HANDUN

Rubber Glove Industry Solutions

We produce single former conveyor chains since 2003 but just start to learn rubber glove industry in 2015. For several years, we have produced chains, sprockets and shafts for glove industry with growing success.

To date we have been able to offer full range drive chains and conveyor chains & parts for rubber glove factories.

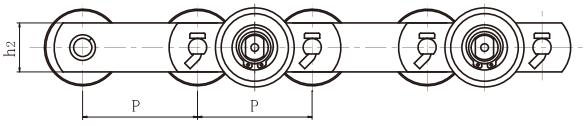
A high level of plant availability and minimal servicing costs are the basic requirements for an optimum production flow in high quality rubber glove manufacturing.

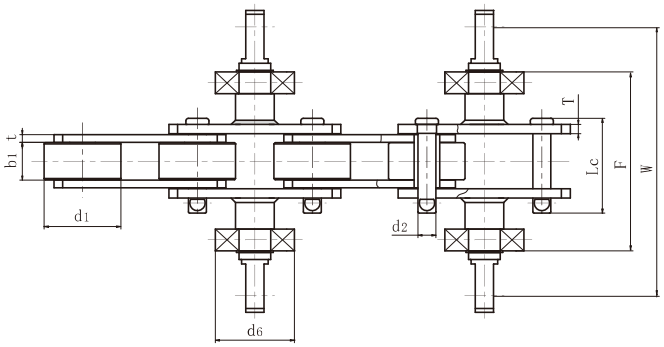
As a specialist in the conveyor system, we cooperate with well known glove manufacturers, as well as glove production line designer. As a result of comprehensive consultancy at a technical level and customised engineering, we supply high-quality product solutions which are optimally suited to the different requirements of your respective application.



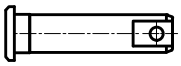
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Latex Glove
Single Former Carrier Chain

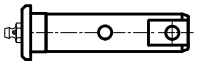




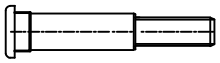
T Type cotter pin



N: Pin with spray nozzle

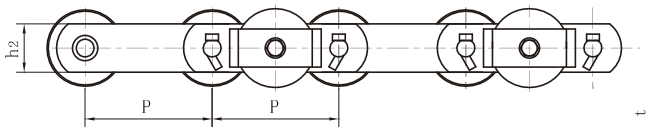


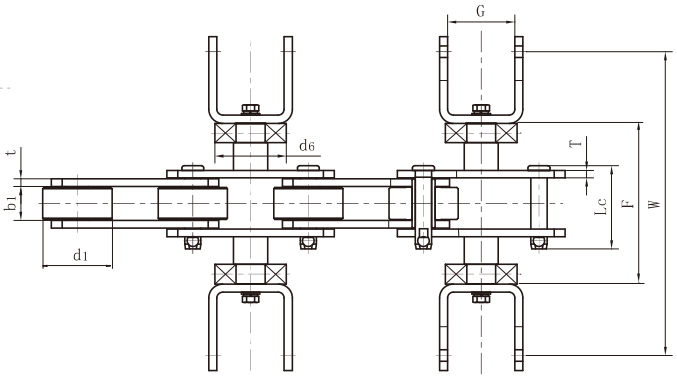
E: Extended screw pin



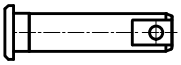
Chain No.	P	b1	*d1	d2	Lc	h2	t/T	d6	F	W	UTS.(kN)
RG90S	90	30	60(50.8)	14.27	75	38.5	6.0/7.0	62	The welded arm pin length designed accoring to customers' rail width		260
RG90SK	90	29.5	60(50.8)	16	71	38	6.5	62			200
RG100SK	100	29.5	60(50.8)	16	71	38	6.5	62			200
RG100SN	100	29	60(50.8)	16	74	38	6.5	62			200
RG100SE	100	29.5	60(50.8)	16	89.5	42	8	62			300
RG101SE	101.6	29	60(50.8)	16	89.5	42	8	62			300

* Roller diameter 60mm for old type. We suggested 50.8mm for new line.
The holder pin with Alloy steel or stainless steel are available

