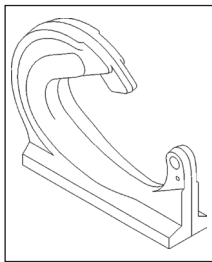


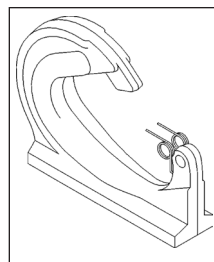
- Position the hook to insure that the load is applied in the plane of the hook, and the load is supported by the hook in all operating positions. Insure that the hook does not interfere with the operation of other mechanisms or cause pinch points.
- Insure that the maximum gap between hook base and support does not exceed 1/8". Modify the support structure if required to reduce gap.
- When welding hook to carbon or low alloy steels (less than .40% carbon), the following welding recommendations are to be followed. For welding hook to other grades of steel, a qualified weld procedure must be developed. Crosby hook material is AISI 8622 modified.
- Welding is to be performed by a qualified welder using qualified procedure in accordance with American Welding Society (AWS), and/or American Society of Mechanical Engineers (ASME) requirements.
- Welding electrode to be in accordance with AWS A5.4 E-312-16. Observe the electrode manufacturer's recommendations.
- Welding preheat range outlined below.
 - Minimum preheat temperature: 212F (100C)
 - Maximum temperature: 716F (380C)
- Before welding, the surface to be welded on, including the hook and support structure, must be clean and free from rust, grease and paint.
- Fillet weld leg size should be of minimum shown in Table 1. Weld profiles to be in accordance with AWS. Weld size is measured by length of leg.
- Welding should be carried out completely around base in a minimum of two passes to insure adequate root penetration at the base of the hook.
- Do not rapidly cool the weld.
- After welding, a visual inspection of the weld should be performed prior to painting.
- No Cracks, pitting, inclusions, notches or undercuts are allowed. If doubt exists, use a suitable NDE method, such as Magnetic Particle or Liquid Penetrate to verify.
- If repair is required on weld, grind out defect and re-weld using original qualified procedure.
- After welding, the assembly should be proof tested before putting into service.

Important – Instructions for Assembling S-4313 Latch on BH-313 Weld-On Hook



Step 1

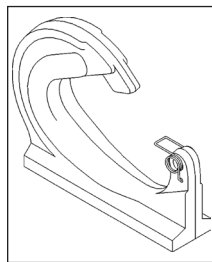
1. Place hook flat on work surface as shown.



Step 2

Hook sizes 1 to 3 tons

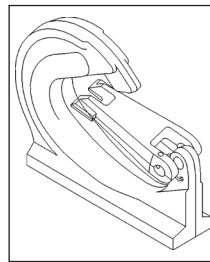
2. Position coils of spring over hook cam, with legs of spring pointing towards hook tip and coil of spring positioned down as shown.



Step 2A

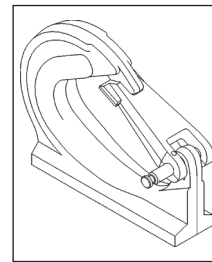
Hook sizes 4 to 10 tons

2A. Spread legs of spring and place into drilled hole. Position coils of spring over hook cam, with end of spring pointing toward hook tip as shown.



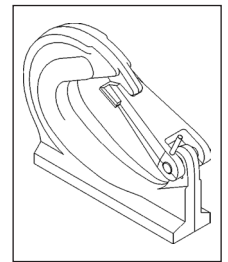
Step 3

3. Position latch over spring, aligning latch ears and spring coil. On pin hole side of latch, insert non grooved end of latch pin through hole in latch and through spring until contact is made with hook body (a small punch may be required for proper alignment).



Step 4

4. Align holes in latch with holes in cam of hook. Continue pushing the pin through hook, spring and latch.



Step 5

5. Insert roll-pin into latch, driving it in with a hammer, while ensuring that latch pin groove is in alignment.