

	AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED Lifting Inspection	Doc No: QC-LIF-P-020
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Title: Inspection Procedure of Lifting Forks and C-Hooks		Rev: 2
Established By: Ashraf Elsaid	Position: Lifting Supervisor	Date: JULY-2022
Approved By: Ahmed Mohamed	Position: Operation Manager	

Inspection Procedure of Lifting Forks and C-Hooks

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1. YOUR SAFETY IS FIRST:

Your safety wear is mandatory at job sites including in general: suit, shoes, helmet, gloves, ear plugs, glasses, and mask.

2. SCOPE:

This Procedure covers the inspection and testing of Lifting Forks and C-Hooks.

3. PRODUCT/ MANUFACTURE STANDARDS:

BS EN 13155-2003+A2-2009	<i>Cranes — Safety — Non-fixed load lifting attachments</i>
AS 4991-2004	Lifting devices
B30.20 - 2018	Below-the-Hook Lifting Devices

4. DEFINITIONS:

4.1. LIFTING FORKS:

Equipment consisting of two or more arms fixed to an upright with an upper arm, essentially to lift palletized or similar loads.



4.2. C-HOOKS:

A C-form lifting equipment for lifting hollow loads.



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5. THOROUGH EXAMINATION:

The intervals for thorough examination for Lifting forks and C-Hooks (lifting accessories) shall not exceed **six months**. The following points shall be checked during thorough examination:

- Marking, as per 7. MARKING
- Main Body: for signs of damage, corrosion, cracks, bending, or distortion
- Hollow sections: for dents, buckling.
- Welds and adjacent areas (HAZ): for cracks, corrosion, or distortion.
Welds and critical load bearing areas may require inspection using NDT techniques such as MPI, which shall be performed as pre related ATS procedures (e.g. for MPI: ATS-NDT-P-001)
- Bolts, rivets: for cracks, damage, wear, corrosion, the bolting shall ensure a secure tightness.
- Load bearing (attachment) points: for wear, cracks, distortion, or any sign of damage
- Tilting mechanism of the lifting fork: condition and functionality
- In case of a C-Hook fitted with wear pad, this pad shall be checked for damage, security.

6. PROOF LOAD TEST:

Proof load is performed before being put to use for the first time, after any major repair / alternation, after heavy use, after exceptional circumstances, or as per client requirements.

lifting forks and C-Hooks are designed as per BS EN 13155 to withstand a load of $2 \times WLL$ without any permanent deformation.

Lifting forks and C-Hooks are proof load tested using a static load of $2 \times WLL \pm 2\%$, this load shall be applied so that the lines of force through the load bearing points are the same as they will be in service, application of load shall be without shock (applied gradually) with alignment being checked at the period of the test, the test is applied for a period of time of not less than 1 minute (to be loaded for five minutes max.), after the release of the static load, the lifting fork or C-Hook is thoroughly examined as per 5.THOROUGH EXAMINATION, the equipment is considered to be accepted if no signs of deformation, cracks, or any defects are present.

7. MARKING:

Marking shall be clearly visible and legible, the information to be included in the marking:

- Manufacturer's name, address, and year of manufacture
- Model
- ID number
- WLL
- Weight of unloaded attachment (self-weight of the equipment) when it exceeds 5% of the WLL of the clamp or 50 kg, whichever is less
- The limits of the intended position of the load center of gravity (COG);
- For lifting forks where a minimum load is required to tilt the fork, the minimum load shall be marked;If the item is not already marked, it shall be clearly marked with an identification number and if the test is satisfactory, the WLL and date of the test.

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8. REPORTING AND CERTIFICATION:

A certificate of test and thorough examination will be issued upon the satisfactory completion of the examination, i.e. the lifting equipment is safe to operate

A defect report will be issued if the lifting equipment fails to meet the requirements.

9. Inspector Competency and Qualification:

Inspector shall have minimum qualification of LEEA Foundation – LEEA Lifting Equipment General