

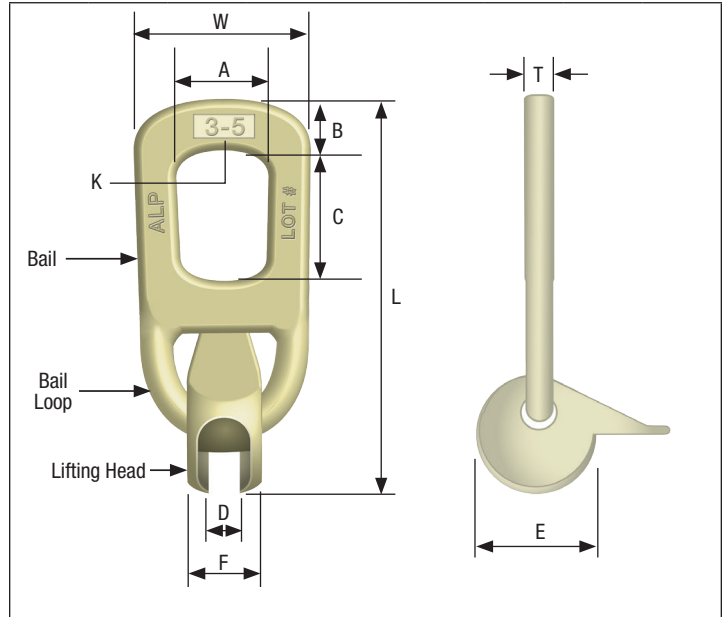
## INSPECTION & MAINTENANCE GUIDELINES FOR ALP® LIFTING EYE

The ALP™ Lifting Eye is an efficient, fast method in a connect/disconnect lifting system allowing precast concrete elements to be handled safely, with reliable and repeated use. The high quality, engineered lifting eye hardware is dimensionally measured, mechanically load tested and magnetic particle inspected (MPI) to ensure manufacturing processes meets and/or exceeds minimum design requirements.

The Lifting Eye is available in variable tonnage sizes: 1, 2, 4, 8 and 20 Tons. Lifting Hardware is clearly identified with its maximum load range, Lot # and company letters “ALP”. This system is exceptionally versatile and an economical choice for handling applied loads in any direction.

The Lifting Eye consists of a lifting head with a protruding lever arm and a high strength bail. The lifting head has a “T” slot that engages the head of a Lifting Pin Anchor. Rotation capabilities allow the lifting eye to stay oriented in the direction of loading to prevent binding. The design of the Lifting Eye body allows the bail to easily rotate 180 degrees, while the complete lifting eye hardware may rotate 360 degrees. This design feature permits precast concrete elements to be manipulated in various lifting sequences, such as, handling flat, rotating or turning during the loading process.

**ALP Supply does not recommend the use of this style Lifting Eye Hardware to be used in edge lifting of thin wall precast concrete panels.**



**ALP™ Lifting Eye – Chart 1.1 – Nominal Dimensions**

Part Number	Description	K Load Range (Tons)	Weight Each (lbs)	Ultimate Capacity in Tension (lbs)	L	W	A	B	C	D	E	F	T
LPLE1T	1T Lift Eye	1T-1.3T	2.20	13,000	7-11/32"	3"	1-3/4"	7/8"	2-3/4"	15/32"	1-5/16"	2-1/8"	1/2"
LPLE2T	2T Lift Eye	1.5T-2.5T	3.60	25,000	9"	3-1/2"	2-1/8"	1"	3-3/8"	11/16"	1-5/8"	2-9/16"	5/8"
LPLE4T	4T Lift Eye	3T-5T	7.65	50,000	11"	4-11/16"	2-5/8"	1-15/32"	3-7/16"	29/32"	2-1/4"	3-3/8"	11/16"
LPLE8T	8T Lift Eye	6T-10T	21.70	100,000	15-1/2"	6-1/4"	3-1/8"	2"	4-3/8"	1-1/4"	2-15/16"	4-1/2"	1-1/16"
LPLE20T	20T Lift Eye	12T-20T	44.10	200,000	20"	7-11/16"	4-3/8"	2-13/16"	5-15/16"	1-11/16"	4-3/8"	5-5/8"	1-3/8"

