


Original operating manual for Special Master Link T

Special Master Link T										
	Chain Ø		Code	Commercial Code	Measurements				Weight	Working Load Limit 0°-45° *)
	⊥	∧			d	t	w	s		
	mm	mm			mm					
	6+7+8	6+7	T 87.8	T 13	14	120	70	10	0.44	2,300
	10	8	T 108.8	T 16	16.5	140	80	14	0.67	3,200
	13	10	T 1310.8	T 20	20	160	95	14	1.21	5,400
	16	13	T 1613.8	T 26	27	190	110	20	2.65	10,100
	18+20	16	T 2016.8	T 32	33	230	130	26	4.78	15,700
	22	18+20	T 2220.8	T 38	38	275	150	29	7.48	20,500
	26	22	T 2622.8	A/T 45	45	340	180		12.82	30,800
	32	26	T 3226.8	A/T 50	50	350	190		16.60	40,000
	36	32	T 3632.8	A/T 56	56	400	200		23.30	60,000

Static test coefficient = 2.5; Safety factor = 4

*) The working load limit is not to be used as classification for chain slings.

These Special Master Links T are designed for the assembly of chain slings and after reading the operating manual as well as to the current national norms for lifting and transporting purposes. KWB Super Alloy Special Master Links T can be combined with suitable components (Super Alloy chains, connecting links and hooks) to build chain slings. This product meets the requirements of the EU Machinery Directive 2006/42/EC and is only to be used when taking into consideration the declaration of incorporation and after reading and understanding the operating manual. The operating manual must always be available to the user until the links are discarded. It is updated continuously and is only valid in its latest version, which can be downloaded from the following link www.kwb-ketten.at.

Conditions of use

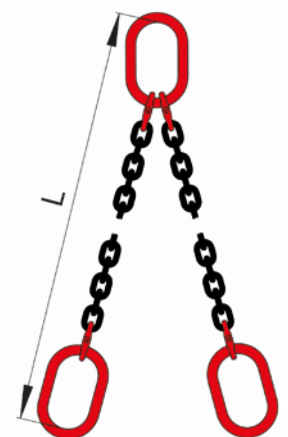
Purpose of use: Special Master Links T are designed for the mounting of chain legs. They serve as an attachment of the lifting chain to the crane hook, hooks or to the lugs of the load. Analogously, they can be attached to wire rope slings.

Load: the load must act in the longitudinal direction and on the plane of the link. The inclination angle of the adjusted chain legs must not exceed 60°. Working Load Limit values are defined in the table above – note that for wire rope slings the working load limit value defined for safety factor number 4 is valid. Special Master Links T must move freely and be aligned to the load direction.

Admissible operating temperature: -40 °C to 200 °C

Impacts: the load must be applied without any impact or shock loading

- Special Master Links T must only be used by competent personnel
- Special Master Links T must be checked before each use for visible signs of damage



Restrictions of use

Under certain conditions, the use of Special Master Links T is restricted (see table below). The table below describes certain loads with their corresponding reduction factors. Safe working load values are calculated by multiplying the working load limit with the reduction factor defined in the table. If more restrictions of use are applicable during a lifting process, all corresponding reduction factors must be taken into account.

Reduction factors			
Temperature*	-40 °C to 200 °C	above 200 °C to 300 °C	above 300 °C to 400 °C
Reduction factor	1	0.9	0.75
Impact Load	Slight impacts created, for example, when accelerating during the lifting or lowering movement	Medium impacts created, for example, when the chain is loaded but it slips while adjusting to the shape of the load	Strong impacts created, for example, when the load falls onto an unloaded chain
Reduction factor	1	0.7	Impermissible

* The use at temperatures below -40 °C and above 400 °C is forbidden!

All instructions given in this operating manual assume the absence of extremely dangerous conditions. Such extremely dangerous conditions include offshore activities, lifting of people and potentially dangerous loads, such as liquid metals or nuclear material. In these cases, the admissibility and extent of the risks are to be assessed by KWB.

Reasonably foreseeable misuse

Special Master Links T are not designed to be used with food, cosmetics or pharmaceutical products, and must not be subjected to severe corrosive influences (e.g. acids, sewage, ...). They must not be used in explosion-protected areas or exposed to the fumes released by acids or chemicals. They also must not be used under other circumstances as the one described in Conditions of use and Restrictions of use – e.g. transverse or flexural loading. Do not apply any surface coating procedure with damaging effects on the materials (e.g. hot galvanizing or electrogalvanizing) and do not subject them to heat, welding or drilling processes.

