SWIVEL HOIST RING, METRIC THREAD WARNINGS AND APPLICATION INSTRUCTIONS

WARNING

• Loads may slip or fall if proper Hoist Ring assembly and lifting procedures are not used.• A falling load may cause serious injury or death.

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•Install hoist ring bolt to torque requirements listed in tables 1 for the 8-204 respectively.

•Read, understand and follow all instructions and chart information.

•Do not use with damaged slings, chain, or webbing. For inspection criteria see ASME B30.9.

•Use only genuine YOKE parts as replacements.

Hoist Ring Application Assembly Safety

- After determining the loads on each hoist ring, select the proper size hoist ring using the Working Load Limit ratings in Table 1 for UNC threads.
- Drill and tap the work piece to the correct size to a minimum depth of one-half the threaded shank diameter plus the threaded shank length. See rated load limit and bolt torque requirements imprinted on top of the swivel trunnion (See Table 1).
- Install hoist ring to recommended torque with a torque wrench making sure the bushing flange meets the load (work piece) surface.
- Never use spacers between bushing flange and mounting surface.
- Always select proper load rated lifting device for use with Swivel Hoist Ring.
- Attach lifting device ensuring free fit to hoist ring bail (lifting ring) (Fig. 1).
- Apply partial load and check proper rotation and alignment. There should be no interference between load (work piece) and hoist ring bail (Fig. 2).

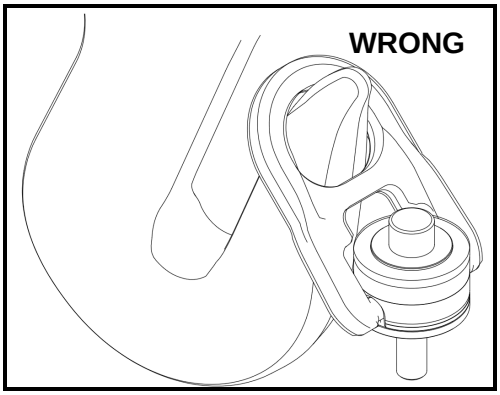


Figure 1

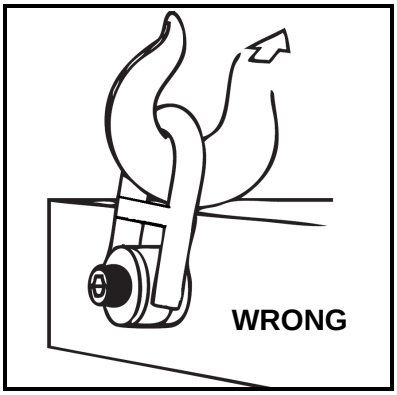


Figure 2

- Special Note: When a Hoist Ring is installed with a retention nut, the nut must have a full thread engagement and must meet one of the following standards to develop the Working Load Limit (WLL).

  1. ASTM A-563 A. Grade D Hex Thick B. Grade DH Standard Hex

  2. SAE Grade 8 — Standard Hex

Hoist Ring Inspection / Maintenance

- Always inspect hoist ring before use.
- Regularly inspect hoist ring parts (Fig.3).

