



MACHINE CUT SPROCKET TOLERANCES

SINGLE STRAND SPROCKET RIM THICKNESS

Pitch	Chain Number	Sprocket Thickness	Un-machined Tolerance	Machined Tolerance
1/4 "	25	.110"	+ .005 / - .021"	+ .000 / - .007"
3/8 "	35	.168"	+ .006 / - .027"	+ .000 / - .008"
1/2 "	41	.227"	+ .007 / - .032"	+ .000 / - .009"
1/2 "	40	.284"	+ .008 / - .035"	+ .000 / - .009"
5/8 "	50	.343"	+ .009 / - .036"	+ .000 / - .010"
3/4 "	60	.459"	+ .012 / - .036"	+ .000 / - .011"
1 "	80	.575"	+ .014 / - .040"	+ .000 / - .012"
1 1/4 "	100	.692"	+ .017 / - .046"	+ .000 / - .014"
1 1/2 "	120	.924"	+ .022 / - .057"	+ .000 / - .016"
1 3/4 "	140	.924"	+ .022 / - .057"	+ .000 / - .016"
2 "	160	1.156"	+ .027 / - .062"	+ .000 / - .019"
2 1/4 "	180	1.301"	+ .032 / - .068"	+ .000 / - .020"
2 1/2 "	200	1.389"	+ .032 / - .072"	+ .000 / - .021"
3 "	240	1.738"	+ .050 / - .088"	+ .000 / - .025"

SPROCKET ROOT DIAMETER

The Root or Bottom diameter tolerance is minus only and can be found by the following formula:

Tolerance Equals: $[(.001 \times \text{Chain Pitch in Inches}) \times \text{Square Root of the No. of Teeth}] + .003$

FACE RUN-OUT

Maximum total face run-out is .0025" total indicator reading per inch of sprocket pitch diameter.

CONCENTRICITY

Maximum allowable pitch line eccentricity with relation to the bore is .001" total indicator reading per inch of sprocket pitch diameter, with minimum tolerance of .006" at regular charges.

HUB DIAMETER AND LENGTH

Hub Diameter Range	Hub Diameter Tolerance	Length Through Bore Tolerance
Hubs up to 3" Diameter	+ 0" - 1/32"	+ 1/32" - 1/32"
Over 3" to 4" Diameter	+ 0" - 1/16"	+ 1/32" - 1/32"
Over 4" to 6" Diameter	+ 0" - 1/16"	+ 1/16" - 1/16"
Hubs over 6" Diameter	+ 0" - 1/8"	+ 1/16" - 1/16"

DRILLED HOLES

Hole Diameter.....	+ .010"	- .000"
Radius from Center.....	+ .015"	- .015"
Spacing	+ .010"	- .010"