Assembly instructions

The assembly may only be executed by a qualified person. KWB Super Alloy Special Master Links T can be combined by means of connecting links with other KWB Super Alloy (G8) chain sling components – especially Super Alloy chains – to form chain slings. The assignment of the right chain dimension is to be found in the table above – for 1-leg chain slings see column 1, and for 2-leg chain slings see column 2. Only 2 chain legs can be directly attached to special master links. When repairing Star Alloy (G10) chain slings, Special Master Links T can also be used as long as a misinterpretation by the user is excluded – e.g. by means of a unified coloration and correct identification. It is vital to pay attention to the right marking of the working load limit of the whole system (WLL on identification tag). The weakest part will determine the working load limit. The lifting accessory into which the master link is to be incorporated must be declared in conformity with the provisions of the Directive 2006/42/EC. Only non-damaged parts must be assembled. Defective Special Master Links T must not be used and used Special Master Links T must be inspected before the assembly process as described below under the section Maintenance, Inspections and Repairs.

Safety precautions to be taken by the user

Gloves must be worn during the whole process. When using Special Master Links T under conditions with restrictions of use, working load limit values must be reduced by the above reduction factors in order to assure the required security level.

How to act in case of accidents or damages

After deformation of the Special Master Links T (e.g. because of overloading) or other extraordinary events, take the lifting assembly out of service for inspection or repair by a qualified person.

Residual risks

Overloading because of exceeding the working load limit or not reducing the working load limit when influences under severe conditions such as temperature, asymmetry, edge load or impact occur, can lead to failure on the enlarged master link. Other factors are unsatisfactory adjustment, transgression of the permitted angle of inclination, strong vibrations with high load, transverse loading or the use of uninspected enlarged master links. In such cases, the load could fall causing injuries or fatalities among the workers who work or operate near the lifting equipment.

Maintenance, Inspections and Repairs

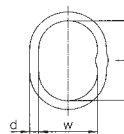
Maintenance: Special Master Links T shall be cleaned regularly, dried when exposed to wet atmospheres and protected from corrosion, e.g. lightly oiled.

Inspections: Special Master Links T need to be inspected in a clean condition – they must not contain oil, dirt or rust. Painting is only permissible if an evaluation of the master link condition is possible. When cleaning, do not subject Special Master Links T to processes which cause material embrittlement (e.g. pickling), overheating (e.g. flame cleaning), material abrasion (e.g. sand blasting), etc. Surface cracks or other defects must not be covered. Master links must be checked before each use for visible signs of damage. Once a year an inspection must be carried out by a competent person. However, this period must be shortened in view of the conditions of use – e.g. because of frequent use with maximum load capacity or under conditions with restrictions of use, wear or corrosion. It is recommended to subject Special Master Links T every two years to a crack test. There are different ways of crack testing: subjecting the master link to a load test with 2 times the working load limit, followed by a visual inspection, a magnetic crack test or a dye-penetration method.

Withdrawal:

- Broken parts, deformation, notches, cracks of all types
- Signs of heat (e.g. discoloration or coating-burn off)
- In the case of doubts about the safety and correct functioning of the Special Master Links T
- Unrecognizable identification marking
- If wear or excessive corrosion occurs and the tolerable change of measure is transgressed (see following table)

Measure	Max. permitted change
d	-10 %
t	+10 %



Repair: Special Master Links T are only to be repaired by a qualified person.

Welding, heat treatments, as well as the straightening of bent master links are not permitted. Inspections and repairs have to be documented and the corresponding reports have to be retained during the service life of the Special Master Link T.

Storage

KWB Super Alloy Special Master Links T shall be stored cleaned, dried, protected from corrosion, e.g. lightly oiled. While stored, they must not be exposed to corrosive, mechanical or thermal influences.

Declaration of incorporation

In accordance with the requirements established in Annex II, part B, of the EU Machinery Directive 2006/42/EC for components in lifting accessories:

This is to inform you that the product mentioned in this original operating manual is designed to be incorporated in lifting accessories complying with all essential requirements of the EU Machinery Directive 2006/42/EC. This product must not be put into service until the final lifting accessory into which it is to be incorporated has been declared in conformity with the provisions of the Directive 2006/42/EC. Moreover, it is a precondition that this operating manual has been read and understood. This declaration has no legal effect if any changes to the product are introduced without KWB's approval.

Following essential safety and health requirements of Annex I of the Directive are applied and fulfilled: 1.1.3, 1.3.4, 1.5.4, 4.1.2.3, 4.1.2.5, 4.3, 4.4.1.

Additionally, we declare that the relevant technical documentation is compiled in accordance with part B of Annex VII and will be transmitted electronically due to a well-founded request by the national competent authority.

The person authorised to compile the technical documentation:
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