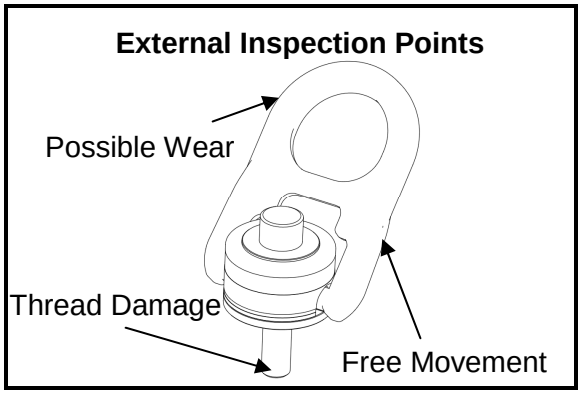


Figure 3

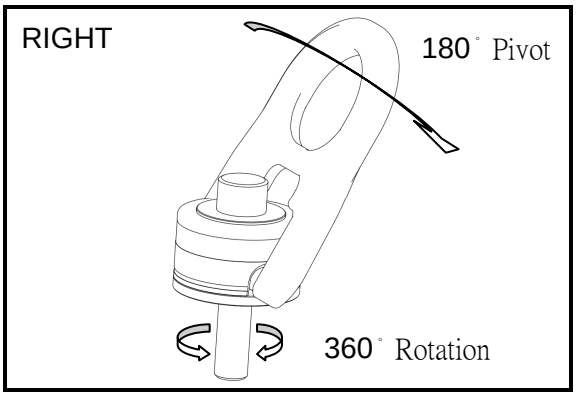
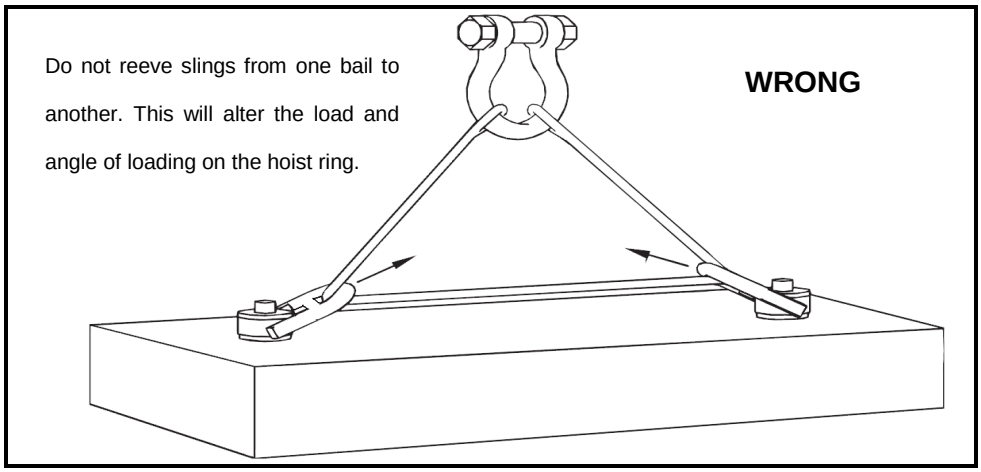


Figure 4

- Never use hoist ring that shows signs of corrosion, wear or damage.
- Never use hoist ring if bail is bent or elongated.
- Always be sure threads on shank and receiving hole are clean, not damaged, and fit properly.
- Always check with torque wrench before using an already installed hoist ring.
- Always make sure there are no spacers (washers) used between bushing flange and the mounting surface. Remove any spacers (washers) and retorque before use.
- Always ensure free movement of bail. The bail should pivot 180 degrees and swivel 360 degrees (Fig. 4).
- Always be sure total work piece surface is in contact with hoist ring bushing mating surface. Drilled and tapped hole must be 90 degrees to load (work piece) surface.

Operating Safety

- Never exceed the capacity of the swivel hoist ring, see Tables 1 for UNC threads.
- When using lifting slings of two or more legs, make sure the forces in the legs are calculated using the angle from the horizontal sling angle to the leg and select the proper size swivel hoist ring to allow for the angular forces.



