



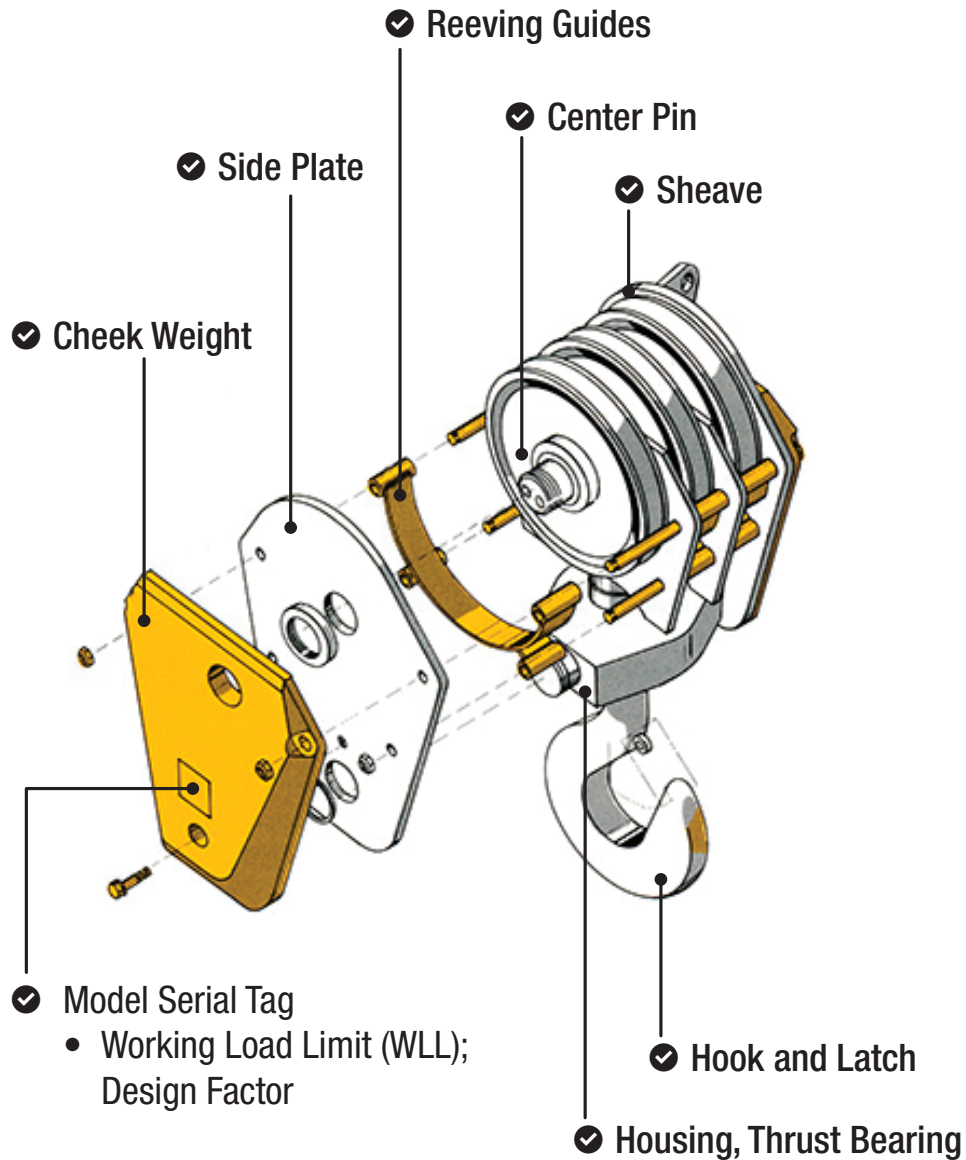
GUNNEBO
Industrier

Block and Ball Inspection Checklist



Block and Ball Inspection Checklist

The purpose for the inspection check list is to provide a quick reference for checking the integrity of a Block or Overhaul Ball for continued use. The inspector must be aware of elongation, cracks, fractures, corrosion, unauthorized welding, damage to bearings and have NDT testing performed if necessary to assure product integrity.