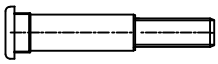




T Type cotter pin



E: Extended screw pin



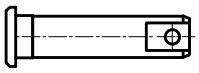
Chain No.	P	b1	*d1	d2	Lc	h2	t/T	d6	F	W	UTS.(kN)
RG90U	90	30	60(50.8)	16	72	38	6.5	62	The welded arm pin length designed accoring to customers' rail width		200
RG90UE	90	29	60(50.8)	16	81	38	8	62			300
RG100U	100	29,5	60(50.8)	16	72	38	6.5	62			200
RG100UE	100	29	60(50.8)	16	81	38	8	62			240
RG100US	100	29	60(50.8)	14.27	72	38	6.5	62			200
RG110US	110	29	60(50.8)	14.27	72	42	6.5	62			280

* Roller diameter 60mm for old type. We suggested 50.8mm for new line.

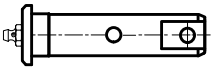
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Latex Glove
Double Former Carrier Chain

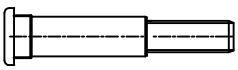
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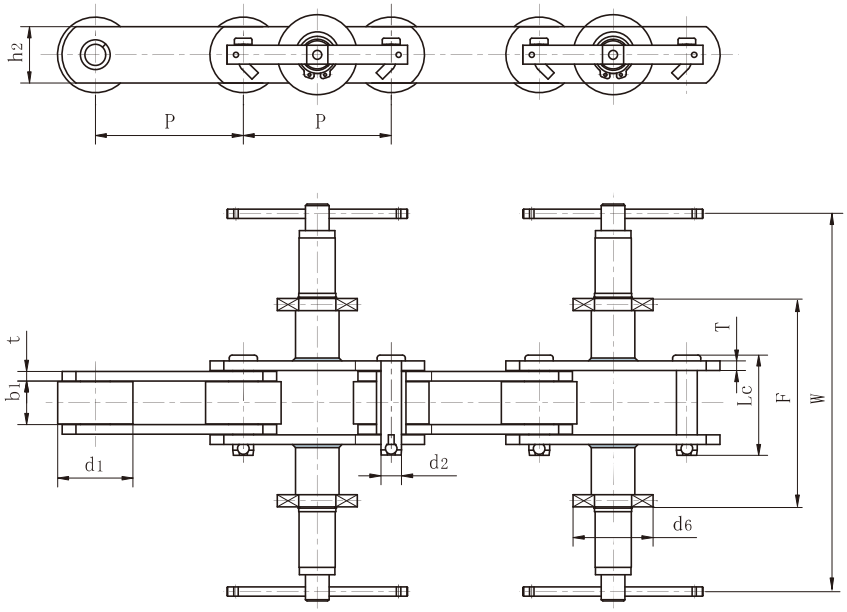
T Type cotter pin



