



### **P51 Swift-Lifting Eye Hardware**

#### 1.0 Scope

- 1.1 This document defines the procedure for plant inspection and maintenance for lifting hardware



#### 2.0 Purpose

- 2.1 To receive and inspect all new and returning product to ensure that all units entering the inventory meet design specifications and are functional.
- 2.2 To check for worn or damaged parts
- 2.3 To establish preventive maintenance control and maintain historical records for maintenance activity.

#### 3.0 Procedure

- 3.1 Inspect all lifting eyes monthly and after each return from field.
- 3.2 Check for evidence of heat applications. If evidence of heat application is present, scrap unit.
- 3.3 Check for bent or twisted bails. Do not attempt to straighten. Discard units with bent or twisted bails.
- 3.4 At least once every three months, the upper limit of Dimension “H” and the lower limit of Dimensions “M” and “B” should be checked. If any of these dimensions are exceeded, the unit must be removed from service and destroyed. See below chart.



**DAYTON  
SUPERIOR**

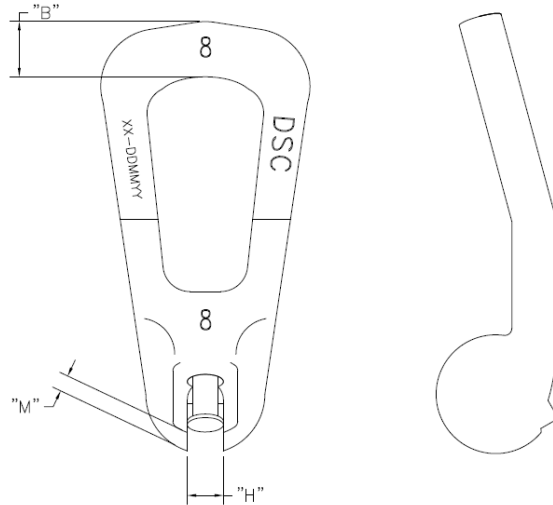
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Rated Load Tons	"H" Maximum Width	"M" Minimum Thickness	"B" Minimum Thickness
2	0.759	0.236	1.260
4	1.034	0.315	1.375
8	1.310	0.472	1.594

3.5 Check for damaged, worn or missing safety pin. Replace as necessary.

3.6 Other than safety pin, no other repairs on the SL Lifting Eye are permitted. Pin Replacement procedure is as follows;

- 3.6.1 Remove existing pin by grinding the peened end and using a punch to drive the pin out of the washer.
- 3.6.2 Insert the new pin from inside of the lifter through the hole in the casting.
- 3.6.3 Place a new washer over the machined shoulder on the pin.
- 3.6.4 Place the lifter into a fixture with the "T" end of the pin bearing on the block.
- 3.6.5 Using a hammer and punch, peen the end of the pin over the washer until it is securely held in place.



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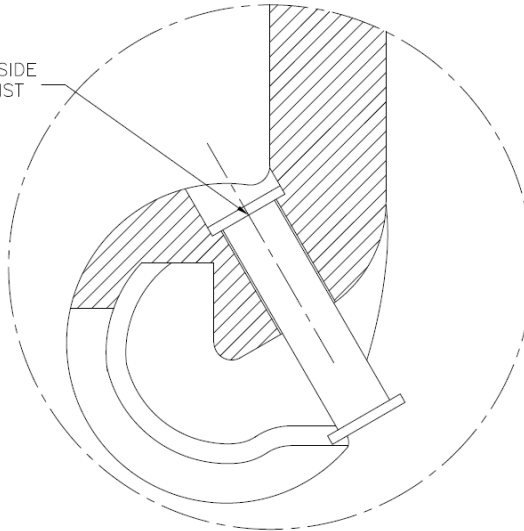
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WASHER MUST BE  
SECURE ON THIS SIDE  
AND SEATED AGAINST  
CASTING



3.7 The proper method used in destroying the lifting eye is to cut through the bail with a cutting torch.

**4.0 Proof Load Testing and Serialization:**

4.1 All units must be proof loaded and serialized.

4.2 If the unit has been previously serialized, review records upon return from customer to determine the date of the last load test and post load test inspection. If the test was performed more than 2 years prior, return the unit to an authorized facility for load test and inspection.

4.3 Document proof load test and inspection into log/database/etc.

4.4 Return unit to service.

**5.0 Documentation**

5.1 Locate Serial Number (XX-XXXX-XXX) on part. Log with repairs and/or comments on the Lifting Hardware Repair Log.

**6.0 References**

6.1 Dayton Superior Precast Handbook

6.2 See DSC Website for latest Revisions.