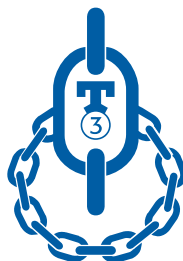




KWS
INC.



THIELE®



KWS CATALOG 6.0

Rev. 2

Made
in
Germany

> Lifting Technology

> Load Securing Technology

> Light Material Handling

> Application Technology



CONTACT US

Sales & Service

Our friendly sales team is available for quotes, receiving & processing orders, and technical service.

Address

KWS Inc.
P.O. Box 470487
Tulsa, OK 74147
USA

Business hours

Monday to Friday:
8:00 am – 5:00 pm Central Time

Toll Free: +1 (800) 872-9313
Phone: +1 (539) 367-2274
Fax: +1 (539) 367-2278
Email: sales@kwschain.com

WARNINGS:

Warning instructions are included in this catalog. Operating instructions for each product are either included with the products and / or are available at www.kwschain.com.

Manual instructions must always be reviewed before operation. Failure of the product can occur due to misapplication, abuse or improper maintenance, resulting in possible property damage, personal injury, or death.

Ratings shown are applicable to new products. Working Load Limits indicate the greatest force or load a product can take. Extraordinary conditions must be taken into account.

The Working Load Limit of a chain sling must not exceed the working load limit of the weakest component in the system. The proof load on all items in this catalog is 2 times the working load limit unless otherwise shown.

Please also read the manual instructions and users guide on page 173-179 and download manuals using the QR-code below or from our website www.kwschain.com.



*QR-Code for downloading
operating and mounting
instructions*



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Company Profile



Our Parent Company

THIELE was established in Iserlohn-Kalthof, Germany more than 85 years ago and the company is now one of the world's leading manufacturers of chain systems. The forging of quality components has become our focus and our strength. Customers benefit from our established expertise in product design and manufacturing, with everything we supply being produced at our plant in Iserlohn, Germany.

In addition to supplying the traditional markets for conveying and lifting equipment, we also operate in new future-oriented sectors like mobility and renewable energies.

Our ultimate goal is customer satisfaction based on fulfillment of high quality products that exceed environmental and safety requirements. THIELE has a quality management system certified according to ISO 9001 and an environmental management system certified according to ISO 14001.

THIELE is also certified according to ISO 50001 energy management system and ISO 45001 occupational health and safety management system.

The longevity of our high-quality products saves resources and protects the environment.

Therefore, they enjoy an excellent reputation among our customers worldwide.

KWS Inc.

In 1995 the company THIELE GmbH & Co. KG established operations in the United States specifically focused on the sales of the THIELE brand of overhead lifting chain and components. Since then, Conveying Chain, Fishing Chain, Lifting Points, Manual Cranes, Hoist Chains as well as Magnet Chain Slings have been added to the product line. New products are continually being added, most recently various fittings and additional trade sizes to the Grade 100-Product range. Today, KWS Inc., with its main warehouse in Beckley, WV and regional warehouses in Chicago, IL and Los Angeles, CA, is able to supply German-made quality products to its valuable customers quickly. Our commitment is: "You need it,

we have it"! Our logistics system ensures stock availability of at least 6-month sales, unique in the industry! THIELE GmbH & Co. KG is an innovative manufacturer with a long tradition in the production of round steel chains and forged parts for the Lifting technology sector.

Still today the company is family-owned. In close cooperation with our customers we are always searching for better and more innovative solutions. We are also supported by renowned universities and leading research institutes. We are continuously researching new knowledge in material technique and shaping in order to develop lighter, more solid, and safer products.



In addition to aforementioned companies, the following also belong to the THIELE-group:

Schlieper GmbH & Co. KG (GER)
RH THIELE GmbH & Co. KG (GER)
Reilloc Chain Ltd. (UK)
THIELE Asia Pte. (SIN)
RM Wilson Comp. (USA)
T-Con Ltd. (CN)

KWS Inc. Conditions of Sale & Limited Warranty

Payment Terms:	1 % 10 days, net 30 days from date of invoice
Delivery Terms:	F.O.B. shipping point (within continental US only) Freight prepaid at lowest tariff rate on shipments of 2,000+ lbs.
Cut Chain:	A minimum charge of 20 % per foot will be applied to each length of chain cut from stock
Special Items:	All orders for non-stock items will be accepted based on the understanding that the delivered quantity can vary plus or minus 10 % from the original quantity and invoice will be issued accordingly.
Returns:	Return requests will only be honored on standard items in new condition and within 90 days from original invoice date. The customer is responsible for return freight. If returned item is part of original prepaid shipment, a portion of original freight will also be assessed against the returned item. Minimum standard restocking charge is 20 % or US\$ 50.00 whichever is greater. If item is not in new condition, credit will not be issued and item will be discarded.
WARNINGS:	<p>Download and read operating instructions before usage! Please use the QR-code below to retrieve the files or go to www.kwschain.com. To prevent accidents, proper selection, application, and loading of chains and accessories is absolutely necessary.</p>  <p>NEVER exceed the published working load limits of chains and accessories and NEVER use slings outside the specified temperature range. Accessories must always have equal or higher working load limits than the chain.</p>
THIELE Plant Standard (TWN)	THIELE products acc. to THIELE Plant Standards (TWN) fulfill the requirements of the EC-Machinery Directive  for Machines, particularly for the safety relevant components.
Disclaimer:	KWS Inc. conditions of sale apply error and omissions excepted.
Liability and Copyright:	All information given is based on our current knowledge and expertise and is supplied without obligations or commitments. This also applies to the patent rights of third parties. We do not give any obligatory warranty in the legal sense as to the properties of the products described in this publication. We expressly reserve the right to change our specifications in accordance with technical progress and company developments. This does not release the buyer from his obligation to inspect all incoming products. The quality of all our products is of course guaranteed in accordance with our general terms and conditions of sale. The copyright for the published objects remains exclusively at the author of this document. Any duplication or utilization of such graphics or texts in other electronic or printed publications are not allowed without any agreement of the author.



**YOUR
ONE-STOP
PROVIDER**

Our range of services:

- Bending
- Forging
- Different welding processes
- Laser, plasma and flame cutting
- Multi-spindle milling machines
- CNC machining
- Assembly and end production
- Heat treatment
- Painting and surface finishing

General Information



Product development

Our in-house manufacturing base covers the entire process from raw material through to the final product.

