BVM Corporation Maintenance Manual
Electro Weld Link Set

For Model _____ S/N_____-___ & -___

Confidentiality Statement
This document contains proprietary and confidential information, which is the property of BVM Corporation. No use or disclosure is to be made without the express written consent of BVM Corporation.

Note: Original Instructions are published in English; in the event the end-user may wish to obtain a translation of these in the official language of the country in which the machinery is to be used please contact your local BVM representative or BVM directly. Please note that this service may not be free of charge. Original Instruction can be downloaded from www.bvmcorp.com

CE Marking (if applicable):
The link complies with the Machinery Directive 2006/42/EC (lifting accessories).

CE

Operating Instructions:
Whenever a link set is in use the following precautions must be observed.

- The links are designed to hang elevators from Top Drive Systems, Hooks, Beckets, and Link Adapters.
- Always ensure that the links are in good condition and properly rated for the application in use. The operator of the equipment shall be responsible for determination of the Safe Working Load (SWL) for any hoisting operation. The SWL is equal to the design load minus the dynamic load.
- Check to verify that the links are a matched set of equal rating.
- Check to see that the eyes are properly seated with the mating components and secondary retention is used when applicable.
- When applicable, install links with the offset end pointing inward at the attaching point.
- Always use caution and wear all applicable safety gear whenever working with links.

Daily Maintenance:

1. Clean with rag, wash if necessary.
2. Visually check for cracks. If cracks are found, DO NOT USE.
3. Check for wear in the upper eye, lower eye and shanks. Using the attached chart replace if wear is present.

Safety Warning: Ensure that all related secondary hardware (not supplied with the electro weld link set) (bolts, nuts, wire, cotter pins) are in good condition. Replace as needed.

Note: Elevator links are matched sets of two pieces measured to within 1/16" of length (inside lower eye to inside upper eye). They are serial numbered per set with an identification number followed by a -1A and -1B. Please insure that after "Yearly Inspection", all links are matched in sets of two pieces with measurement of each piece being within 1/8" of the other.

Yearly Maintenance:

1. Remove all paint from elevator links.
2. Magnetic Particle inspect each link for cracks per ASTM E 709. If cracks are found, DO NOT USE. Consult factory or replace.
3. Inspect the upper eye, lower eye, and shanks for wear and markings. Replace if wear is present.

Note: If wear is present upon inspection of elevator link (in upper eye, lower eye, Or shank, DO NOT WELD TO REPAIR. Special alloy metal is used for "Arctic Service" and "Standard Service" elevator links. Welding on links is not allowed for any reason.

4. Matched sets are to be within 1/8"
5. Paint Links.

Inspection and Wear Data:

