TSUBAKI
Small Size Conveyor Chain
LSK™ Series Corrosion Resistant

Long Life Stainless Steel Chain

Stainless Steel Double Pitch Chain
Stainless Steel RS® Attachment Chain
Introducing Tsubaki’s new LSK™ Series

Tsubaki has added another series to its corrosion resistant stainless steel attachment chain line up. The LSK Series chain demonstrates high performance in high temperatures, dry conditions, in contact with water, or even underwater to meet the needs of the food industry and a wide range of other industries. Let Tsubaki’s LSK Series be the next solution for your production lines.

### LSK Series with its revolutionary construction offers...

**Better wear resistance!**

Provides long life thanks to a special wear resistant bush. Reduces burdensome chain maintenance.

**Less initial elongation**

![Graph showing wear elongation life in ambient temperatures (in house test data, -10ºC to 60ºC)](image)

**Better heat resistance!**

Greatly increased heat resistance. Can be used in the high temperature range.

![Graph showing wear elongation life in 180ºC environments (in-house test data)](image)

**Better chemical resistance!**

Tsubaki uses its extensive plastic chain engineering know-how to carefully select the special engineering plastic used with the bush.

![Images of LSK Series chains](image)

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### Chain Sizes and Performance

*LSK Series cannot be connected to standard specifications due to the differences in their pins.*

<table>
<thead>
<tr>
<th>Chain Size</th>
<th>Roller Type</th>
<th>Roller Material</th>
<th>Maximum Allowable Load kN(kgf)</th>
<th>Roller Allowable Load kN(kgf)/each</th>
<th>Continuous Usage Temperature °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>R540-LSK</td>
<td>S</td>
<td>Stainless steel</td>
<td>0.44 (45)</td>
<td>0.05 (5)</td>
<td>~20°C ~180°C</td>
</tr>
<tr>
<td>R550-LSK</td>
<td></td>
<td></td>
<td>0.69 (70)</td>
<td>0.06 (6)</td>
<td></td>
</tr>
<tr>
<td>R560-LSK</td>
<td></td>
<td></td>
<td>1.03 (105)</td>
<td>0.09 (9)</td>
<td></td>
</tr>
<tr>
<td>RF20405-LSK</td>
<td></td>
<td>Stainless steel</td>
<td>0.44 (45)</td>
<td>0.05 (5)</td>
<td></td>
</tr>
<tr>
<td>RF20505-LSK</td>
<td></td>
<td></td>
<td>0.69 (70)</td>
<td>0.06 (6)</td>
<td></td>
</tr>
<tr>
<td>RF20605-LSK</td>
<td></td>
<td></td>
<td>1.03 (105)</td>
<td>0.09 (9)</td>
<td></td>
</tr>
<tr>
<td>RF2040R-LSK</td>
<td>R</td>
<td>Stainless steel, KV Series</td>
<td>0.44 (45)</td>
<td>0.20 (20)</td>
<td>~20°C ~180°C</td>
</tr>
<tr>
<td>RF2050R-LSK</td>
<td></td>
<td></td>
<td>0.69 (70)</td>
<td>0.29 (30)</td>
<td></td>
</tr>
<tr>
<td>RF2060R-LSK</td>
<td></td>
<td></td>
<td>1.03 (105)</td>
<td>0.49 (50)</td>
<td></td>
</tr>
</tbody>
</table>

Note:

1. Contact a Tsubaki representative if you will degrease the chain before use.
2. Regularly clean any black wear dust that may develop.
3. Contact a Tsubaki representative regarding extended pins.
4. Standard Series engineering plastic rollers (white) may suffer premature wear in contact with or under water and are not recommended for these environments.
Tsubaki’s new LSK Series chain, with greatly improved wear resistance.

Uses a special bush in the bearing area

Tsubaki’s LSK Series stainless steel conveyor chain uses a special bush to provide self-lubricating functions between pin and bush for a longer wear life. In addition to stainless steel rollers, we also offer KV Series rollers for our LSK Series Double Pitch chain.

**Material**
- Base chain: 18-8 stainless steel (SUS304 equiv.) (pins, plates)
- Bush: 18-8 stainless steel (SUS304 equiv.) + special engineering plastic (Special engineering plastic approved by the Food Sanitation Act)
- Roller: 18-8 stainless steel (SUS304 equiv.)
  - KV Series (special engineering plastic, black)

**Chain Size**
- RS40-LSK – RS60-LSK
- RF2040-LSK – RF2060-LSK
*Made to order item; above sizes can be used with attachments.

**Usage Temperature Range**
- -20°C to 180°C
  (With stainless steel or KV Series engineering plastic rollers)

**Connecting link**
- Cotter pin type

**Perfect for the following equipment!**
- Packing equipment (horizontal pillows, bundling, shrinking, etc.)
- Fill, form, and seal equipment (liquids, powders, etc.)