High-level expertise leads to short developing times, especially when new products are designed.



Modern 5-spindle machining centre



Manufacture of dies, trim dies and calibration tools

FEM simulation

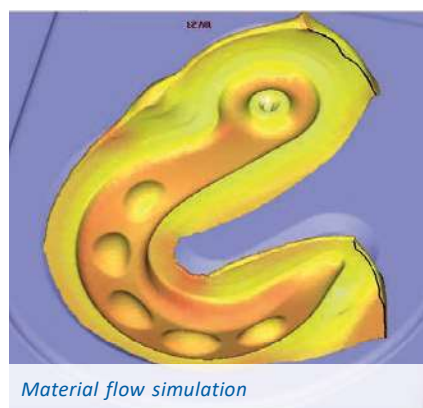
With precise calculations and the experience of our engineering team, we carry out stress analysis before production begins. This makes the product development process highly efficient and optimized to the maximum.



FEM simulation of a XKE-Point

Material flow simulation

3D simulations optimize the forging process, enable precise volume calculations, increase efficiency and have a positive impact on the product quality.



Material flow simulation



CNC machining



General Information



WHAT YOU CAN EXPECT FROM US

High added value and state-of-the-art forging aggregates

Our range services:

Forging machines (16 - 160 kJ) | forging presses (up to 1,600 t)
component weights from 100 g to 100 kgs | lengths up to 1,350 mm

Our forged products are based around a large selection of materials:

- Chain steels (DIN 17115)
- Non-alloy heat-treatable steels (DIN EN ISO 683-1)
- Alloy heat-treatable steels (DIN EN ISO 683-2)
- Case-hardened steels (DIN EN ISO 683-3)
- Non-alloy structural steels (DIN EN ISO 10025-2)

Special steels, e.g. high-alloy corrosion-resistant, heat-resistant and antimagnetic steels, are available on request.

Heat treatment:

A process-based heat treatment stage delivers the final product characteristics. Our state-of-the-art, fully automated heat treatment plant ensures that the end-products meet the highest mechanical requirements.



QR-Code to movie of Mr. Thiele making the first blow forge of the new forging hammer.



Square billets (edge length 50 to 120 mm) or round bar material (18.5 to 200 mm in diameter) can be used as raw material.



General Information

KWS SERVICE

KWS Catalog 6.0

You can download our KWS Catalog.



*KWS Catalog 6.0
Rev. 2*

3D CAD Data

All user information, geometry data and CAD download can be found on the respective product pages of our website www.kwschain.com. Our website provides an excellent resource for engineer-friendly files!



Website/ Products

Operating and Mounting Instructions

The operating and assembly instructions for all THIELE lifting products contain important information for a safe operation in the sense of the EC-Machinery Directive. They must be read before operation.



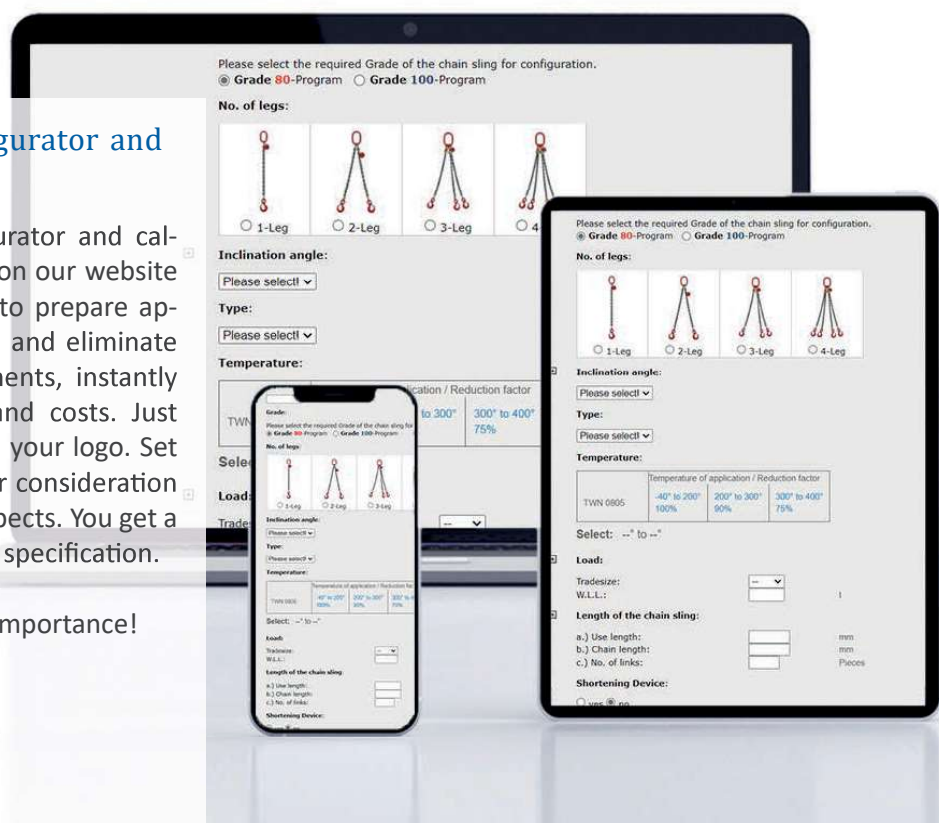
*Operating and mounting
instructions*

THIELE Chain Sling Configurator and Calculator (TKGK)

The THIELE chain sling configurator and calculator in the customer portal on our website makes it much easier for you to prepare appropriate offers. You save time and eliminate errors when selecting components, instantly calculating lengths, weights, and costs. Just upload your company data and your logo. Set up your customized offer under consideration of commercial and technical aspects. You get a structured offer with a detailed specification.

At THIELE, service is of utmost importance!

Please ask for your login data.



THIELE-LIFTING-EVOLUTION



is the brand feature of the THIELE Lifting components.



All new THIELE lifting components offered by KWS Inc. are developed with a new design.

The design ensures you can differentiate THIELE products from the other brands.

For more than 85 years, THIELE stands for world class quality with our rugged design.

The ellipses style design adds value by improving consumer confidence while using THIELE components for their lifting application needs.

Our in the field knowledge with lifting products have shown that the assured product properties are not always being upheld. Standards are often cited but not extensively fulfilled.