N: Pin with spray nozzle



E: Extended screw pin

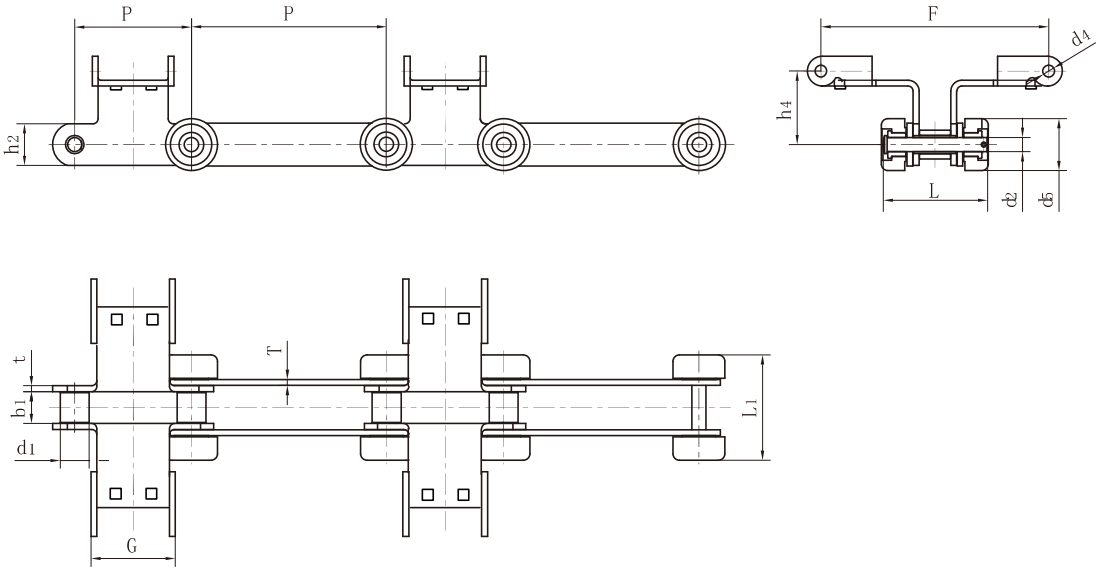


Chain No.	P	b1	*d1	d2	Lc	h2	t/T	d6	F	W	UTS.(kN)
RG100D	100	29	60(50.8)	14.27	72	38	6.5	62	The welded arm pin length designed accoring to customers' rail width		200
RG100E	100	29	60(50.8)	16	72	38	6.5	62			200
RG110DH	100	29	60(50.8)	15	75	38	7.0/8.0	62			230
RG110D	100	29	60(50.8)	16	75	38	6.5	62			200
RG110DC	100	29	60(50.8)	16	75	38	7	62			220
RG100DF	100	30	50.8	16	81	42	7	80			270
RG100DP	100	29.5	50.8	16	79	42	8	62			300
RG100DSN	100	29.5	60(50.8)	16	80	38	8	62			240

* Roller diameter 60mm for old type. We suggested 50.8mm for new line.

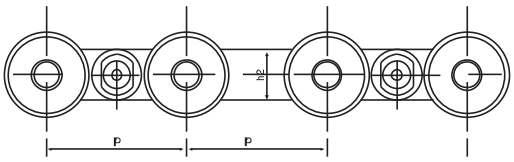


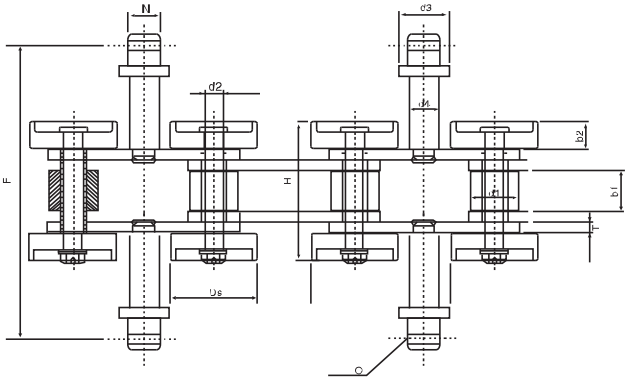
PVC Glove Single Former Carrier Chain



Chain No.	P	b1	d1	d2	L	h2	t/T	F	G	h4	d5	d4	UTS.(kN)
PV90	90	24	22.23	11.1	89	32	6	172	75	56.5	40	9.2	72
PV95	95	24	22.23	11.1	89	32	6	176	75	56.5	40	9.2	72
PV100	100	24	22.23	11.1	85	32	5	194	75	56.5	40	9.2	72
PV100F1	100	24	22.23	11.1	89	32	6	196	75	56.5	40	9.2	72
PV100F2	100	24	22.23	11.1	85	32	5	173	75	58.5	40	9.2	72
PV100F3	100	24	22.23	11.1	89	32	6	176	75	56.5	40	9.2	72
PV100F4	100	24	22.23	11.1	99	36	5	226	75	56.5	41	9.2	72
PV100F5	100	24	22.1	12	89	32	6	194	74.8	56.5	40	9.2	120
PV105	105	24	22.23	12.7	89	32	6	196	75	56.5	40	9.2	72
PV110	110	24	22.23	11.1	89	32	6	230	75	56.5	40	9.2	72
PV110F2	110	24	22.23	11.1	85	32	5	204	75	57.5	40	9.2	72
PV110F3	110	24	22.23	11.1	89	32	6	194	75	56.5	40	9.2	72
PV110F4	110	24	25.4	12.7	99	36	6	230	75	56.5	41	9.2	72
PV110F5	110	31.75	28.58	14.27	113	36	6	237	75	56.5	42	9.2	72
PV125	125	24	22.23	11.1	85	32	5	230	75	56.5	40	9.2	72
PV130	130	24	30	16	105	32	8	220	75	58	54	9.2	72
PV150	150	24	22.23	10.8	81.5	32	4.5	175	65	57	40	9.2	60