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**Long Life**

Minimizes chain elongation for less replacement costs and maintenance time!

**Heat Resistance**

Solves problems with mis-positioning during work transfer!

**Chemical Resistance**

Quieter for a better work environment!

Say goodbye to articulation worries!
Double Pitch Stainless Steel Chain

- Base Chain

![Base Chain Diagram]

- Offset Link

![Offset Link Diagram]

- A-2 Attachment

![A-2 Attachment Diagram]

- K-2 Attachment

![K-2 Attachment Diagram]

- SA-2 Attachment

![SA-2 Attachment Diagram]

- SK-2 Attachment

![SK-2 Attachment Diagram]

- LSK Series cannot be connected to standard specifications due to the differences in pins.
- Connecting links use cotter pins.
- Offset links use cotter pins on both ends.
- Contact a Tsubaki representative regarding extended pins.
- Drawings above show attachments on every link.
- Drawings above show 5 rollers on the attachments, but the dimensions are the same with R rollers. Drawings above show attachments on every link.

**Base Chain Dimensions**

<table>
<thead>
<tr>
<th>Tsubaki Chain No.</th>
<th>Pitch P</th>
<th>Roller Diameter R1</th>
<th>R2</th>
<th>Inner Link Width W</th>
<th>Diameter D</th>
<th>L1</th>
<th>L2</th>
<th>L</th>
<th>Thickness T</th>
<th>Width H</th>
<th>Length L</th>
<th>Stainless Steel Rollers</th>
<th>Plastic Rollers</th>
<th>Approximate Mass kg/m</th>
<th>No. of Links per Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>RF2040-LSK</td>
<td>25.40</td>
<td>7.92</td>
<td>15.88</td>
<td>7.95</td>
<td>3.56</td>
<td>8.0</td>
<td>9.2</td>
<td>18.5</td>
<td>1.5</td>
<td>12.0</td>
<td>0.51</td>
<td>0.87</td>
<td>0.52</td>
<td>120</td>
<td></td>
</tr>
<tr>
<td>RF2050-LSK</td>
<td>31.75</td>
<td>10.16</td>
<td>19.05</td>
<td>9.53</td>
<td>4.45</td>
<td>10.15</td>
<td>11.85</td>
<td>23.9</td>
<td>2.0</td>
<td>15.0</td>
<td>0.84</td>
<td>1.30</td>
<td>0.83</td>
<td>96</td>
<td></td>
</tr>
<tr>
<td>RF2060-LSK</td>
<td>38.10</td>
<td>11.91</td>
<td>22.23</td>
<td>12.70</td>
<td>5.09</td>
<td>14.35</td>
<td>15.95</td>
<td>32.0</td>
<td>3.2</td>
<td>17.2</td>
<td>1.51</td>
<td>2.19</td>
<td>1.48</td>
<td>80</td>
<td></td>
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</tbody>
</table>

**Attachment Dimensions**

<table>
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<tr>
<th>Tsubaki Chain No.</th>
<th>C</th>
<th>C1</th>
<th>C2</th>
<th>K</th>
<th>N</th>
<th>O</th>
<th>S</th>
<th>X</th>
<th>X2</th>
<th>XS</th>
</tr>
</thead>
<tbody>
<tr>
<td>RF2040-LSK</td>
<td>12.7</td>
<td>11.1</td>
<td>13.6</td>
<td>9.5</td>
<td>19.1</td>
<td>3.6</td>
<td>9.1</td>
<td>19.3</td>
<td>17.6</td>
<td>19.8</td>
</tr>
<tr>
<td>RF2050-LSK</td>
<td>15.9</td>
<td>14.3</td>
<td>15.9</td>
<td>11.9</td>
<td>23.8</td>
<td>5.2</td>
<td>11.1</td>
<td>24.2</td>
<td>22.0</td>
<td>24.6</td>
</tr>
<tr>
<td>RF2060-LSK</td>
<td>21.45</td>
<td>17.5</td>
<td>19.1</td>
<td>14.3</td>
<td>28.6</td>
<td>5.2</td>
<td>14.7</td>
<td>31.5</td>
<td>28.2</td>
<td>30.6</td>
</tr>
</tbody>
</table>

RS® Stainless Steel Attachment Chain

- Base Chain

![Base Chain Diagram]

- Offset Link

![Offset Link Diagram]

- A-1 Attachment

![A-1 Attachment Diagram]

- K-1 Attachment

![K-1 Attachment Diagram]

- SA-1 Attachment

![SA-1 Attachment Diagram]

- SK-1 Attachment

![SK-1 Attachment Diagram]

- LSK Series cannot be connected to standard specifications due to the differences in pins.
- Connecting links use cotter pins.
- Offset links use cotter pins on both ends.
- Contact a Tsubaki representative regarding extended pins.
- Drawings above show attachments on every link.