The requirements on safety for lifting products are more than a determination of a breaking force.

The intensity of intermediate quality controls within the production cycle creates a difference in the end result of the quality of the product. Our motto:

“At THIELE you always know, what you get!”

The ellipses style hooks will improve the orientation while in use. The enhanced design makes our product more modern, and dynamic compared to the competition.

“Lifting, moving and securing of loads in shape”. The improved design is a reflection of our consumers' expectations of THIELE for decades. We are committed to investing in our superior quality standards.

The result of years of experience with controlled and safer sophisticated processes in our production.

“MADE BY THIELE!”



Not available on Connectors, Master Links and Lifting Points.

Our Product Range



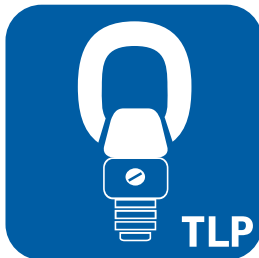
**Lifting Products
Grade 100**



**Lifting Products
Grade 80**



**Lifting Products
Offshore**



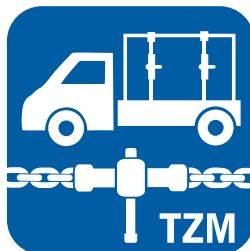
Lifting Points



Hoist Chains



Load Lifting Equipment



Lashing Products



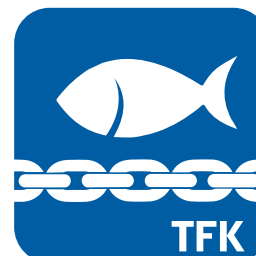
Poultry Chains



Farming Chains



Chain Sprockets



Fishing Chains



Inspection Service



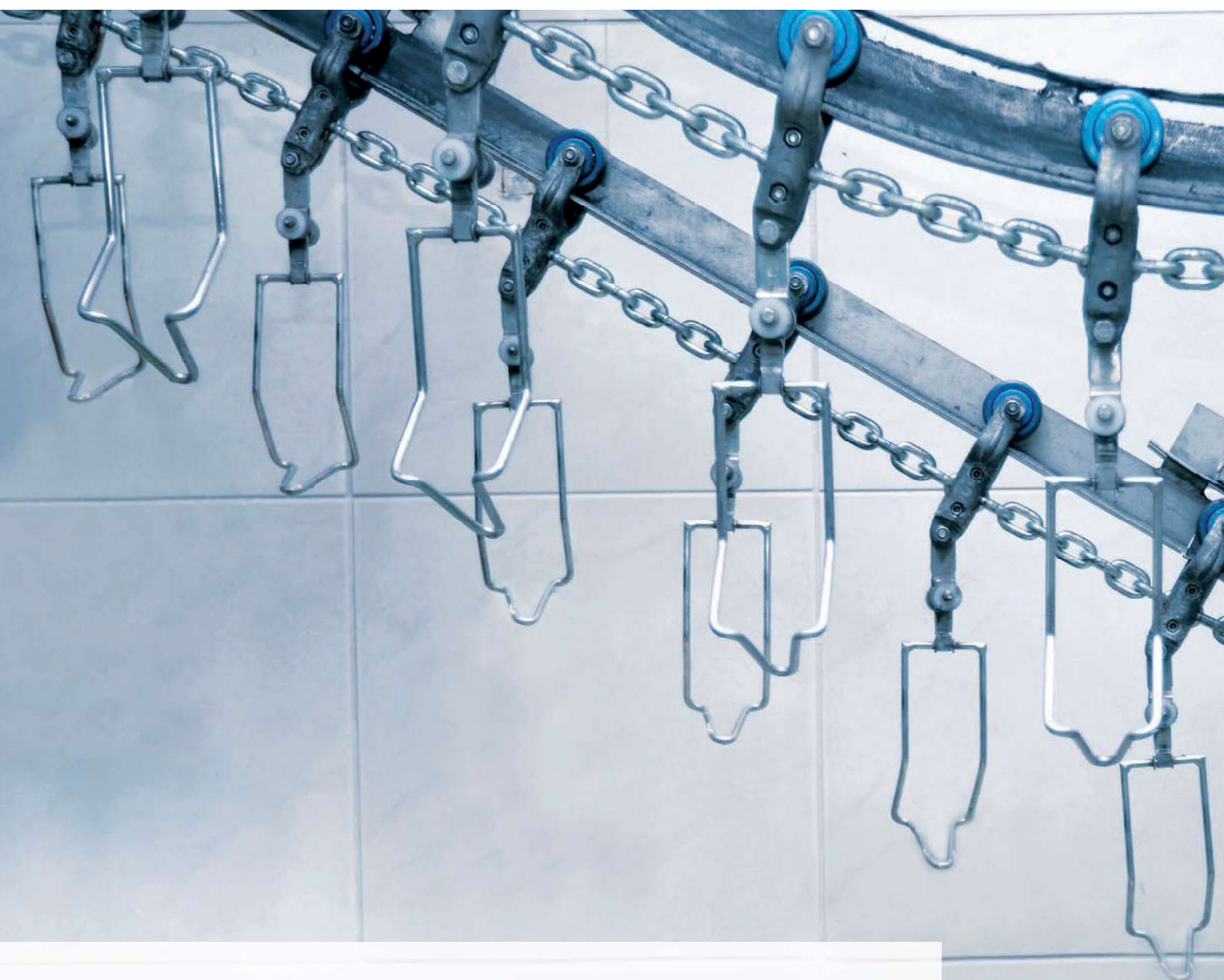
Engineering



KWS



THIELE®



THIELE POULTRY CHAINS

Conveyor Chains for Slaughterhouses

Calibrated Poultry Conveyor Chains TWN 0085

The calibrated conveyor chains TWN 0085 are used for applications in the poultry industry, especially in slaughterhouses, as a central means for power and drive. The special THIELE case-hardening ensures a high wear resistance and the galvanized surface provides a high corrosion protection of the round steel chains. The manufacturing and testing requirements are based on manufacturer specific specifications.

The fine tolerated round steel chains are offered in standard lengths of 50 m.

THIELE provides screw-type connecting links (TWN 0086) to connect the chain lengths.

