07	2.56	2.23

\*Ultimate Load is 4 times the Working Load Limit. For Grade 6 LOK-A-LOY®, see page 252.

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# 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

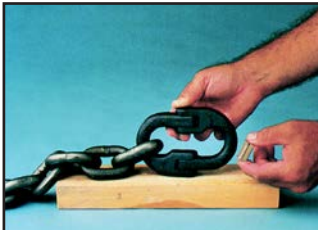


1. Place chain link into clevis of chain coupler. Insert pin fully into the clevis ears.

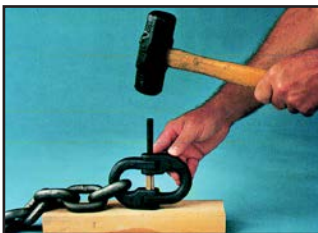


2. Place the coupler link on its side and using a hammer, drive the locking pin into the clevis ear until it is flush with the outside surface.

## 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.

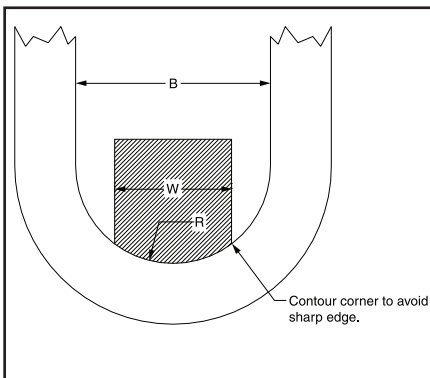


Figure 1

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 AWRP 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.