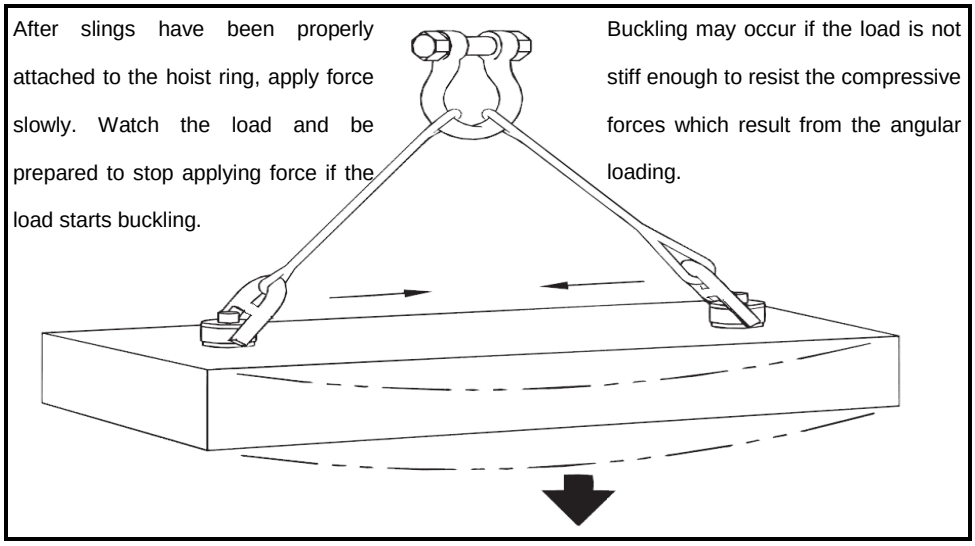


Table 1

Table 1

	Item No.	Working Load Limit	Torque in ft. Lbs	Bolt Size	Dimensions (inch)						N.W.
		Lbs*			E	A	B	D	F	G	Lbs
	8-204-004	800	7	5/16 - 18 x 2	0.68	1.57	1.61	0.35	4.02	2.56	0.9
	8-204-005	1000	12	3/8 - 16 x 2	0.68	1.57	1.61	0.35	4.02	2.56	0.9
	8-204-010	2500	28	1/2 - 13 x 2.5	0.69	2.56	2.32	0.59	6.26	4.13	3.7
§	**8-204-010L**	2500	28	1/2 - 13 x 3.0	1.19	2.56	2.32	0.59	6.26	4.13	3.7
	8-204-019	4000	60	5/8 - 11 x 2.5	0.69	2.56	2.32	0.59	6.26	4.13	4.0
§	**8-204-019L**	4000	60	5/8 - 11 x 3.25	1.44	2.56	2.32	0.59	6.26	4.13	4.0
	8-204-021	5000	100	3/4 - 10 x 2.75	0.94	2.56	2.87	0.59	6.26	4.13	4.0
§	**8-204-021L**	5000	100	3/4 - 10 x 3.25	1.44	2.56	2.87	0.59	6.26	4.13	4.2
	8-204-030	7000	100	3/4 - 10 x 3.0	0.83	3.35	2.87	0.59	6.26	5.28	9.0
§	**8-204-030L**	7000	100	3/4 - 10 x 3.75	1.58	3.35	2.87	0.87	8.03	5.28	9.5
	8-204-042	8000	160	7/8 - 9x 3.5	1.33	3.35	2.87	0.87	8.03	5.28	9.3
§	**8-204-042L**	8000	160	7/8 - 9x 4.25	2.08	3.35	2.87	0.87	8.03	5.28	9.7
	8-204-045	10000	230	1 - 8x 3.5	1.33	3.35	2.87	0.87	8.03	5.28	9.5
§	**8-204-045L**	10000	230	1 - 8x 4.5	2.33	3.35	2.87	0.87	8.03	5.28	10.1
**	**8-204-070**	15000	470	1 1/4 - 7x 4.5	2.22	3.95	3.15	1.00	8.58	6.30	14.8
**	**8-204-125**	24000	800	1 1/2 - 6x 6.5	3.15	4.72	4.29	1.38	12.09	8.66	36.4
**	**8-204-135**	30000	1100	2 - 4.5 x 6.5	3.15	4.72	4.29	1.38	12.09	8.66	38.6

* Minimum Ultimate Load is 5 times the Working Load Limit. * Proof Load is 2.5 times the Working Load Limit.
§Long Bolts are designed for soft metal work piece.
The depths of thread need to be in a minimum 1 times thread for steel,1.25 times thread for cast iron and, 2 times thread for aluminum work piece.

** Will be supplied with a hex head bolt.

Additional Information

- For information concerning parts, special application, or situations requiring other features, contact:

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