Dimension [mm]	Article-No.	Pitch p [mm]	Pitch- Tol. [mm]	Inner Width w ₁ [mm] min.	Outside Width w ₂ [mm] max.	Multi Pitch Length 11 x p [mm]	Multi Pitch Length Tol. [mm]	Weight app. [lbs/ft]
8 x 25.3	F05470	25.3	-0.2/ +0.3	9.2	26.0	278.3	-0.0/ +1.0	0.94
8 x 25.4	F05471	25.4	-0.2/ +0.3	9.6	26.1	279.4	-0.4/ +0.6	0.89
8 x 38.0	F05472	38.0	-0.2/ +0.3	13.3	30.0	418.0	-0.0/ +1.1	0.81
10 x 38.0	F05473	38.0	-0.25/ +0.5	12.5	34.0	418.0	-0.5/ +1.4	1.34

Technical Properties:

Description	Nominal Size [mm]	Test Force [kN] min.	Breaking Force [kN] min.	Surface Hardness [HV1]	Hardening Depth at HV 550 [mm]	Surface Thickness [μm] min.	Compatible with*
T50E	8 x 25.3	24	40	min. 750	0.4 - 0.56	25	S
T50E	8 x 25.4	24	40	730 - 830	0.4 - 0.56	12	S, M, F, L
T80E	8 x 38.0	24	40	730 - 830	0.4 - 0.56	12	
T50E	10 x 38.0	37.5	62.5	730 - 830	0.5 - 0.70	12	
T80E	10 x 38.0	60	98	730 - 830	0.5 - 0.70	12	
T50V	8 x 25.4	24	40	min. 250	—	—	

Material-Options: *Manganese Steel, Chrome-Nickel-Steel*

***Feature:** suitable for S = "Marel Stork"; M = "Meyn", F = "FOODMATE"; L = "Linco"



Finish: *electro galvanized*

Poultry Chains

Round Steel Chains made of corrosion-resistant Austenitic Steel TWN 0085

The round steel chain has been the central element in the power transmission in the poultry processing industry, especially for slaughterhouse operations. Round steel chains are being used on nearly all type of production lines, e.g. at slaughter, cutting and cooling lines.

The fine-tolerance round steel chains are made from austenitic steel and are offered in standard lengths of 50 m.

Dimension [mm]	Article-No.	Pitch p [mm]	Pitch-Tol. [mm]	Inner Width w ₁ [mm] min.	Outside Width w ₂ [mm] max.	Multi Pitch Length 11 x p [mm]	Multi Pitch Length Tol. [mm]	Weight app. [lbs/ft]
8 x 25.4	F054711	25.4	-0.2/ +0.3	9.2	26.1	279.4	-0.4/ +0.6	0.89

Technical Properties:

Description	Dimension [mm]	Test Force [kN] min.	Breaking Force [kN] min.
T60R	8 x 25.4	37.5	60

Material: Corrosion-resistant austenitic steel (1.4404/316L or similar)

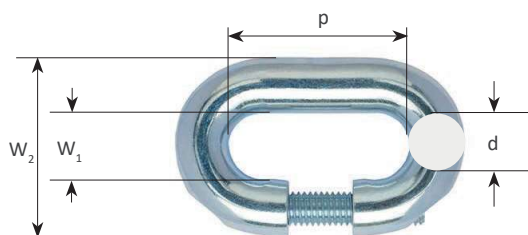


Finish: Bright finish

Screw-type Connecting Links TWN 0086

The screw-type connecting links TWN 0086 are used to easy connect conveyor chains in poultry slaughterhouses. The special THIELE case-hardening ensures high wear resistance and the galvanized surface provides high corrosion protection of the round steel chains. The manufacturing and testing requirements are based on manufacturer specific specifications.

Dimension [mm]	Article-No.	Pitch p [mm]	Inner Width w ₁ [mm] min.	Outside Width w ₂ [mm] max.	Breaking Force [kN] min.	Surface Hardness [HV10]	Hardening Depth at HV 550 [mm]	Weight app. [lbs/ft]
8 x 25.4	F42077	25.4	9.3	26.1	30	550 - 600	0.2 - 0.3	0.03



Finish: Electro galvanized



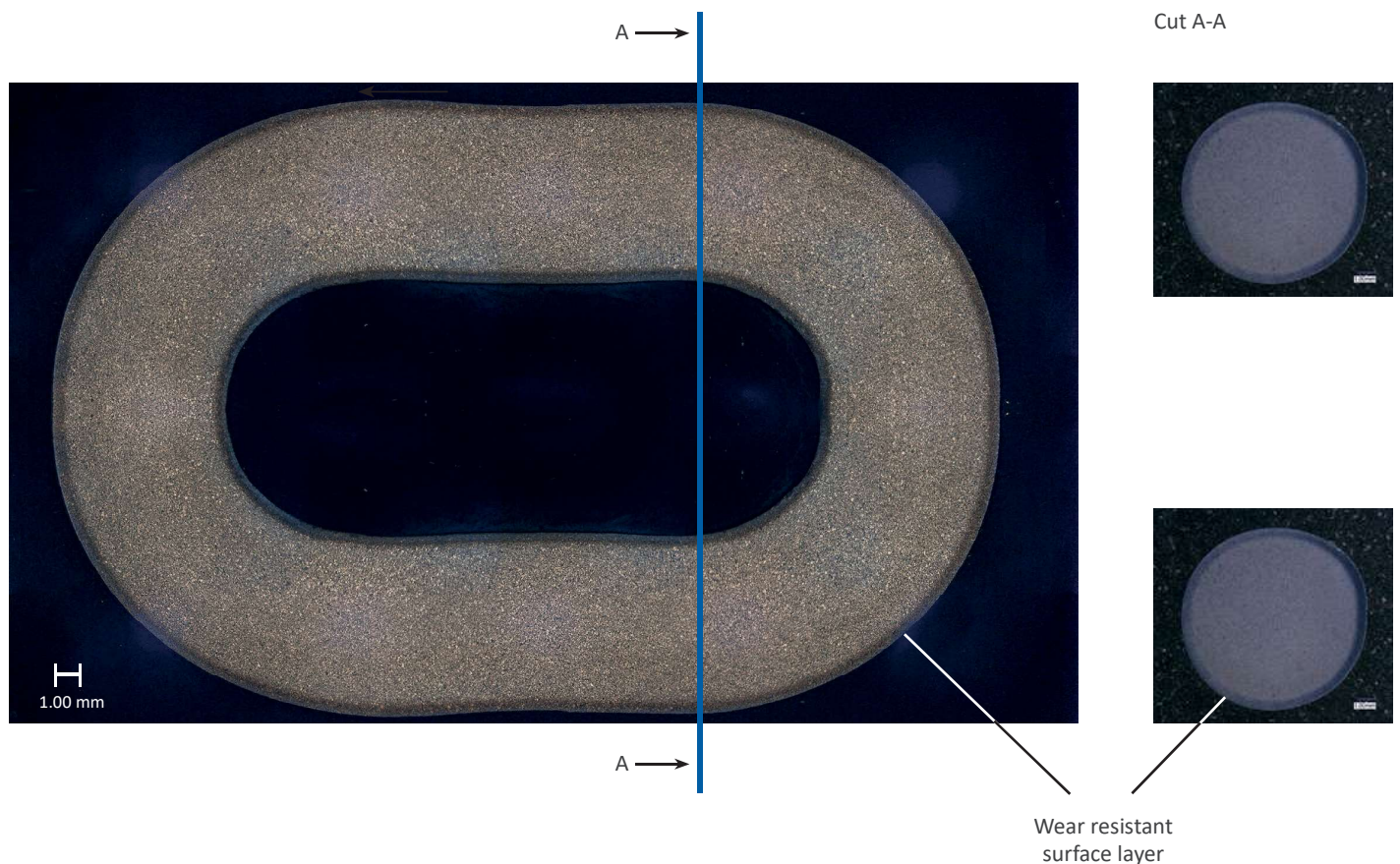
THIELE fine-tolerance round steel chains are manufactured with a high dimensional accuracy over a defined measuring distance.