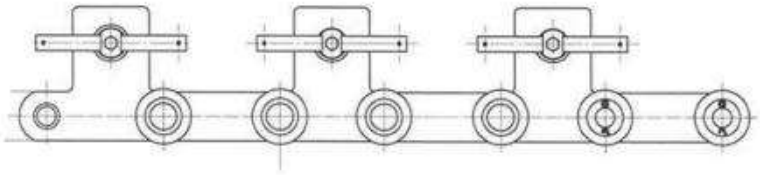
PVC Glove Single Former Carrier Chain

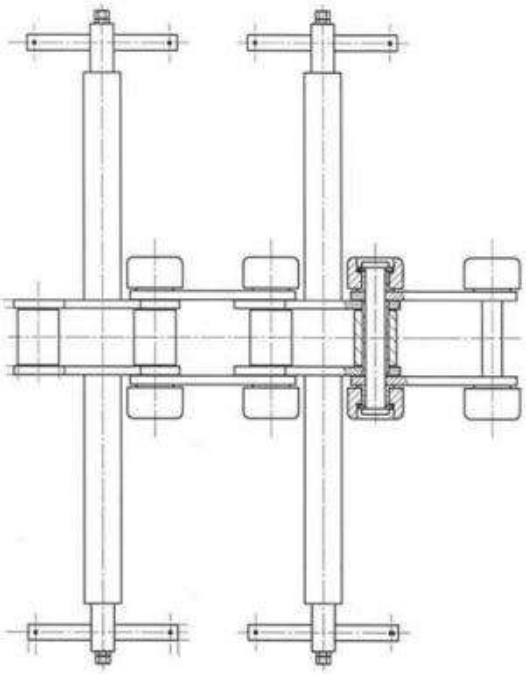




Chain No.	P	b1	d1	h2	d2	T	F	N	O	b2	d3	Ds	H	d4
PVS110	110	32	38.1	40	15	8	220	25.6	8	22	40	70	110	28

PVC Glove Double Former Carrier Chain



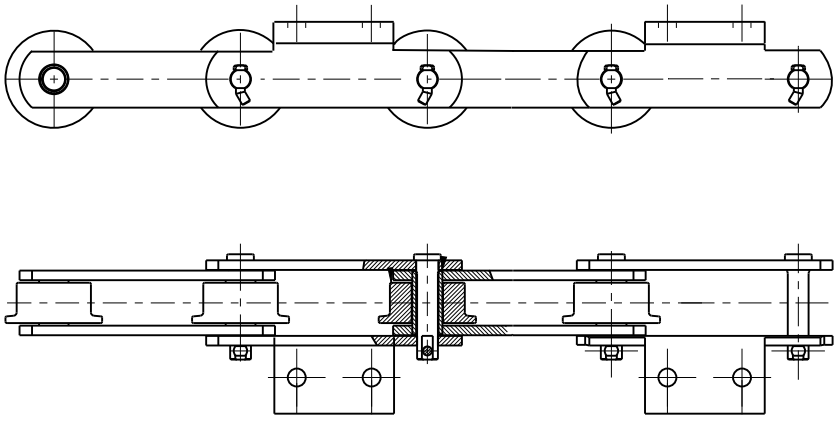


without bearing due to higher tempeture in PVC production line. It need to be used in C type rails.

The chain sizes can be designed according to customers' requirements.

