

RETURN – ANNUAL CHECK AND REPAIR

QUALITY PROCEDURE / CPQ03 / INDICE 02

Preliminary remark

This is an internal Codipro procedure. In any case Codipro cannot be held responsible for third party claims resulting from the use of this document.

This form is only valid for the annual check/repair of CODIPRO lifting rings.

The check can only be made by CODIPRO itself (or any other designated party) or an officially certified company.

Return procedure/ Repair of swivel lifting rings

The lifting rings can be send back according to the « return/repair of swivel lifting rings procedure » together with the « return/repair form ».

Lifting ring return file

As soon as the lifting rings have been received Codipro establishes a « goods received sheet » for its production department and a “swivel rings return file”.

Control procedure:

General information: (for SEB, DSR, DSS, TSR, DSP, DSH, CSS, ADA)

- A visual check will carried out. The general aspect such as described in the technical data sheet is mandatory.
- No modification is permitted.
- No discolorations of heat, no welding, or machining marks, no deformation, no sign of unusual corrosion, no undesirable engravings.
- Undesirable engravings will be judged as not conform.

Mobility/Swivel: (for SEB, DSR, DSS, TSR, DSP, DSH, CSS)

- The shackle must be able to swivel by natural gravity in all directions (see description in the technical data sheet).
- Exception: for lifting rings with retaining spring (f.e. clips, breaks, etc.) natural gravity cannot make the rings swivel, it must be checked manually.

Thread: (for SEB, DSR, DSS, TSR, DSP, DSH, CSS, ADA)

- Visual control/check
- Testing with calibrated gauge
- Verification of the thread length according to tolerances as described in the technical data sheet.
- In case of any abnormalities the lifting ring has to be taken out of use.

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Visibility of engravings:

The engraved information which is stated on the certificate of compliance must be legible on the following elements.

- Bolt head (or on the lifting ring itself of custom-made lifting rings) :
 - Tractability mark
 - Thread type (f.e. M36, M42C, 2"UNC, ...)
 - WLL (f. e. WLL : 12T5)
- On the shackle
 - Tractability mark
- Individual engraving (for lifting rings produced from 2008 until today)
 - Type « JJ MM AA 123 » (f.e. 280414 001)
 - For lifting rings which have already been repaired the letter « R » will be added in order to indicate a repair. For lifting rings which have already passed a control without needing to be repaired the letter « V » will be added.

Tightening:

The inside and outside hex must be in compliance with the tolerances such as indicated on the technical data sheet.

Wear and tolerance of shackle for DSR and DSS

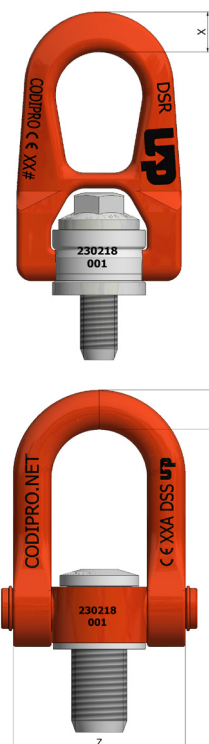
The X section must not be lower than:

- 10mm for DSR type 1
- 15mm for DSR type 2
- 24mm for DSR type 3
- 30mm for DSS type 3
- 39mm for DSS type 4
- 39mm for DSS type 4+

The Z section (lateral mobility) must not be lower than:

- 141mm for DSS type 3
- 172mm for DSS type 4
- 178mm for DSS type 4+

For SEB, TSR, DSP, DSH, CSS and ADA, please contact CODIPRO.



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