

ISO 16877:2015-01 (E)

Round steel short link chains for lifting purposes - Fine tolerance hoist chains for hand operated chain hoists - Grade TH

Contents		Page
Foreword		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	General conditions of acceptance	1
5	Dimensions	2
5.1	Nominal size, dn	2
5.2	Diameter tolerance	4
5.3	Pitch	4
5.4	Width	4
5.5	Standard gauge length	4
5.6	Weld diameter	4
5.7	Length dimensionally affected by welding	5
6	Material and manufacture	5
6.1	Quality of material	5
6.1.1	General	5
6.1.2	Type of steel	5
6.1.3	Deoxidation	5
6.1.4	Weldability	5
6.1.5	Chemical composition	5
6.1.6	Finished condition	5
6.2	Heat treatment	6
6.3	Working load limits (WLL)	6
6.4	Mechanical properties	6
6.4.1	Manufacturing proof force (MPF)	6
6.4.2	Breaking force (BF)	7
6.4.3	Total ultimate elongation, A	7
6.4.4	Bend deflection, f	7
6.4.5	Surface hardness	7
6.4.6	Toughness	7
7	Verification of safety requirements	11
7.1	Size of lot and selection of samples	11
7.2	Manufacturing proof force (MPF) -- Acceptance criteria	11
7.3	Breaking force (BF) and total ultimate elongation -- Acceptance criteria	11
7.4	Bend deflection	11
7.4.1	Bend test	11
7.4.2	Bend deflection -- Acceptance criteria	12
7.5	Hardness test -- Acceptance criteria	12
7.6	Toughness of chain test material	13
7.6.1	Toughness test	13
7.6.2	Toughness test -- Acceptance criteria	13
8	Marking	13
8.1	Grade marking	13

8.2	Manufacturer's marking	13
9	Manufacturer's certificate	13
10	Information for assembly into the chain hoist and for use	13
10.1	General	13
10.2	Assembly of hoist chain into the chain hoist	13
10.3	Hoist chain use	14
10.4	Inspection	14
	Annex A (normative) Bases for calculation	15
	Bibliography	18