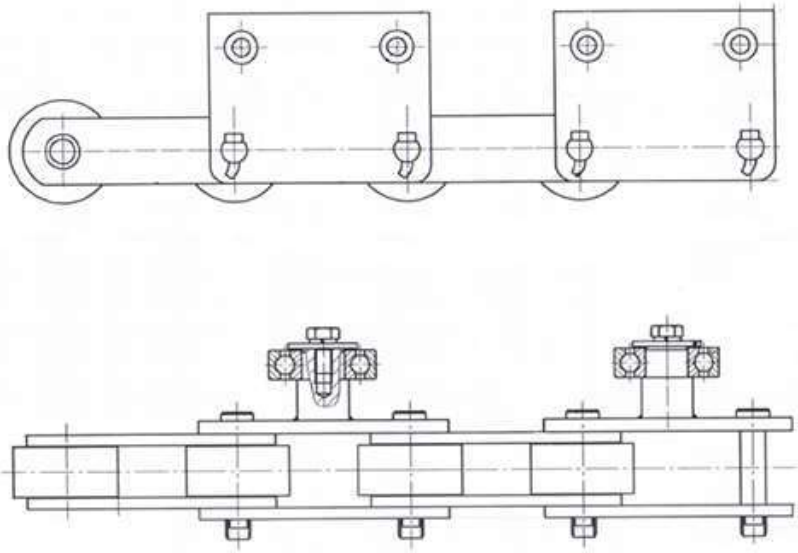
PVC Glove Mould Release Chain

Produced for machinery manufacturers and glove factories replacements. The dimenstions are designed according to rubber glove factories' glove release machine.

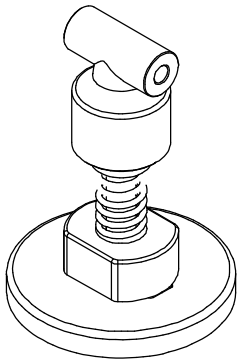


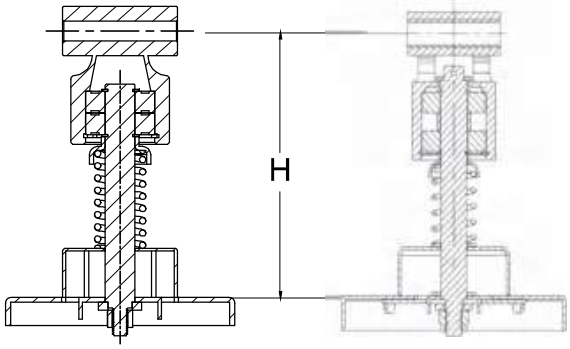
Latex Glove Mould Release Chain

Produced for machinery manufacturers and glove factories replacements. Usually, the dimenstions of base chain are same with former carrier chain. The attachment height are designed to rubber glove factories' glove release machine.



Single Former Holder





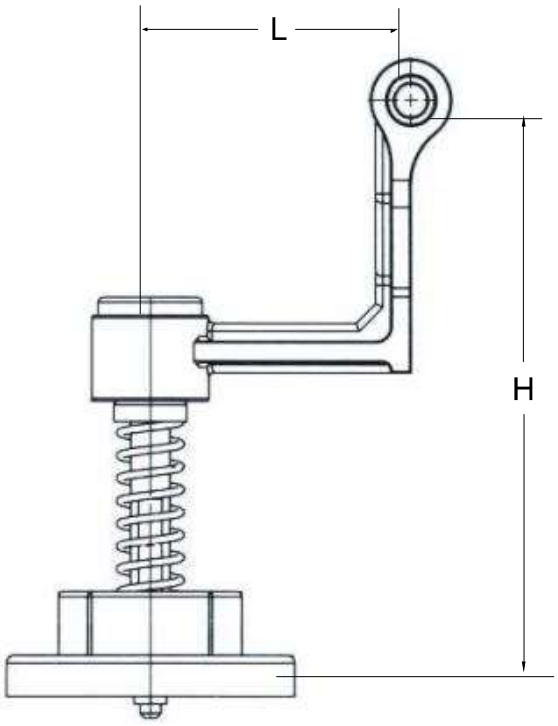
A Type

B Type
more stable rotation

Size No.	Height(H)
SH43	143.5
SH45	145
SH50	150
SH59	159

Can be designed according to customers' sizes

Double Former Holder



A Type: standard type
B Type: more stable rotation

Size No.	Length (L)	Heigth (H)
PK15	88.00	200
		203
		205
		212
PK18	96.00	200
		203
		205
		212
PK20	100.00	200
		203
		205
		212
PK22	110.00	200
		203
		205
		212

Can be designed according to customers' sizes

HANDUN

High Quality Former Holder

Features:

- Our former holder use high quality materials, keep improving for customers.
- Great development capacity to design and manufactured for customers.
- Wear resistance designed for all touch surface to improve working life.
- Perfet quality inspe-ction system to ensure the quality for every patch.
- Lower noice design Special touch surface not only anti-wear but also lower noice



