



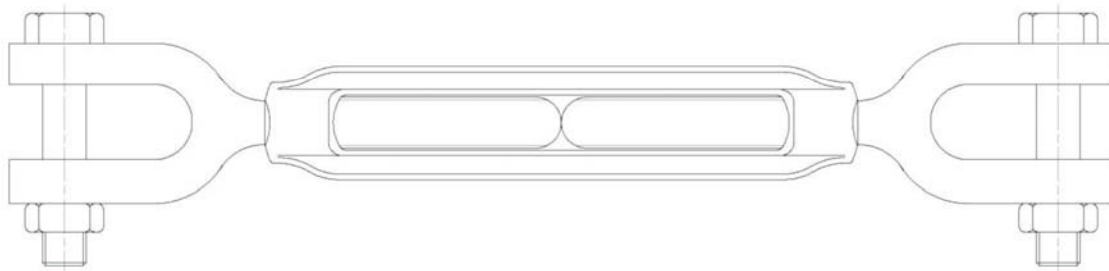
R/SP/8009/06
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PRODUCT SPECIFICATIONS

OPERATING AND MAINTENANCE INSTRUCTIONS

Technical Specifications
Operating Conditions and Limits
Operator's Instructions
Residual Risks

How and how often periodical fitness inspections should be conducted



JAW AND JAW TURNBUCKLES **ITEM 8009**

The original language of this technical specification is Italian

Manufacturing site **ROBUR wire rope accessories**
 Zona Industriale – C.da S. Nicola
 I-67039 SULMONA (L'AQUILA)
 Tel. +39.(0)864.2504.1 – Fax +39.(0)864.253132
www.roburitaly.com – info@roburitaly.com

1) TECHNICAL SPECIFICATIONS

Material / Reference Standard: BODY steel S235JR - UNI EN 10025-2
JAW steel S235JR - UNI EN 10025-2
SCREW steel strength class 4.6 - EN ISO 898/1
NUT steel strength class 4 - UNI EN 20898-2

Heat Treatment: /

Surface Treatment: Galvanized A2E EN ISO 4042

The test is performed on the basis of in-house specifications and rules in accordance with UNI EN ISO 9001.

This item complies with Machinery Directive 2006/42/EC.

DIMENSIONAL SPECIFICATIONS:

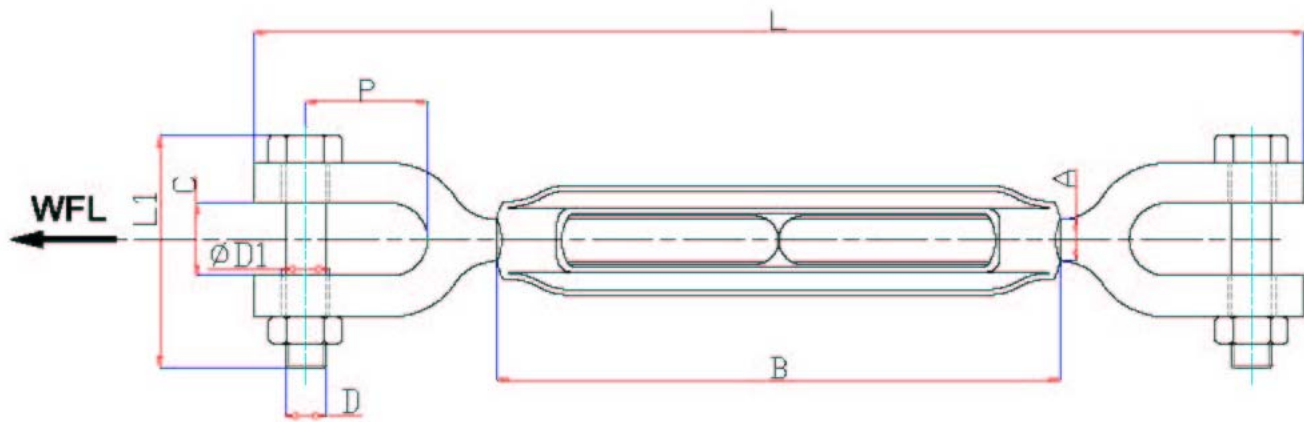



TABLE "A"