Never use a crane block without a legible identification tag...Crane block tag is required to insure proper block application."All hook and ball assemblies and load blocks shall be labeled with their rated capacity and weight." - ASME B30.5-1.7.6.

Gunnebo Johnson recommends a complete tear down inspection of crane blocks and overhaul balls every five (5) years to include a full magnetic particle inspection of the hook or load fitting, unless a more frequent period is required by regulation, statute, standard, policy or indicated by previous inspection.

The following findings shall be cause for crane block removal from service until repaired or replaced:

- Elongated center pin and hook trunnion holes exceeding 5% of original diameter,
- Bent side plates,
- Severe corrosion pitting
- Corroded hook threads,
- Bent or twisted hook,
- Welding on hook,
- Damaged or dysfunctional hook latch,
- Cracks in sheaves, side plates, cheek weights, center pins, hook trunnion, dead end connections and hook.
- Material loss due to wear exceeding 10% of original section.
- Sheave wobble,
- Deeply corrugated (not imprinted) sheave grooves,
- Sheave wire rope groove diameter smaller than 2.5% or greater than 10% of the nominal wire diameter,
- Missing or damaged retaining nuts, snap rings, set screws, cotter pins, tie bolts, hook nut cap screws and lock wire,
- Missing or illegible rating and warning tags.

The following findings shall be cause for crane block removal from service until corrected:

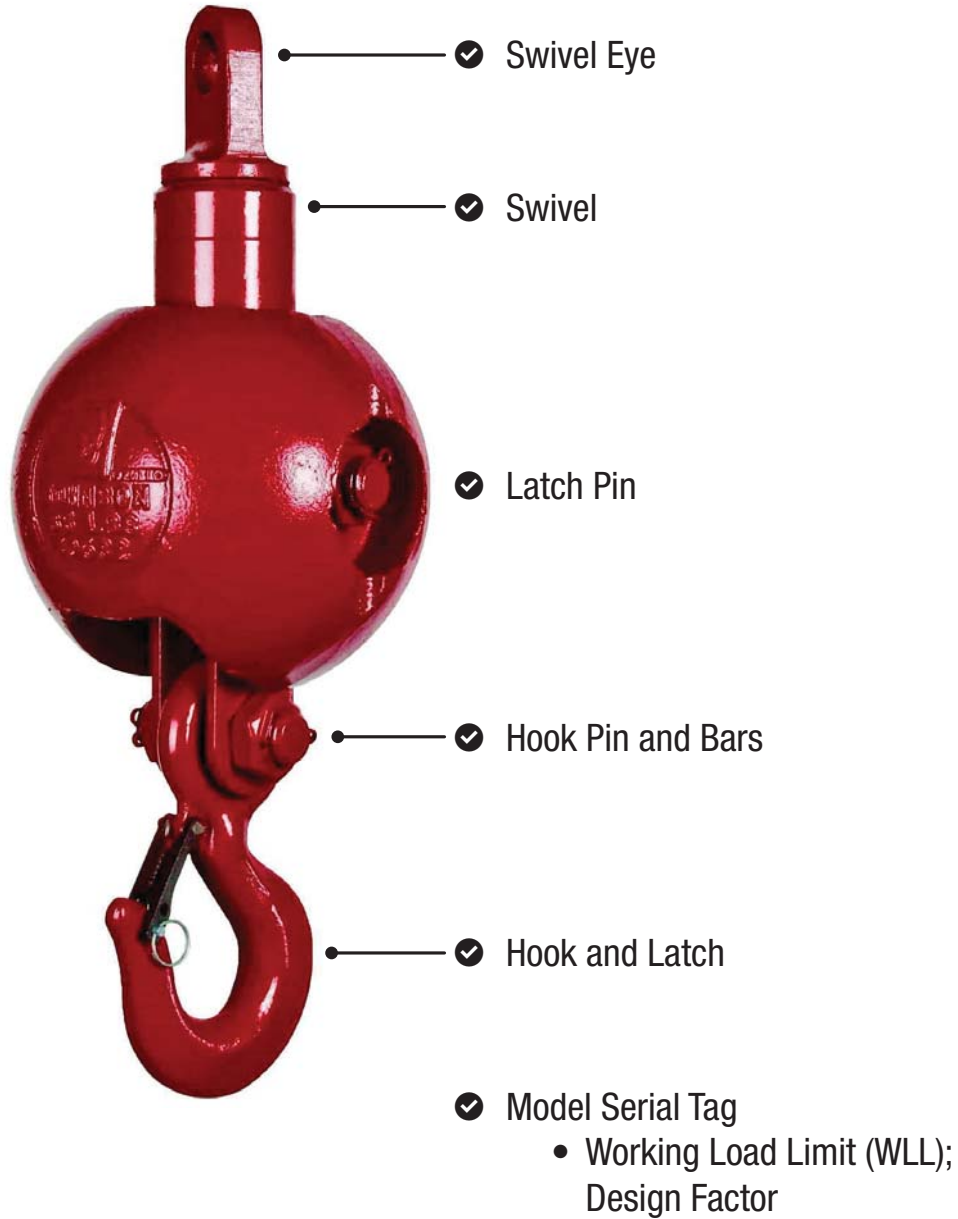
- Loosened tie bolt nuts, center pin round nuts, cheek weight cap screws and hook nut cap screws. Tie bolt nuts to a torque of 35 - 40 ft-lbs and restacked, all other fasteners wrench tight.
- Lack of sheave and hook bearing lubrication. Continuous operation: lubricate bushings every 8 hours and roller bearings every 24 hours. Intermittent operation: lubricate bushings and bearing every 14 days.