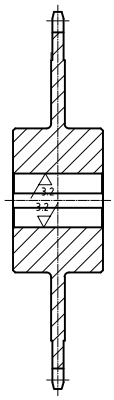
No.	Name	Material	Picture
1	Aluminium Housing Arm	ADC12, the surface should be shot blasting or electrophoretic black	
2	Holder Shaft	Stainless Steel 304 or 430. Made by automatic machine in higher concentricity	
3	bearing	Famous brand bearings, with CHEVRON high temperature grease 50%	
4	Holder Disc	Stainless Steel 304	
5	Spring Cap	Stainless Steel 304	
6	Spring	Stainless Steel 304	
7	Lubricant free Bush	Alloy steel processed in lubricant free	

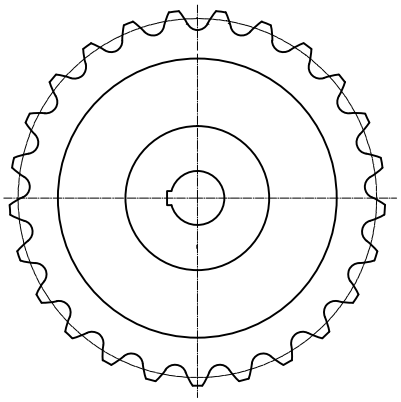
HANDUN

Former Carrier Chain Sprocket

13







We can manufacture sprockets to meet your specific needs. The results are sprockets designed to maximize the life of your chain. Chain and sprockets must work together, so buying them from the same manufacturer makes sense. When chains and sprockets articulate correctly, the life of the chain is extended. Many of our wide range of carbon steel sprockets are heat treated, provides long wear life and resists abrasion.

Made-to-Order capabilities: Specializing in high quality engineering class sprocket.
Over 45 years of manufacturing experience.
Heat treating: Induction, flame, carburizing/case hardening, etc.
Effective hardness depth maintained in sprockets.
CNC machining for special machined tooth profiles.
Flame and laser cutting
Finishes including paint, powder coat and black oxide.
Stress relieving sprockets
Balancing sprockets.

Our Former Carrier Chain Sprocket features:

1. We use high quality 45 steell (not rough steel material)
2. Quenching and tempering heat treatment for sprocket and shaft material before machining to avoid deformation and even fracture.
3. We use CNC machine to process the sprocket teeth to make sure the teeth without slope.
4. Sprocket teeth is hardened.



HANDUN can supply Sprocket and Shaft in one set



Delivery Chain & Sprocket in Set

- The alignment tolerance of sprocket and shaft can be guranteed
- It can ensure that the dimensions of sprocket and shaft correspond
- Let the shat and sprocket better matching former carrier chain.
- Increase the stability of the production line and improve the production efficiency.
- High quality material with quenching and tempering heat treatment to improve the strength. Working long time without deformation.

Handun Advantages

1. More than 45 years in engineer chains
2. Exquisite processing and heat treatment technology, bring safe quality for customers.
3. With rich experiences in snstallation and matching, we can provide assembled products. also can be disassembled and shipped after assembly (after dimension inspection)



- The shaft maximum size can reach 9000mm and dismeter reach 1000mm.
- We can supply the sprocket with maximum outer circle reach 3000mm

$$P.C.D. = P \times \frac{1}{\sin\frac{180^\circ}{N}}$$

$$O.D. = P.C.D. + 0.7d$$

$V = 2d$ When $d>h$

$= 3d$ When $d<h$

(However, P-V≧5mm must be satisfied)