A	A"	B	C	D	D1	P	L min	L max	L1	 g	WFL kg	ROPE min Ø	ITEM NUMBER
M8	5/16	105	10	M6	6.5	25	192	274	34	175	300	3.5	080090008
M10	3/8	125	12	M8	8.5	30	234	331	40.5	310	470	4.0	080090010
M12	1/2	140	16	M10	10.5	38	274	380	52	545	690	4.0	080090012
M14	9/16	170	20	M12	12.5	44	342	472	63	970	940	6.0	080090014
M16	5/8	190	20	M12	12.5	44	372	517	63	1140	1290	6.0	080090016
M18	11/16	205	24	M16	16.5	50	406	560	75	1800	1660	7.0	080090018
M20	3/4	220	24	M16	16.5	50	406	570	75	2070	2130	7.0	080090020
M22	7/8	240	28	M20	20.5	56	466	645	88	3140	2630	10.0	080090022
M24	1"	260	28	M20	20.5	56	486	678	88	3440	3060	10.0	080090024
M27	1"1/8	270	32	M22	22.5	62	510	704	99	5550	4000	11.0	080090027
M30	1"3/16	280	36	M24	25.5	70	566	762	110	7310	4860	12.0	080090030

All measurements are expressed in mm.

WFL = WORKING FORCE LIMIT

SAFETY COEFFICIENT: 4

Definitions:

- **WFL (working force limit):** the maximum force the item can support (along the main axis, if not otherwise specified) under operating conditions.
- **Safety coefficient:** guaranteed minimum breaking force to working force limit ratio.
- **Inspection:** visual testing of the state of the turnbuckle, to check for clear damage or wear which may affect its use.
- **Accurate examination:** visual inspection performed by a trained person, supported, if need be, by any other instruments, including non-destructive testing, to check for damage or wear which may affect the use of the turnbuckle.
- **Trained person:** a designated, suitably trained person who has proper know-how and practical expertise and has been given the instructions needed to perform any required tests and examinations.

CAUTION: The safety coefficient is only provided by way of example, in relation to product safety. The working force limits (WFL) shown in the table should never be exceeded.

2) TESTING SPECIFICATIONS

The individual parts of the item are subjected to several stringent spot checks for serviceability, performance and compliance with specifications.

The number of samples and the related sampling plans are chosen according to the characteristic to test under UNI ISO 2859/1, and the results are filed in the quality department of the factory in Sulmona.

2.A Dimensional test

Making sure that the dimensions of the item meet such tolerances as established in in-house working drawings.

2.B Visual test

Testing for defects resulting from forming, mechanical working, surface coating and correspondence between the marking and in-house drawings.

2.C Chemical analysis

Making sure that the chemical composition of the material complies with the limits established under the relevant standards.

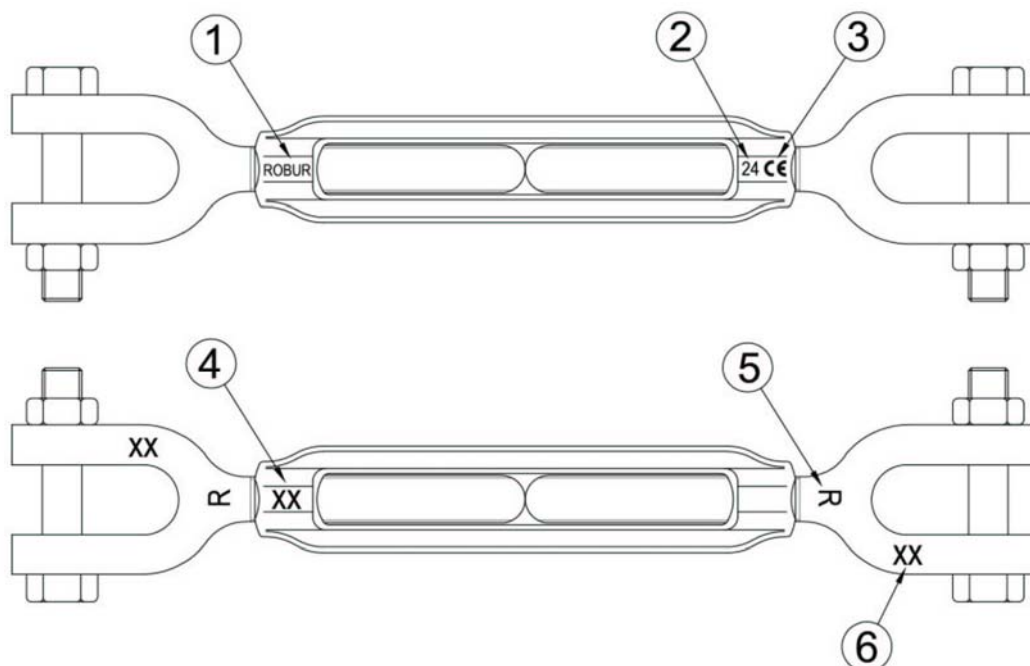
2.D Tensile stress tests

Making sure that the accessory subjected to tensile stress will break, after the applied force has at least exceeded the working load as multiplied by the safety coefficient. The test is performed in accordance with UNI 10002/1.

