



DETAILS OF MEASUREMENTS

ITEM NO.	DIA (MM) AS PER IS-2266	LENGTH (Meter) "L"	LOOP SIZE (MM) "L-1"	SWL (TONE)	PROOF LOAD TESTING (2 X SWL)
#1	26mm	13.5	min380 - 420max	5.0	10.00
#2	18mm	13.5	min370 - 400max	2.5	05.00
#3	18mm	7.5	min370 - 400max	2.5	05.00
#4	13mm	9.0	min350 - 380max	1.5	03.00
#5	13mm	7.5	min350 - 380max	1.5	03.00
#6	9mm	9.0	min300 - 320max	0.7	01.40
#7	9mm	7.5	min300 - 320max	0.7	01.40
#8	32mm	13.5	min470 - 510max	9.0	18.00
#9	32mm	5.0	min470 - 510max	9.0	18.00
#10	32mm	10.0	min470 - 510max	9.0	18.00
#11	32mm	16.0	min470 - 510max	9.0	18.00
#12	36mm	13.0	min500 - 540max	11.0	22.00
#13	42mm	13.0	min550 - 600max	14.0	28.00
#14	44mm	13.0	min600 - 650max	17.0	34.00
#15	48mm	13.0	min700 - 750max	20.0	40.00
#16	52mm	12.0	min720 - 750max	23.0	46.00
#17	36mm	3.0	min500 - 540max	11.0	22.00
#18	36mm	4.0	min500 - 540max	11.0	22.00

TECHNICAL SPECIFICATIONS

- SPECIFICATIONS/STANDARD OF STEEL WIRE ROPE:
 - 1.1 UNGALVANISED STEEL WIRE ROPE OF CONSTRUCTION 6 X 36 (14-7+7-1)(CF) WITH FIBER CORE AND SHALL CONFORM TO IS-2266.
 - 1.2 FIBER CORE RIGHT HAND ORDINARY LAY, SHALL BE COMPLY WITH THE REQUIREMENTS OF IS-1804.
 - 1.3 TENSILE STRENGTH AS 1770 N/mm Sq. (180 KG/7mm Sq.) CONFORMING TO IS-1835.
 - 1.4 DIAMETER AND LENGTH OF EACH SLING SHALL BE AS MENTIONED IN THE TABLE GIVEN IN THE DRAWING AND SHALL COMPLY TO IS - 2266
 - 1.6 THE EYE LOOP SHALL BE TERMINATED BY MECHANISED SPLICING AS PER IS-5245(PART-II), HAND SPLICING NOT ACCEPTABLE.
 - TOLERANCE IN LENGTH - "L" IS $\pm 1\%$ OF "L".
 - IDENTIFICATION TAG: A STEEL WASHER(Normally used with fasteners) PUNCHED WITH SLING DETAILS e.g. SIZE OF SLING, SL.NO., MONTH & YEAR OF MFG & SAFE WORKING LOAD AND TO BE INSERTED IN LOOP AS SHOWN IN DRAWING OR SLING. DETAILS CAN ALSO BE PUNCHED IN LARGER SIZE FERRULES.

[eg. FOR #1 - 26 X 13.5 Mm. (Mfg.Company's short Name) - 9999. (Other side of washer) 09/2009, SWL-05 T1]
 - TESTING:
 - 4.1 TESTING OF WIRE ROPE SHALL BE DONE AS PER IS-2266.
 - 4.2 TESTING SHALL BE WITNESSED BY BHEL SAFETY INSPECTORS.
 - 4.3 BREAKING LOAD TEST: WIRE ROPE SHALL BE TESTED FOR MINIMUM BREAKING LOAD AS PER IS-2266, CERTIFICATE TO BE SUBMITTED.
 - 4.4 PROOF LOAD TEST: THE SUPPLIER SHALL TEST THE WIRE ROPE SLING FOR TWICE THE SAFE WORKING LOAD AS PER IS-5245 (PART-II).
 - 4.5 TESTING CERTIFICATE: THREE COPIES OF TEST CERTIFICATE AS SPECIFIED IN APPENDIX 'C' OF IS-6594 SHALL BE SUPPLIED.
 - 4.5 GREASE / OIL SHOULD NOT BE APPLIED ON THE ROPE/SLINGS UNTIL INSPECTED BY BHEL ENGINEERS.
 5. PACKING: SLINGS SHALL BE PACKED AS PER IS-6594.
- NOTE: WHEREVER STANDARDS ARE MENTIONED, THE LATEST VERSION OF THE SAME ARE TO BE REFERRED.

STEEL WIRE ROPE SLING

SCALE	STEAM TURBINE MANUFACTURING
NTS	DIV. BLOCK- 6, BHEL BHOPAL

DRG.NO:- STM/78/46 REV-04

Rev.03 Date:01.06.2015
ITEM NO. 9 TO 16 ADDED.

Rev.04 Date:20.12.2018
ITEM NO. 17 & 18 ADDED.

Rev.02 Date:14.11.2009

Rev.01 Date:15.10.2007

TECHNICAL SPECIFICATIONS AND MEASUREMENT TABLE IMPROVED, DELETED "SWL" WORD FROM DRAWING NO.

Item No-03,04,05,06, 07 & 08 added. T. Specification parts added.

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