Use the following chart to determine when the hook must be replaced. Replacement of the hook is necessary if any of the above problems are found or the maximum dimensions on the charts that follow are reached.

### Chain Inspection

Inspect chain before each use. Between regular inspections visually check on a daily basis the following:

- Clean chain before inspection using a non-caustic/non-acid solvent
- Lubrication of the chain may be necessary if it binds up or is noisy
- Chain feeds smoothly into and from the hoist and does not emit cracking noise when hoisting a load
- Visually examine link by link for any nicks, gouges, weld splatter, corrosion, or distorted links pay close attention to chain’s contact points, which may show excessive wear.
- Test hoist with load and observe operation of chain over load sheaves.

<table>
<thead>
<tr>
<th>Size</th>
<th>Standard L (mm)</th>
<th>Max L (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.5 ton</td>
<td>28</td>
<td>30.5</td>
</tr>
<tr>
<td>1 ton</td>
<td>26</td>
<td>28.5</td>
</tr>
<tr>
<td>1.5 ton</td>
<td>32.5</td>
<td>35.5</td>
</tr>
<tr>
<td>2 ton</td>
<td>32</td>
<td>35</td>
</tr>
<tr>
<td>3 ton</td>
<td>37</td>
<td>40.5</td>
</tr>
<tr>
<td>5 ton</td>
<td>46</td>
<td>51</td>
</tr>
<tr>
<td>10 ton</td>
<td>50</td>
<td>58</td>
</tr>
<tr>
<td>20 ton</td>
<td>81</td>
<td>100</td>
</tr>
<tr>
<td>30 ton</td>
<td>81</td>
<td>100</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Size</th>
<th>Standard H (mm)</th>
<th>Min H (mm)</th>
<th>Standard T (mm)</th>
<th>Min T (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.5 ton</td>
<td>19.1</td>
<td>17.1</td>
<td>13</td>
<td>11.7</td>
</tr>
<tr>
<td>1 ton</td>
<td>25.7</td>
<td>23.1</td>
<td>16</td>
<td>14.4</td>
</tr>
<tr>
<td>1.5 ton</td>
<td>28.8</td>
<td>25.9</td>
<td>17</td>
<td>15.3</td>
</tr>
<tr>
<td>2 ton</td>
<td>34.3</td>
<td>30.9</td>
<td>21</td>
<td>18.9</td>
</tr>
<tr>
<td>3 ton</td>
<td>43.9</td>
<td>39.5</td>
<td>25</td>
<td>22.5</td>
</tr>
<tr>
<td>5 ton</td>
<td>52.5</td>
<td>47</td>
<td>32</td>
<td>28.8</td>
</tr>
<tr>
<td>10 ton</td>
<td>60.5</td>
<td>54.5</td>
<td>40</td>
<td>36</td>
</tr>
<tr>
<td>20 ton</td>
<td>88.5</td>
<td>79.5</td>
<td>60</td>
<td>54</td>
</tr>
<tr>
<td>30 ton</td>
<td>88.5</td>
<td>79.5</td>
<td>60</td>
<td>54</td>
</tr>
</tbody>
</table>
Use the following chart to determine when the chain must be replaced. Replacement of the entire chain is necessary if any of the above problems are found or the maximum dimensions on the charts that follow are reached.

**Load Chain - One link length**

<table>
<thead>
<tr>
<th>Dia (mm)</th>
<th>Standard L (mm)</th>
<th>Max L (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4</td>
<td>12</td>
<td>12.6</td>
</tr>
<tr>
<td>5</td>
<td>15</td>
<td>15.8</td>
</tr>
<tr>
<td>6</td>
<td>18</td>
<td>18.9</td>
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<tr>
<td>8</td>
<td>24</td>
<td>25.2</td>
</tr>
<tr>
<td>10</td>
<td>30</td>
<td>31.5</td>
</tr>
</tbody>
</table>

**Load Chain - Diameter**

<table>
<thead>
<tr>
<th>Dia (mm)</th>
<th>Standard D (mm)</th>
<th>Min D (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4</td>
<td>4</td>
<td>3.6</td>
</tr>
<tr>
<td>5</td>
<td>5</td>
<td>4.5</td>
</tr>
<tr>
<td>6</td>
<td>6</td>
<td>5.4</td>
</tr>
<tr>
<td>8</td>
<td>8</td>
<td>7.2</td>
</tr>
<tr>
<td>10</td>
<td>10</td>
<td>9</td>
</tr>
</tbody>
</table>

**Load Chain - Five link length**

<table>
<thead>
<tr>
<th>Dia (mm)</th>
<th>Standard L (mm)</th>
<th>Max L (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4</td>
<td>60</td>
<td>61.8</td>
</tr>
<tr>
<td>5</td>
<td>75</td>
<td>77.5</td>
</tr>
<tr>
<td>6</td>
<td>90</td>
<td>92.7</td>
</tr>
<tr>
<td>8</td>
<td>120</td>
<td>123.6</td>
</tr>
<tr>
<td>10</td>
<td>150</td>
<td>154.5</td>
</tr>
</tbody>
</table>

**Hand Chain - One link length**

<table>
<thead>
<tr>
<th>Dia (mm)</th>
<th>Standard L (mm)</th>
<th>Max L (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>25</td>
<td>26.8</td>
</tr>
</tbody>
</table>