

8.5. Marking and labelling

8.5.1. Each length of chain shall be etched or engraved on the outside face of the last outer link plate with the manufacturers name and the year of manufacture.

8.5.2. Each chain length shall then be given an identity tag bearing the order number, chain part number and measured length, which shall be securely, wired to the last link plate.

8.5.3. For all chain types other than ladder chains, each tag shall additionally carry a unique identity, e.g. 1L, 1R, 2L, 2R, 3L, 3R, to ensure that the chains can be re-matched when delivered to site.

8.6. Match pairing

8.6.1. The chain shall be supplied in precision-matched pairs. For each pair of the Contractor's standard length units, the lengths of individual left and right hand chains shall be matched within 0.5mm. The overall chain length when installed shall be matched left-to-right to within 1mm.

9. Testing and inspection

9.1. Step chain tensile test

9.1.1. The Contractor shall carry out a destructive test of a sample chain at an approved test house. Where the manufacturer has supplied a chain type previously and can provide the destructive test certificate, the Employer will generally waive the requirement for a destructive test.

9.1.2. Where the Contractor is manufacturing a chain design for the first time, a destructive test shall be carried out.

9.1.3. Where a chain has been in production for a prolonged period, The Employer reserves the right to request a repeat destructive test to ensure consistency with the original design.

9.1.4. These tests apply to all chain types. Where the chain is of a "ladder" configuration, the Contractor shall test a single strand.

9.1.5. Where the chain incorporates "cranked" male/female links in the design, the test shall be carried out on a sample of chain containing such links.

9.1.6. For the purposes of this test, the hollow outer link bushes shall be plugged with close-fitting solid bars to represent the axles, the material being the same as that specified for the axles. A tensile load shall then be applied to one end of the chain, the other end being firmly anchored to the test rig. A tensile breaking load in excess of that stipulated on the drawing shall be achieved.

9.1.7 Following this test, a certificate shall be presented to the Employer, who will place this on record as a type test for the given chain type and given manufacturer.

The destructive test certificate shall record:

- a) Date of test;
- b) Name of test house;
- c) Manufacturer of chain;
- d) Chain type;
- e) Drawing number(s) and revision status;
- f) LU purchase order number;
- g) Materials/equipment, traceable to the LU purchase order;
- h) Chain length;
- i) Tensile breaking load;
- j) Yield point;