$D = d + 2$ $(d \leqq 50)$

$0 < d \leqq 100)$

$00 < d)$

$R \fallingdotseq P$

$$r = \frac{O.D. - P.C.D.}{2}$$

$$M = \frac{P.C.D. - 0.95P.C.D.}{2}$$

$F = 0.6d$

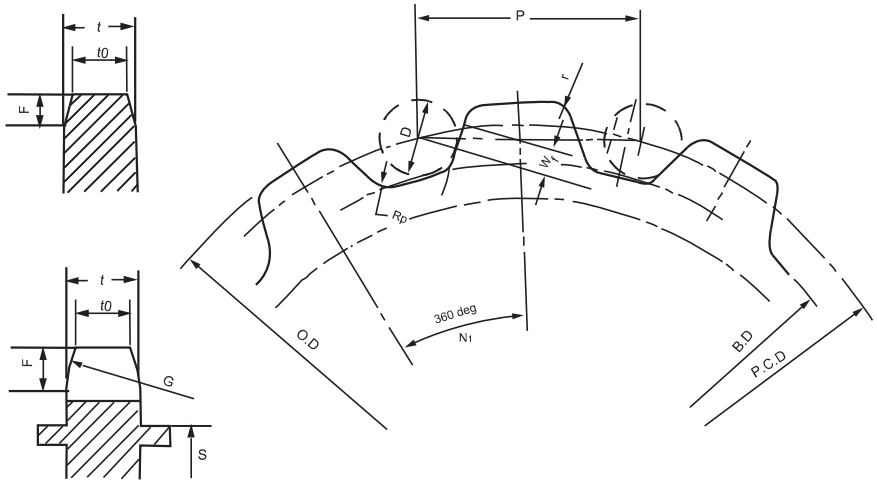
$t = 0.75W \sim 0.85W$

$$G = \frac{2F^2}{t} + \frac{t}{8} \quad \text{or to} = 0.5t$$

$$S = P.C.D. - \left(P \times \tan\frac{180^\circ}{2N} + 1.2h + 20\right)$$

Standard dimensions

- P :Chain pitch
- N : No. of teeth
- d : Roller, bush or barrel diameter
- h : Link plate height
- W: Width between inner link plates, or width of parallel part of barrel.



Pitch cirde Diameter

The sprocket pitch circle diameter (P.C.D.) can be found simple by multiplying the chain pitch by the coefficient below:

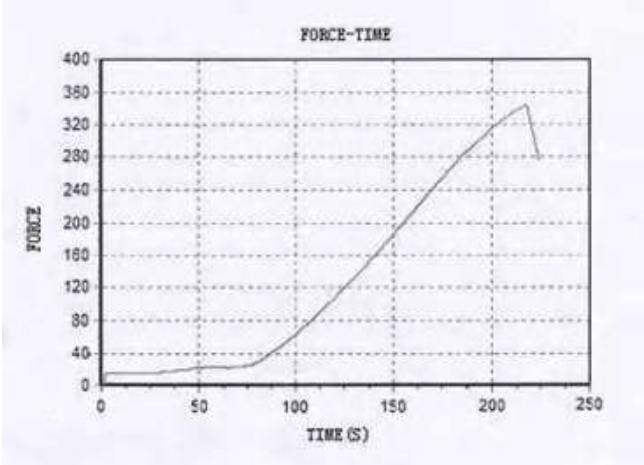
$$P.C.D. = P \times \frac{1}{\sin\frac{180^\circ}{N}}$$

No.of Teeth (N)	Coefficient $\left(\frac{1}{\sin\frac{180^\circ}{N}}\right)$	No.of Teeth (N)	Coefficient $\left(\frac{1}{\sin\frac{180^\circ}{N}}\right)$	No.of Teeth (N)	Coefficient $\left(\frac{1}{\sin\frac{180^\circ}{N}}\right)$
5	1.7013	17	5.4422	29	9.2491
6	2.0000	18	5.7588	30	9.5668
7	2.3048	19	6.0755	31	9.8845
8	2.6131	20	6.3925	32	10.2023
9	2.9238	21	6.7095	33	10.5201
10	3.2361	22	7.0267	34	10.8380
11	3.5495	23	7.3439	35	11.1558
12	3.8637	24	7.6613	36	11.4737
13	4.1786	25	7.9787	37	11.7916
14	4.4940	26	8.2962	38	12.1096
15	4.8097	27	8.6138	39	12.4275
16	5.1258	28	8.9314	40	12.7455

We control the quality in every procedure from raw material to finished products The quality records is traceability.

For finished former carrier chains, we will get the following test results:

1. Chain length accuracy: according to ISO 606 international standard, the conveyor length tolerance should be 0~0.25%. Our former carrier chains are strictly implemented this standard.
   if the chains are too longer, that's means less the chain wear life because the chain will be elongated in running due to wear in pins and bushs.
2. Ultimate tension strength:
   We will test the strength of first sample before official assembling to check the chain components performance.
   During chain assembling, we will test a sample again for official test report.





The inspeciton before shipment:

1. Make sure each link is flexible.
2. Make sure that no deformed link plates after welding.
3. Make sure that the holes of each arm shaft are on same horizontal line.
4. We will mount the holder pin and other accessories to they are in correct fit.