Dimensional accuracy plays a decisive role and has a major impact on the operating life of the chain. Another important factor in ensuring a frictionless operation between the round steel chain and the drive and take wheels, is dimensional coordination to each other.

The two key factors that affect the service life of round steel chains are wear and corrosion.

THIELE uses a specific case hardening process to minimise the wear. The process applies carbon diffusion into the surface of the material in order to render the wear resistance of the chains.

Case Hardened Round Steel Chain 8 x 25.4 mm



Round steel chains operating in slaughterhouse lines are exposed to chemical influences, such as cleaning agents. As a result, round steel chains are exposed to a continuous process of corrosion. Therefore, the round steel chains TWN 0085 are protected with a galvanic coating to counteract the effect of corrosion.

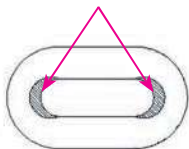
Poultry Chains

Wear

In operation, round steel chains are exposed to wear at the interlinks.

The interlink wear causes a pitch elongation of the chain link and therefore of the complete conveyor chain.

Primary wear at the interlinks



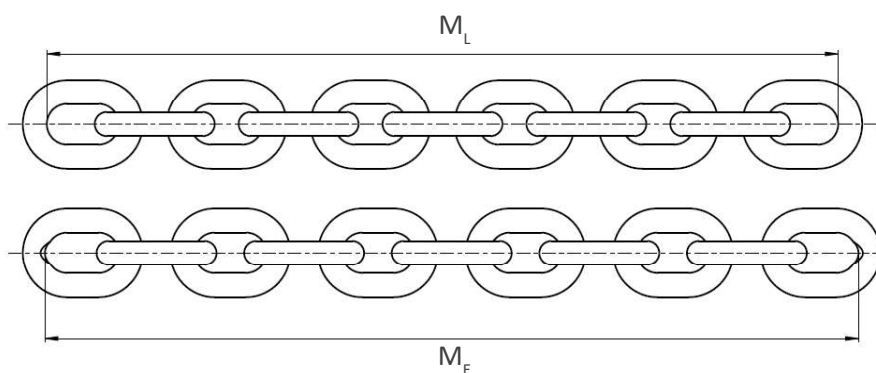
THIELE conveyor chains are produced with a corresponding surface hardness and hardening depth.

Discard criteria

Any frictional process will inevitably result in material loss, especially in the interlink areas. THIELE as a manufacturer recommends to take round steel chains out of operation once the total elongation over a defined length exceeds 2 %.

The definition of the discard criteria is calculated with the following formula, taking a measuring length of 11 link pitches into consideration:

$$\text{POINT OF DISCARD} = M_E > 2 \% M_L + M_L$$



Legend:

M_E = actual measured test section in use (actual value)

M_L = Original length of the section (as per manufacturer specification)

To continue using the chain beyond this point of discard may result in an excessive wear of the chain and chain wheels. It may also cause functional failures which may lead to costly production downtimes.



Poultry Chains

The requirements imposed on the fracture mechanics of round steel chains are derived from the process parameters.

The speed and load conditions under consideration of the coefficients of friction and deflection, are essential to determine the breaking force requirements of the chains.

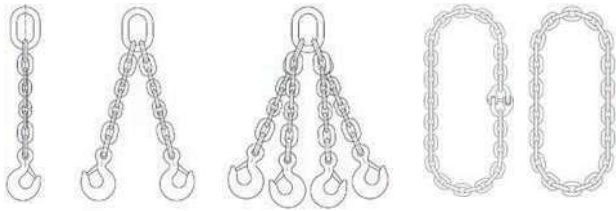
THIELE provides a range of different material grades and heat treatments for individual customer applications. They are precisely coordinated with the equipment manufacturer or plant operator on a case-by-case basis.


THIELE has experience in manufacturing round steel chains for poultry processing plants for many decades and work as the central element in power transmission.


THIELE Poultry Chains **The central element in power transmission**



Safety Instructions and Requirements (Vers. B11082-D US 07.23)







WARNING

The following operating instructions must always be followed to avoid the risk of personal injury or property damage.

Do not use a chain sling before reading these operating instructions.

1. ABOUT THIS INSTRUCTION

These operating instructions describes in particular how sling chains according to TWN 0805A grade 80, TWN 0072 and TWN 1805 grade 100 (TWN = THIELE Shop Standard) are to be safely used for lifting purposes.

The instruction applies analogously to components of the identical design.

To comply with these instructions is essential to help avoid hazards and increases the reliability and service life of the chain slings.