**ALP® Lifting Eye Lifting Head, Bail and Bail Loop – Chart 1.2 – Critical Dimensions Check**

Part Number	Description	Load Range (Tons)	B (Min.)	D (Max.)	G (Min.)	H (Min.)
LPLE1T	1T Lift Eye	1T-1.3T	0.55"	0.51"	0.22"	0.41"
LPLE2T	2T Lift Eye	1.5T-2.5T	0.69"	0.71"	0.24"	0.49"
LPLE4T	4T Lift Eye	3T-5T	1.10"	0.97"	0.31"	0.73"
LPLE8T	8T Lift Eye	6T-10T	1.42"	1.28"	0.50"	1.03"
LPLE20T	20T Lift Eye	12T-20T	2.21"	1.87"	0.79"	1.29"

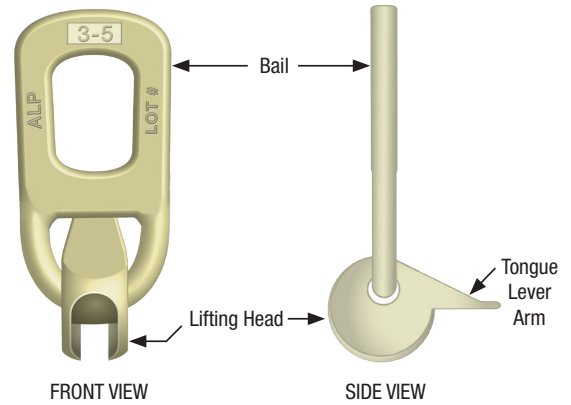
The diagram shows three views of the lifting hardware. The left view is a perspective view of the lifting head with dimensions H (height of the top opening), G (width of the lifting head), and D (width of the lifting head base). The middle view is a front view of the lifting head with dimensions B (height of the top opening) and D (width of the lifting head base). The right view is a side view of the bail and bail loop with dimension B (height of the bail).

All critical dimensions are unique to ALP® engineered and manufactured components, which have been verified through testing.

## INSPECTION & MAINTENANCE GUIDELINES FOR ALP® LIFTING EYE HARDWARE

Users must determine an inspection program based on frequency of use. The Lifting Eye Hardware may be exposed to mishandling, overloading, wear and any other factors that may contribute to adverse effects in lifting eye's allowable load ratings. Thus, it is pertinent that the lifting eye is inspected by a designated person on a regular basis to evaluate it's general condition and degree of wear. Reference ASME B30.20-2013: Section 20-1.3.

- ALP® Lift Eyes must be inspected immediately after returned from jobsite.
- Additional general inspections should be conducted periodically, depending on the frequency of use.
- Lift Eyes that don't meet the below inspection criteria should be immediately discontinued from use and destroyed. Inspection documents should be filed for the life of the Lift Eye.



### INSPECTING LIFT EYES

#### STEP 1 Prepare Lift Eye for Inspection

Prior to inspection, the Lift Eye should be cleaned to ensure any cracks or damage can be seen by the inspector.

#### STEP 3 Measure the Bail and Bail Loop

Dimensions B and H found in Chart 1.2 on page 1. These measurements must meet minimum requirements for the Lift Eye to pass inspection.

#### STEP 5 Measure the Lifting Head

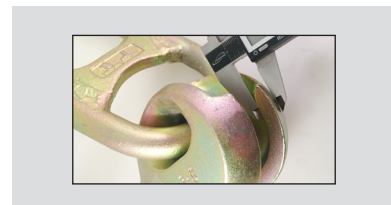
Dimensions D and G found in Chart 1.2 on page 1. These measurements must meet min/max requirements for the Lift Eye to pass inspection.

#### STEP 2 Visual Inspection of Bail

Visually inspect the bail for any splitting, cracking, deformation, bending, applied heat or damage to the welding. If the Lifting Eye fails any of this criteria it must be removed from service.

#### STEP 4 Visual Inspection of Lifting Head

Visually inspect the lifting head for any splitting, cracking, deformation, applied heat or damage. If the Lifting Eye fails any of this criteria it must be removed from service.



**WHEN REMOVING A LIFT EYE FROM SERVICE, THE CORRECT PROCEDURE IN DESTROYING THE HARDWARE IS TO CUT/TORCH THROUGH THE LIFTING BAIL TO DECLARE AS UNUSABLE.**

### Inspection Report, to be completed by the precast manufacturer or erection company

Date	Part Number	Nominal Dimensions (Verify all measurements in Chart 1.1, Pg 1)	Critical Dimensions (Chart 1.2, Pg 1)				Other Damage	Pass/Fail?	Inspector Initials
			B	D	G	H			