OUR LUBRICATION OIL

We use special oil with temperature resistance, formed high viscosity oil film on the surface of all chain parts. Not only rust proof, but also can improve the service life of the chains.



HIGH PRECISION COMPONENTS

We use high quality annealed material finish rolling material to produce chain plates and bushes. Each plates are punched by imported equipments with advanded moulds to create precision holes. Each pin is centreless ground producing almost perfectly cylindrical diameters. Designed pin and bush facilitates optimum fits in the plates.



SHOT PEENED PARTS

Chain parts are shot peened to get residual stresses, combating fatigue and making the chains stronger beneficiary for high speed chain applications.



HEAT TREATMENT

Strictly process controls and the art heat-treating by imported furnaces provide consistent quality in all our chain components. This results in optimum toughness and resistance to wear.





AUTOMATED ASSEMBLY

Roller Chains (06A/B~24A/B) are assembled by high precision automatic machines from parts to rivetting. Other sizes are assembled inner link by automatic machines.



FACTORY PRELOADED AT 50 PERCENT MUTS

Our chains are proloaded to 50% of minimum ultimate tensile strength (MUTS), which is especially important for applications involving fixed center-to-center sprockets without take-ups. Applications can withstand shock loads up to 50% of the chain's MUTS without premature elongation.



PRELUBRICATION

After final assembly, we hot-dip roller chains in a special lubricant. It endures all the bearing surfances are initially protected from metal-to-metal contact, improve the wear We use the oil with high adhesieve force.



HANDUN

Abnormality of Conveying Chain and Its Measures

There can be many reasons why chain and sprocket installations of any type can give difficulties in service and we can only list a small number of suggestions when operating problems occur.

FAULT	CAUSE	REMEDY
Fractured Chain Bush	Chain Speed too High	Chain of Shorter Pitch but equivalent strength
	Heavy Shock Loads	Investigate to reduce shock Loads
	Corrosion Pitting	Consider using special material or Improve Lubrication
Roller Flatting due to Skidding	Too lightly loaded System	Increase load within limit of chain
	Heavy Load where Friction between bush and roller bore overcomes lever friction effect of friction at roller periphery	Increase chain size if no reduction possible
	Excessive lubricant on chain track	Clean tracking
	Canting Over of chain on Track	Investigate
Tight Chain Joints	Material packed in chain	Clean & re- lube
	Frozen / Seized Chain	Clean & re- lube
	Incorrect Lubricant	Clean & re- lube
	Corrosion	Investigate
	Mal-alignment	Check structure
Fractured Chain Plates Fractured Pin Elongated Linkplate Holes	Overload above maximum Chain working capacity	Investigate for foreign object causing construction Check alignment between drive & tail sprockets
		Protect with chain Overload Device
		Check Power Consumption
Excessive Roller Bore Wear	High Unit Load	Distribute Load
	Twisted Slats / Carriers	Investigate, highlight, correct
	Unsatisfactory Lubrication	Improve Lubrication
Excessive Noise	Mis-alignment of Chain Tracking	Check all Structure Alignments
	Too little or too much Chain Slack	Re-tension chain
	High Speed	Use Shorter Chain Pitch Size
	Chain Sprocket Wheels Worn	Replace
	In-effective Lubrication Damaged / Incorrectly positioned chain tracking	Lubricate correctly Investigate and adjust as necessary
Uneven Running	“Stick Slip” / Hunting	See Roller Flatting. Check Drive for adequate capacity
	Polygonal Action of closely spaced sprockets in a complex circuit	Increase sprocket chainwheel centres or reposition wheels
	Polygonal Action at Drive Chainwheel	Use larger diameter sprocket
Chain Whip	Excessive Slack	Adjust correctly
	Worn Tooth Form	Replace Chainwheel
Chain Clings to Sprocket Teeth	Incorrect Tooth Form	Replace
	Worn Tooth Form	Replace
	Heavy Tacky Lubricant	Clean & re-lube
	Stiff Chain Joints	See chain assembly Procedures
Chain Climbs Sprocket Teeth	Excessive Tooth Form Wear	Replace
	Build Up of Excessive Chain Slack	Adjust Chain
	Chain Elongation	Replace Chain
	Severe Overloads	Investigate, highlight, correct