DANGER! Indicates a hazardous situation which, if not avoided, will result in death or serious injury.



WARNING! Indicates a hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION! Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.



NOTICE! Is used to address practices not related to physical injury.



Safety Instructions signs indicate specific safety-related instructions or procedures.

Chains and accessories marked with the American nominal size 7/32" already corresponded to the European nominal size 6 mm. In order to achieve a better match, the previous nominal size 7/32" is now converted to the new nominal size 1/4" #.

The working load limits have now also been adjusted.


DEFINITIONS


Clevis

A U-shaped fitting with pin.

Working Load Limit (WLL)

The maximum load which a chain sling is designed to support in direct tension without shock loading at a designated sling angle of lift.





NOTICE


Read ASME B30.9 "Slings", Chapters 9-0 and 9-1.


Read ASME B30.10 "Hooks".

Read ASME B30.26 "Rigging Hardware",
pChapters 26-0, 26-1, 26-4.

If chain slings are used with lifting magnets, read ASME B30.20 "Below-the Hook-Lifting-Devices", Chapter 20-4.

2. BASIC SAFETY REQUIREMENTS





WARNING

To prevent the risk of injury never walk or stay under lifted loads!

The working load limit must not be exceeded!

Only use lifting and attachment means free from defects!

Working under the influence of drugs, medications impairing the sense and/or alcohol is strictly forbidden!



- Operators, fitters and maintenance personnel must in particular observe the operating instructions as well as standards ASTM A 906/A 906 M (Standard Specification for Grade 80 and Grade 100 Alloy Steel Chain Slings for Overhead Lifting), ASTM A 952/A 952 M (Standard Specification for Forged Grade 80 and Grade 100 Steel Lifting Components and Welded Attachment Links), ISO 3056 (Non-calibrated round steel link lifting chain and chain slings; Use and maintenance), ISO 7593 (Chain slings assembled by methods other than welding; Grade T(8)) and ISO 4778 (Round steel short link chains for lifting purposes – Chains slings of welded construction – Grade 8).
- The specific safety and operating regulations and standards issued locally in the country where the items are used must be observed.

Safety Instructions and Requirements (Vers. B11082-D US 07.23)

SAFETY INSTRUCTIONS

- The directions given in these operating instructions and specified documentations relating to safety, assembly, operation, inspection, and maintenance must be made available to persons operating and using the sling chains.
- These operating instructions must be available in a place near the product during the time the equipment is used. Please contact the manufacturer if replacements are needed. Also see Chapter 13.
- During operation work, wear your personal protective equipment!
- **Improper assembly and use may cause personal injury and/or damage to property.**
- Assembly and removal as well as inspections and maintenance must exclusively be carried out by skilled, qualified, trained and authorized persons only.
- Structural changes are impermissible (e.g. welding, bending).
- **Operators must carry out a visual inspection and, if necessary, a functional test of the safety equipment before each use.**
- Never use worn-out, bent or damaged chain slings.
- Only lift loads that do not exceed the working load limit of the chain sling.
- Never expose chains to loads exceeding the specified working load limits.
- Position the load hook above the load's center of gravity.
- Do not use force when mounting/positioning the attachment components.
- The load must resist and tolerate the forces to be applied without suffering deformation.
- Do not tip-load a hook.
- Do not twist or knot the chains together.
- When using shortening elements without additional safety means (e.g. TWN 0827, TWN 1827, TWN 0851 or TWN 1851), special care must be taken and the correct position of the chain in the shortening element is to be verified for each individual lifting operation.
- Avoid sharp edges. Use edge protectors or reduce the working load limit by 20 %.
- The working load limit must be reduced in the following cases
 - if the load is not balanced symmetrically,
 - if the chain is used in choke hitch applications,
 - when higher temperatures prevail,
 - when high dynamic and cyclic loads arise (automated or multi-shift operation),
 - when lifting magnets are employed.
- In case of multi-leg chain slings never allow sling angles of less than 30° and in excess of 75°.
- Hooks shall have well-functioning safety latches.
- Attach unused chain legs to the suspension link.

- Suspension links must be allowed to move freely in the crane hook.
- Only lift loads that are freely movable and not attached or fastened.
- Do not bend loads to act on chain links and components.
- Safety elements must not be stressed or strained operationally.
- Use only shortening/grab hooks or claws for chain shortening purposes.
- Shortening hooks must not be attached directly to loads, e.g. metal sheets.
- For shortening claws, only the chain coming out of the bottom of the claw pocket must be loaded.
- Only chain legs and shortening elements of the same nominal size and grade may be connected.
- Shortening elements must be allowed to move freely in all tensile directions.
- Safeguard chain slings to prevent slipping when using the basket hitch application method.
- Do not start lifting before you have made sure the load has been correctly attached and balanced.
- **No one including you (operator) must be in the way of the moving load (hazard area).**
- During lifting your hands or other body parts must not come into contact with lifting means. Only remove lifting means manually (use your hands).
- Avoid impacts, e.g. due to abruptly lifting loads with chain in slack condition.
- Never move a suspended load over persons.
- Never cause suspended loads to swing.
- Always monitor a suspended load.
- Put the load down only in flat places/sites where it can be safely deposited.
- Do not allow a chain sling getting caught under the load.
- Assume for sufficient space for the personnel to move when choosing the route of transportation and storage location. Danger to life and risk of injury by crushing hazards!
- In the event of doubts or concerns about the proper and safe use, inspection, maintenance or similar things contact your safety officer or the manufacturer.

THIELE is not responsible for damage caused by non-observance of the instructions, rules, standards and notes indicated!

As regard grade 100, THIELE does not give its approval to the assembly of components sourced from different manufacturers!

As a rule, chain slings are not permitted for the transportation of persons.

Safety Instructions and Requirements (Vers. B11082-D US 07.23)

3. DESCRIPTION AND INTENDED USE

THIELE sling chains and attachment components form part of chain slings and are intended for a safe transportation of loads.

These operating instructions describe in particular how sling chains according to TWN 0805A grade 80, TWN 0072 and TWN 1805 grade 100 (TWN = THIELE Shop Standard) are to be safely used for lifting purposes.

THIELE chain slings of the following design configurations are available:

- assembled with clevis fastening system,
- assembled with connecting links,
- assembled with clevis fastening system and connecting links,
- as welded chain sling,
- as welded endless chain,
- as endless chain with mounted connector.