3) HOW TO READ MARKINGS:

The accessory carries indelible marks and codes which identify the product and define the specifications and applications.

- 1) Manufacturer's mark (R-ROBUR) -body
- 2) Size (e.g. M24)
- 3) CE mark
- 4) Traceability code -body
- 5) Manufacturer's mark (R) -jaw
- 6) Traceability code -jaw



4) GENERAL WARNINGS

The manual must be kept by the person in charge in a suitable place and readily available for consultation, in optimal conditions. Should it be lost or damaged, the manual can easily be retrieved on the constructor's web site: www.roburity.com
the constructor retains all material and intellectual rights on the manual, and restricts its modification, albeit partial, for any commercial use.

As regards the information provided in these operating instructions, BETA UTENSILI S.P.A. will accept no responsibility in the event of:

- any use of the accessories other than the uses under national safety and accident prevention laws;
- mistaken choice or arrangement of the apparatus they are going to be connected to;
- failure to comply with, or properly follow, the operating instructions;
- changes to the accessories;
- misuse or failure to carry out routine maintenance jobs;
- use with noncompliant accessories.

!CAUTION: The marking data should not be removed by grinding or abrasion (whether accidental or not – any turnbuckles that do not carry any identification references should be made unusable and scrapped).

No characters other than the manufacturer's may be affixed.

5) SELECTION CRITERIA

The following parameters should be carefully considered in choosing the turnbuckle:

5.A WORKING FORCE LIMIT

The tensile stress exerted by the turnbuckle **should be lower than or equal to** the working force limit (WFL) recommended for the item being considered, and shown in Table "A".

5.B CONNECTING PART

Make sure that the connecting part suits the load capacity of the turnbuckle, has a suitable diameter – as per Table "A", item "ROPE min. Ø" - and an adequate mechanical resistance to tensile forces.

5.C OPERATING TEMPERATURES

The maximum operating temperature is +80 °C.

For applications under 0 °C please use our high strength turnbuckles, like items 8109 or inox items 8209, 8210 etc.

5.D LIFE AND FREQUENCY OF USE

The accessory is perfectly serviceable as long as its geometric and physical characteristics remain unchanged.

Hence the turnbuckle should be replaced in case of reduced section, deformation, corrosion or connecting instability.

6) NONPERMISSIBLE CONDITIONS

The turnbuckles should not be operated under the following circumstances:

- when the applied force exceeds the permissible "WFL";
- when dynamic stresses or swinging loads may result;
- when the turnbuckles are operated under any temperatures other than the permissible temperatures;
- when the directrix of forces does not develop along the main axis crossing the two terminals.

7) PRELIMINARY TESTS

Before the accessories are operated and/or assembled, they should be tested by a suitably trained person.

- Check the state of the turnbuckle; in particular make sure that it is free from cuts, bends, indentations, abrasions, cracks, irregular threads, corrosions, sharp burrs, wear or defects resulting from improper storage.
- Measure and record the dimensions according to **Table "A"**.
- Check the state of all the parts of the marking, so that the accessory can be accurately identified according to the working force.
- Make sure that the threads fit.

8) INSTALLATION, ASSEMBLY INSTRUCTIONS

During the installation of the accessory please use adequate Personal Protective Equipment: gloves, safety shoes, helmet, etc.

Unscrew the jaws, so that the maximum available opening can be obtained, and connect them to the parts to pull.

Connect one rope or one part for each terminal.

After the connection has been completed, move the bolt locking nut to the jaw wall; avoid overtightening, to prevent flexure towards the inner part of the jaw.

Exert tensile stress through the main body, making sure that, after the operating condition has been reached, the terminals have been inserted into the body at least throughout the length of its thread.

While exerting tensile stress, make sure that the turnbuckle can freely move and position itself; hence no forcing or interference should occur, to prevent any lateral force components from being produced.

Tensile stress should be checked after a short period, to make up for any system adjustments.

