ISO 16872:2015-01 (E)

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

Contents

Page

Foreword v

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 1

4 General conditions of acceptance 2

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 Verificationofsafetyrequirements 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'scertificate 13

10 Informationforassemblyintothechainhoistandforuse 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