THIELE sling chains and chain slings meet EC-Machinery Directive 2006/42/EC requirements and feature a safety factor of at least 4 based on working load limit.

Sling chains and pertinent components are marked with nominal chain size and grade data, manufacturer's symbol and traceability code.

THIELE chain slings and attachment elements are designed to withstand 20 000 dynamic load changes under maximum load conditions. In the event of higher loads (e.g. multi-shift/automatic operation, magnetic spreaders), the working load limit must be reduced.

Chain slings shall be composed of sling chains and components of identical nominal chain size and grade. In case of deviating configuration the pertinent documentation (operating instructions etc.) must be suitably modified.

Sling chains according to TWN 0805A, TWN 0072 and TWN 1805 as well as the related attachment components and connecting links are intended for use as chain slings according to ASTM A 906/A 906 M for lifting of loads.



Chain slings must only be used

- if mass and center of gravity of the load are known or have been professionally estimated,
- within the limits of their permissible working load limit,
- for permissible attachment methods and sling angles,
- within the temperature limits prescribed,
- with suitable connecting links, attachment components or shortening elements,
- by trained and authorized persons.

Failure to do so may cause serious injury or property damage.



Chain slings must not be employed for binding, rigging, lashing or as hoist chains.

Shortening elements must not be connected directly to the load!

4. COMMISSIONING

Prior to using the components for the first time assure that

- the components comply with the order and have not been damaged,
- test certificate and operating instructions are at hand,
- markings correspond with what is specified in the documentation,
- inspection deadlines and the qualified persons for examinations are determined,
- visibility and functional testings are carried out and documented,
- documentation is safely kept in an orderly manner.

Dispose of the packing in an environmentally compatible way according to local rule.

Safety Instructions and Requirements (Vers. B11082-D US 07.23)

6. ASSEMBLY AND REMOVAL

6.1 Preparations

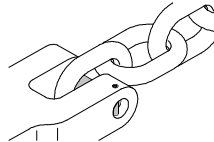
All components to be installed or used must be in perfect condition and the relevant working load limits of all parts must accommodate the respective load to be handled.

6.2 Chain assembly

When assembling or disassembling chain slings the relevant assembly and operating instructions issued for the components must be observed.

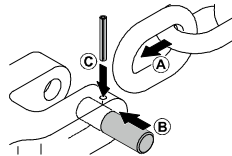
6.3 Clevis fastening system

The clevis fastening system only permits attachment of the nominal chain size that suits the attachment component.



6.3.1 ASSEMBLY

- If necessary, remove dowel pin and pin.
- (A) Place end of chain leg between the lateral clevis elements.
- (B) Push pin from the side fully into the clevis and through the last chain link of the leg.
- (C) Drive dowel pin fully in (must not project) to secure the pin. The slot must face away from the pin.



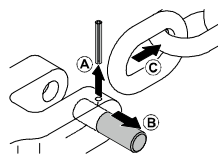
WARNING
Check whether the chain runs smoothly.

The dowel pins must only be installed once.

Only connect pins and attachment components of identical grades. Starting with $\varnothing \frac{1}{2}$ " the pins are marked on the front end.

6.3.2 DISASSEMBLY

- Slacken the respective chain leg.
- (A) Drive dowel pin out using hammer and drift punch ¹⁾.
- (B) Push pin out using a drift punch.
- (C) Remove the chain.



1) Suitable drift punches are available by article no. Z03303.

7. CONDITIONS OF USE

7.1 Normal use



WARNING

When 4-leg chain slings are used there is a risk that the load will act on two oppositely located chain legs only. In such a case, check the working load limit of the chain sling and use a chain sling with a higher working load limit. #

Shortening individual chain legs is indicative of a non-symmetrical load distribution. In this case, the working load limit must be reduced.

If choke hitch applications are involved the working load limit is to be additionally reduced by 20 %.

When using hooks without safety latch, e.g. due to operational necessities, special care is to be taken, and a separate risk analysis must be carried out before operation.



DANGER

When attaching components, observe the correct position of the connecting links.

Relevant forces must act in longitudinal direction.



If two chain legs are assembled into one connecting link half for alternate use of the legs, only one chain leg must be subjected to loads!

If not all chain legs in a multi-leg chain sling are used, the working load limit is to be reduced according to the following table:

Total number of legs	Number of legs to be put to use	Use factor relevant to WLL specified
2	1	1/2
3 or 4	2	2/3
3 or 4	1	1/3

Safety Instructions and Requirements (Vers. B11082-D US 07.23)

7.2 Influence of temperature



The respective temperature range limits must be considered for all components used. Using chain slings in high temperatures will cause the working load limit to be reduced as indicated below.

Grade TWN	Temperature range	Remaining WLL
Grade 80 TWN 0805	-40 °C ≤ t ≤ 205 °C -40 °F ≤ t ≤ 400 °F	100 %
	205 °C < t ≤ 300 °C 400 °F < t ≤ 572 °F	90 %
	300 °C < t ≤ 400 °C 572 °F < t ≤ 752 °F	75 %
Grade 100 TWN 0072	-40 °C ≤ t ≤ 205 °C -40 °F ≤ t ≤ 400 °F	100 %
Grade 100 TWN 1805	-30 °C ≤ t ≤ 205 °C -22 °F ≤ t ≤ 400 °F	100 %



If the chain slings have been exposed to temperatures exceeding the maximum values specified they must not be used furthermore.

7.3 Environmental influence



Chain slings must not be used in environments where acids, aggressive or corrosive chemicals or their fumes are present. Hot-dip galvanizing or a galvanic treatment is prohibited.

7.4 Special hazardous conditions



The degree of danger when used in offshore applications, the lifting of hazardous loads, such as for example liquid metal or similar, risk potentials must be assessed by a competent person in the form of a risk analysis. Any additional rules and directives must be followed in this case.

For applications in abrasive blasting environments short inspection intervals must be scheduled. Selecting a welded chain sling of the next bigger nominal size increases the permissible wear allowance.

7.5 Asymmetrical load balancing



In the case of multi-leg sling chains, if the individual legs have different sling angles, the greatest stress occurs in the single leg with the smallest sling angle. In the extreme case, a vertically hanging single leg will carry the entire load.