**Base Chain Dimensions**

<table>
<thead>
<tr>
<th>Tsubaki Chain No.</th>
<th>Pitch P</th>
<th>Roller Diameter R</th>
<th>Inner Link Width W</th>
<th>Diameter D</th>
<th>L1</th>
<th>L2</th>
<th>L</th>
<th>Thickness T</th>
<th>Width H</th>
<th>Length L</th>
<th>Stainless Steel Rollers</th>
<th>Plastic Rollers</th>
<th>Approximate Mass kg/m</th>
<th>No. of Links per Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>RS40-LSK</td>
<td>12.70</td>
<td>7.92</td>
<td>7.95</td>
<td>3.56</td>
<td>8.0</td>
<td>9.2</td>
<td>18.5</td>
<td>1.5</td>
<td>12.0</td>
<td>0.64</td>
<td>240</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>RS50-LSK</td>
<td>15.875</td>
<td>10.16</td>
<td>9.53</td>
<td>4.45</td>
<td>10.15</td>
<td>11.85</td>
<td>23.9</td>
<td>2.0</td>
<td>15.0</td>
<td>1.04</td>
<td>192</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>RS60-LSK</td>
<td>19.05</td>
<td>11.91</td>
<td>12.70</td>
<td>5.09</td>
<td>12.65</td>
<td>14.25</td>
<td>28.6</td>
<td>2.4</td>
<td>18.1</td>
<td>1.53</td>
<td>160</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Attachment Dimensions**

<table>
<thead>
<tr>
<th>Tsubaki Chain No.</th>
<th>C</th>
<th>C1</th>
<th>N</th>
<th>O</th>
<th>S</th>
<th>T</th>
<th>X</th>
<th>X2</th>
<th>XS</th>
</tr>
</thead>
<tbody>
<tr>
<td>RS40-LSK</td>
<td>12.7</td>
<td>12.7</td>
<td>9.5</td>
<td>3.6</td>
<td>8.0</td>
<td>1.5</td>
<td>17.8</td>
<td>17.8</td>
<td>17.40</td>
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<tr>
<td>RS50-LSK</td>
<td>15.9</td>
<td>15.9</td>
<td>12.7</td>
<td>5.2</td>
<td>10.3</td>
<td>2.0</td>
<td>23.4</td>
<td>23.4</td>
<td>23.05</td>
</tr>
<tr>
<td>RS60-LSK</td>
<td>19.05</td>
<td>18.3</td>
<td>15.9</td>
<td>5.2</td>
<td>11.9</td>
<td>2.4</td>
<td>28.2</td>
<td>28.2</td>
<td>26.85</td>
</tr>
</tbody>
</table>

**Model Numbering Example**

- **RF2040LSK-1LK2**
  - Chain number: RF2040
  - Roller type: LSK Series
  - Attachment type: 1LK2
- **RF2040RPKV-LSK-1LK2**
  - Chain number: RF2040
  - Roller type: LSK Series
  - Attachment type: 1LK2
  - When using KV Series rollers
- **RS40-LSK-1LK1**
  - Chain number: RS40
  - Roller type: LSK Series
  - Attachment type: 1LK1
Selection and Handling

1 Selection

Refer to the Tsubaki Small Size Conveyor Chain catalog for Double Pitch and RS attachment chain selection.

Select the appropriate chains size and type based on the conveyor type and capacity. Selection will depend on many varying conveyor usage conditions. If you cannot unconditionally select a chain, follow the general steps below.

Step 1 Confirm conveyor conditions
Step 2 Provisionally select the chain model
Step 3 Confirm the roller and attachment allowable load
Step 4 Calculate the maximum load acting on the chain
Step 5 Determine the chain size
Step 6 Use the index conveyance chain selection method if necessary

2 Sprockets

Double Pitch Chain:
When using S rollers, use RS sprockets only if the sprocket will have 30 or more teeth. In all other situations you will need to use Double Pitch chain sprockets.

RS Attachment Chain:
Use RS sprockets. Refer to the Tsubaki Drive Chains & Sprockets catalog or the Tsubaki Small Size Conveyor Chain catalog for more information.

3 LSK Series corrosion resistance

Corrosion resistance varies accordingly depending on application conditions. This table should not be considered a guarantee. Using this table as a reference, be sure to check the corrosion resistance of the chain in advance according to the actual operating conditions when selecting your chain.

Data in this table is for 20ºC operating temperatures.