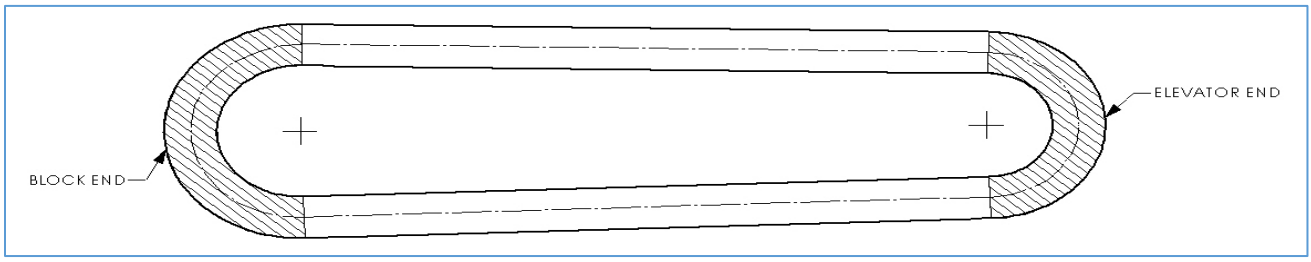


Figure 1: Critical areas shaded

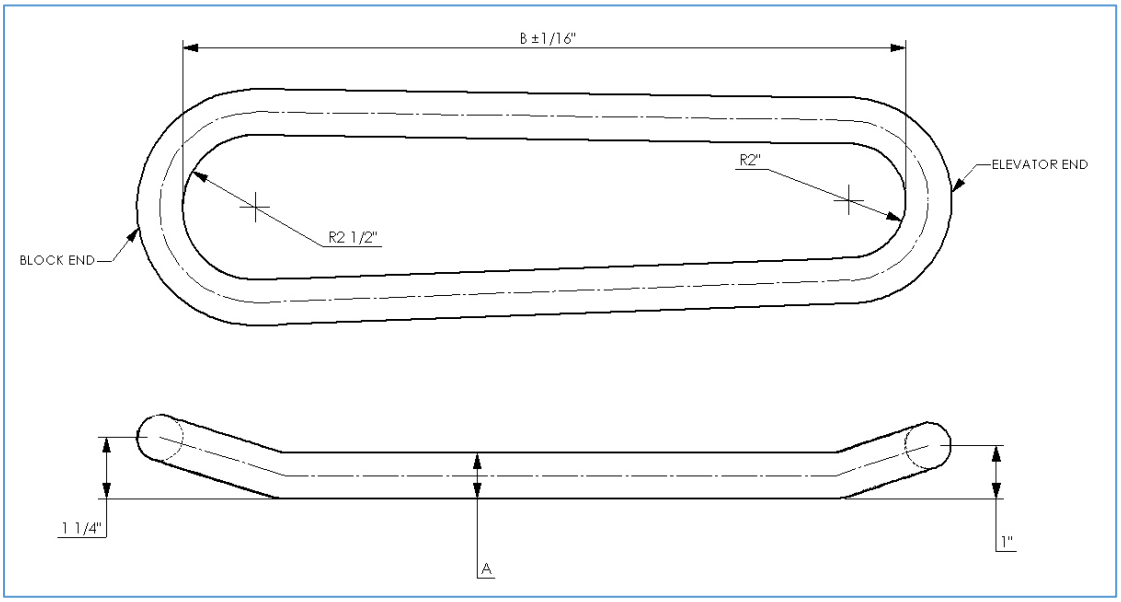
Nominal Size (in)	Min Worn Diameter (in)
0.875	0.750
1.250	1.125
1.500	1.313
1.750	1.500
2.000	1.750

NOTE: The capacity of a set is that of the weakest link. Diameter is for 100% rated load

NOTE: No additional components are included nor are any spare parts recommended to support this

product, therefore no assembly drawings exist.

Dimensions by Part Number:



P/N	A	B
87518	Ø7/8	18
87524	Ø 7/8	24
87540	Ø 7/8	40
87542	Ø 7/8	42

P/N	A	B
12518	Ø1 ¼	18
12526	Ø1 ¼	26
12530	Ø1 ¼	30
12536	Ø1 ¼	36
12540	Ø1 ¼	40
12548	Ø1 ¼	48
12560	Ø1 ¼	60
12572	Ø1 ¼	72

P/N	A	B
15024	Ø1 ½	24
15030	Ø1 ½	30
15036	Ø1 ½	36
15042	Ø1 ½	42
15048	Ø1 ½	48
15060	Ø1 ½	60
15072	Ø1 ½	72

P/N	A	B
18030	Ø 1 ¾	30
18036	Ø 1 ¾	36
18039	Ø 1 ¾	39
18042	Ø 1 ¾	42
18048	Ø 1 ¾	48
18060	Ø 1 ¾	60
18072	Ø 1 ¾	72
18084	Ø 1 ¾	84
18096	Ø 1 ¾	96

P/N	A	B
20030	Ø2	30
20036	Ø2	36
20042	Ø2	42
20048	Ø2	48
20060	Ø2	60
20072	Ø2	72
20084	Ø2	84
20096	Ø2	96