In case of an asymmetrical load, the lifting operation must be approved by an expert. Alternatively, the working load limit should be reduced to half of the marked working load limit.

8. GENERAL NOTES ON ATTACHMENT COMPONENTS

8.1 Connecting links



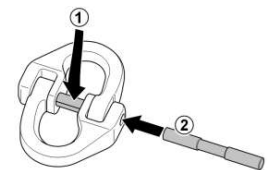
In mounted chain slings the chains are, for example, joined to other components by the use of connecting links. In this way, components can be mounted the nominal size of which deviates from that of the chain.

Sizes and grades of sling chains and connecting links must always coincide!

8.1.1 ASSEMBLY

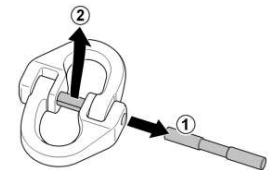
Install the connecting link halves in the components to be connected and join both halves.

1. Position split sleeve as shown.
2. Push pin up to the split sleeve, align pin bevels to suit split sleeve and drive the pin in using a hammer.
3. Check to make sure split sleeve safely embraces the pin centrally.



8.1.2 DISASSEMBLY

1. Use drift to drive pin out.
2. Remove the split sleeve.
3. Separate connecting link halves from the components they joined.



A set of drifts according to TWN 0945 is available by article no. Z03303.

The split sleeves must only be installed once.

The components to be connected must be able to move freely within the connecting link half they are placed in.

8.2 Shortening elements

A shortening element within a chain leg is intended only to shorten the effective length to optimize the balance of the whole system.

When using shortening elements, such as for example shortening hooks or claws, please read the respective separate operating and/or assembly instructions.

Safety Instructions and Requirements (Vers. B11082-D US 07.23)

9. IDENTIFICATION/ MARKING

An identification tag must be attached to the chain sling adjacent to the master link.

The identification tag must show

- name or trademark of manufacturer
- nominal chain size
- grade
- number of legs
- rated load and corresponding sling angle
- length/reach
- individual identification/serial number

10. INSPECTION, MAINTENANCE, DISPOSAL

10.1 General



Inspections and maintenance must be arranged by the owner!

Inspection intervals shall be determined by the owner!

Visual inspections must be regularly carried out and documented by competent and trained persons, at least once a year or more frequently if the chain slings are in heavy duty service. After three years at the latest they must additionally be examined for cracks. A load test is not a substitute for this examination.

The results of the inspections shall be kept in a file that has to be set up for each sling chain before first use.

The register shall show characteristic data of the chains and components as well as identity details.

Immediately stop using chain slings that show the following defects:

- missing or illegible identification/markings,
- deformation, elongation or fractures of chain links or components,
- cuts, notches, cracks, incipient cracks, pinching,
- links heated beyond permissible limit,
- severe corrosion,
- pitch elongation of individual chain links by more than 5 % each,
- reduction of the average diameter of more than 10 % as mean value of measurements taken perpendicularly towards each other,
- impaired or missing safety systems, for example if the hooks' safety latch is defect,
- widening of the hook opening by more than 10 % or if the safe seating of the hook safety latch is no longer ensured
- limited hinging capability of connecting links (e.g. halves get stuck),
- wear in excess of 10 %, e.g. in the receiving area of the connecting link halves or of the pin diameter,
- missing or damaged pin locks or removal of preventing guards



Cleaning (e.g. prior to inspections) must not take place by using flames or methods that might cause hydrogen embrittlement (e.g. pickling or immersion in acidic solutions).

The following chain gauges are available to be used during chain inspections:

Nominal size		Article no.
Grade 80		F48856
1/4"	Grade 100	F01690
5/16	Grade 100	F01691
3/8	Grade 100	F01692
1/2	Grade 100	F01693
5/8	Grade 100	F01694

10.2 Inspection service

THIELE offers inspection, maintenance and repair services by trained and competent personnel.

10.3 Maintenance and repair



Maintenance and repair work must only be performed by competent and trained persons.



Do not repair or replace individual chain links but replace complete chain legs only.

If the safety latch of hooks does not engage properly with the tip of the hook, probably not only the hook but also the corresponding chain leg has been overloaded. In all such cases, all items used in the respective leg must be replaced (chain, shortening element, ring shackle etc.).

Minor notches and cracks may be eliminated by careful grinding, observing the maximum cross section reduction requirement of max. 10 % and avoid making more severe cuts or scores.

Welded chain slings must exclusively be repaired by the manufacturer.

All maintenance and repair activities must be documented properly.

10.4 Disposal

NOTICE

All steel components and accessories taken out of service must be scrapped in accordance with local regulations and provisions.

11. SPARE PARTS - ARTICLE NUMBERS FOR SLING CHAINS AND OTHER COMPONENTS



Use only original spare parts.

Detailed information on spare parts for other THIELE-components can be found in the respective component instructions that are available for download on www.thiele.de, www.kwschain.com or upon request.

12. STORAGE

NOTICE

Chain slings must be stored properly sorted, suspended and in dry conditions at temperatures between 32 °F and 104 °F.

Do not store in a manner that causes mechanical damage.

13. THIELE OPERATING AND MOUNTING INSTRUCTIONS

NOTICE

All current and updated operating and mounting instructions are available in the download-center on our website www.kwschain.com and www.thiele.de.



14. PUBLISHING INFORMATION

Distributor:

KWS Inc.
P.O. Box 470487 | Tulsa, OK 74147 | USA

Toll Free: +1 (800) 872-9313
Phone: +1 (539) 367-2274
Fax: +1 (539) 367-2278
Email: sales@kwschain.com
Web: www.kwschain.com

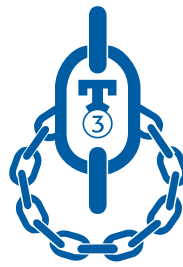
Manufacturer:

THIELE GmbH & Co. KG
Werkstraße 3 | 58640 Iserlohn | Germany

Phone: +49 2371 947-0
Fax: +49 2371 947-241
Email: info@thiele.de
Web: www.thiele.de



KWS
INC.



THIELE®

KWS Inc.

P.O. Box 470487
Tulsa, OK 74147
USA

Toll Free: +1 (800) 872-9313
Phone: +1 (539) 367-2274
Fax: +1 (539) 367-2278
Email: sales@kwschain.com
Website: www.kwschain.com

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