<table>
<thead>
<tr>
<th>Chemical/Food Product</th>
<th>Acetic acid</th>
<th>Anhydrous ammonia</th>
<th>Zn chloride 5%</th>
<th>Hydrochloric acid 37%</th>
<th>Hydrofluoric acid 5%</th>
<th>Hydrochloric acid 30%</th>
<th>Hydrofluoric acid 5%</th>
<th>Acetic acid 10%</th>
<th>Sodium hypochlorite</th>
<th>Hydrochloric acid 2%</th>
<th>Sodium hypochlorite</th>
<th>Hydrochloric acid</th>
<th>Sodium hypochlorite</th>
<th>Hydrochloric acid</th>
<th>Sodium hypochlorite</th>
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</thead>
<tbody>
<tr>
<td>LSK Series</td>
<td>○</td>
<td>○</td>
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<td>×</td>
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<td>LSC Series</td>
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<tr>
<td>SS Series</td>
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<tr>
<td>AS Series</td>
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<td>NS Series</td>
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<td>▲</td>
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<td>▲</td>
<td>▲</td>
</tr>
</tbody>
</table>

For Your Safety When Using the Chain

Warning
To avoid danger, observe the following rules.

- Do not use chain or chain accessories for any purpose other than their originally intended use.
- Never perform additional work on chain.
  - Do not anneal any chain parts.
  - Do not clean chain with acids or alkalis. These may cause cracking.
  - Never attempt to electropolish or chain parts. This may cause hydrogen embrittlement.
  - Do not weld chain. Heating effects will cause weakening and cracking.
  - When a torch is used to heat or cut chain, remove the links on each side and do not reuse them.
- When replacing a worn or damaged part, do not replace just the worn or damaged part. Replace all parts with new parts.
- If an acid is used, the chain will be allowed to contact the chain without any harm.
- When using chain in a lifting device, set up a safety barrier and do not allow anyone to go under the equipment.
- Always install safety equipment (safety covers, etc.) on chain and sprockets.
- Strictly observe the general guidelines listed in Section 1, Chapter 1, 2nd Edition of the Japanese Occupational Safety and Health Regulations as well as rules and regulations concerning occupational safety and health in your region/country.
- When installing, removing, inspecting, maintaining and oiling chain,
  - Perform the work as instructed in the manual, catalog or other documentation that was provided with the product.
  - Before starting work, turn off the power switch and take measures to prevent it from being turned on accidentally.
  - Secure the chain and parts to prevent them from moving freely.
  - Use a press tool or other special tools to separate or connect chain, and follow the correct procedures.
  - Remove and insert pins and rivets in the correct direction.
  - Wear clothing and protective gear (safety glasses, gloves, safety shoes, etc.) that are appropriate for the work.
- Only experienced personnel should perform chain replacement.

Caution
To prevent accidents, observe the following rules.

- Understand the structure and specifications of the chain that you are handling.
- Before installing chain, inspect it to make sure no damage occurred during delivery.
- Inspect and maintain chain and sprockets at regular intervals.
- Chain strength varies by manufacturer. Only Tsubaki products should be used when chain is selected using Tsubaki catalogs.
- Minimum tensile strength refers to the failure point when the corresponding load is applied to the chain once and does not refer to the allowable operational load.
Warranty

1. LIMITED WARRANTY
Products manufactured by Seller (a) conform to the design and specifications, if any, expressly agreed to in writing by Seller; and (b) are free of defects in workmanship and materials at the time of shipment. Seller's obligations are expressly set forth above. Seller is not responsible for damages resulting from misapplication or improper use of products. Seller shall not be liable for any consequential or incidental damages, including, but not limited to, damages resulting from personal injury, death or damage to or loss of use of property.

2. NON-RELIANCE
Buyer is not relying upon any advice, representations or warranties (except the warranties expressly set forth above) of Seller, or upon Seller's skill or judgment regarding the Seller's products. Buyer is solely responsible for the design and specifications of the products, including without limitation, the determination of suitability for Buyer's application of the products.

3. CLAIMS
(a) Any claim relating to quantity or type shall be made to Seller in writing within 7 days after receipt of the products; any such claim made thereafter shall be barred.
(b) Any claim under the above-stated Limited Warranty shall be made to Seller in writing within three (3) months after receipt of the products; any such claim made thereafter shall be barred.

(c) Seller’s liability for breach of warranty or otherwise is limited to repair or replacement, at Seller’s option, of non-conforming or defective products. Buyer waives all other remedies, including, but not limited to, all rights to consequential, special or incidental damages, damages related to, damages resulting from personal injury, death or damage to or loss of use of property.

(d) Any claim made to Seller pursuant to this warranty shall be made within 90 days after Buyer’s knowledge of such non-conformance or defect. Buyer waives all other remedies, including, but not limited to, all rights to consequential, special or incidental damages, damages related to, damages resulting from personal injury, death or damage to or loss of use of property.

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