For additional information please refer to the **Gunnebo Johnson Crane Block Warning and Use Limitations** located on our website:

http://www.gunnebojohnson.com/wp-content/uploads/63516_craneblock.pdf

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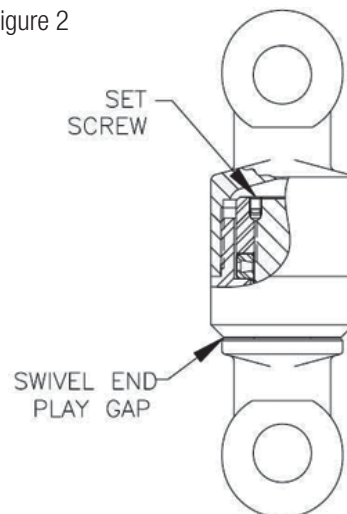


Never use an overhaul ball without a legible identification tag... Overhaul ball tag is required to insure proper ball application. All hook and ball assemblies and load blocks shall be labeled with their rated capacity and weight. - ASME B 30.5-1.7.6.

The following findings shall cause overhaul ball removal from service until replaced or repaired:

- Elongated ball pin holes hook latch pin holes and swivel eye exceeding 5% of original diameter,
- Swivel end play gap exceeding .08". Excessive endplay indicates damaged internal set screw. (See Figure 2)
- Bent connector plates,
- Severe corrosion pitting,
- Bent or twisted hook,
- Welding on hook,
- Damaged or dysfunctional hook latch,
- Cracks in connector plates, ball casting, ball pin, hook latch pin, swivel and hook,
- Material loss due to wear exceeding 10% of original section,
- Loose, missing or damaged retaining nuts, cotter pins or swivel set screws or missing or illegible rating and warning tags.

Figure 2



For additional information please refer to the **Gunnebo Johnson Crane Block Warning and Use Limitations** located on our website:

http://www.gunnebojohnson.com/wp-content/uploads/63516_craneblock.pdf

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