Particular attention is required while tensioning, to prevent the working force limit (WFL, see Table "A") from being exceeded, which would result in permanent deformation, especially if any levers or mechanical means are used.

If the turnbuckle is subjected to the danger of loosening, for example because of the presence of vibrations, it's recommended to use a locking nut, to be screwed on the terminals before their mounting on the turnbuckle body.

NOTE: for each turnbuckle it's necessary to mount one nut with right-hand thread and one with left-hand thread.

9) USING ACCESSORY – GRIP AND HANDLING

The turnbuckle is designed to be used in static situations; periodically check tensile stress, the state of preservation of the parts and their connection, according to the Table "Maintenance jobs and inspections".

10) NONPERMISSIBLE USE

Using the accessory for any purposes other than the purposes it has been designed for, using it under extremely dangerous conditions and performing poor maintenance may pose **a severe hazard to the safety of the people being exposed** and cause severe damage to the working environment, while affecting the actual serviceability and safety of the product. The precautions mentioned below, which, obviously enough, cannot cover the whole spectrum of potential "**misuses**" of the accessory, should be "reasonably" deemed to be the most common steps to take. Therefore:

- DO NOT connect the accessory to any apparatus which does not match its specifications in terms of size, temperature, hook-up point and shape;
- DO NOT use the accessory for direct lifting purposes;
- DO NOT stretch any apparatus that may change its static configuration, centre of gravity or chemical and physical state;
- DO NOT use the accessory to lift or carry people or animals.
- DO NOT use the accessory to pull restrained loads;
- DO NOT work in areas where any explosion/spark-proof parts are expected to be used or in the presence of big magnetic fields;
- DO NOT weld any metal parts to the accessory; do not use any filling welds; do not use the accessory as mass for any welder.

11) FITNESS FOR USE

The accessory was subjected to spot check in order to test serviceability and performance at the manufacturer's. The certificate supplied with it states that the tests were passed. However, before starting working, the user should test the installed accessory for serviceability and performance, to prove the entire system is fit for use.

12) INSPECTION AND MAINTENANCE

Inspections and maintenance jobs should be carried out by trained personnel, who should perform accurate tests during operation.

Below is a list of tests to perform at such intervals as stated in the table “**Maintenance jobs and inspections**”.

- **VISUAL TEST:** making sure that the accessory is free from surface defects, including cracks, indentations, cuts, fissures and abrasions.
- **THREAD TEST:** making sure that the thread is free from wear, deformation and dents, that its fit is accurate and stable, and that there is not too much clearance.
- **DEFORMATION TEST:** making sure that the accessory has not got deformed, using a gauge to measure such critical dimensions as shown in **Table “A”**. **NO DEFORMATIONS** will be tolerated compared to the measurements made when the accessory was **first put into operation**.
- **WEAR TEST:** making sure that the points of contact are not worn, using a gauge to measure such critical dimensions as shown in **Table “A”**.
- **PRESERVATION TEST:** making sure that the accessory is free from oxidation and corrosion, especially in case of outdoor use; using suitable methods (e.g. liquid penetrants) to make sure that it is free from cracks.

The results of the above-mentioned tests should be stored.

Maintenance jobs and inspections			
Type of inspection			
	Whenever used	Month	Year
General visual inspection	X		
Thread state	X		
Deformation	X		
Wear		X	
State of preservation			X

If the turnbuckle has been used for heavy-duty jobs, both wear and the state of preservation should be tested for more frequently.

13) SCRAPPING ACCESSORY

The accessory should be scrapped by cutting, so that it can no longer be used, whether at the end of its expected lifetime or if:

- it is permanently worn compared to the original size;
- any cracks or distortions are shown, or the sections have become small compared to the original size;
- the state of the thread is such that the parts do not fit perfectly, any threads are worn, deformed, irregular etc.



SIRTEF

SIRTEF s.r.l.

Zona Industriale - Via dei Lavoratori, 1 (ang. Via delle Industrie)
Tel. +39.02.90059273 (6 linee ric. aut.) - Telefax +39.02.90059258
20088 Calvignasco (MI)

SEDE DI ROMA:

Via Libero Leonardi 4
Tel. +39.06.266098 - Fax +39.06.2677606 - Cell. +39.334.8109251
00173 Roma

FILIALE DI UDINE:

Via G.D'Annunzio, 9 - Loc. Crosada
Tel. +39.0432.685022 - Fax +39.0432.685033
33050 Santa Maria la Longa (UD)