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Lifting Bag Inspection Procedure

Service life

Lifting bags are made from rubber and therefore exposed to ageing. Although the visual check-up shows that the bag is in good condition, we must recommend it be put out of operation after **15 years**.

Any bag more than 15 years old can be inspected and passed but not certified by the inspector.

Sequence of check-ups:

1. clean the bag
 2. visual and operating check-up
 3. inspect air supply hoses couplings
 4. inspect safety valves, couplings and pressure gauges on controllers
 5. inspect pressure reducer operation
 6. inspect lifting bag coupling devices (replace if worn or damaged)
- Pressurize bag with air to 10 PSI (air) and check for damage. If there is no damage visible such as holes or cuts, increase the pressure to 60 PSI (air) maximum and repeat the visual check-up. Pressurize bag with 118PSI hydro and hold for 10 min. repeat the visual check-up.

In case of holes or cuts, through which the armature is visible, it should be recommended that the lifting bags should be put out of operation. Due to safety reasons repair of such lifting bags is not allowed.

When the repair is allowed, it may be performed only by a manufacturer representative or its authorized person, who at the same time checks and tests the lifting bag after the repair.

Detecting defects

Damaged inflation nipples must be replaced.

Foreign objects in the rubber or materials such as excess Teflon tape residue must be removed or cleaned.

PROCEDURES FOR PERFORMING PERIODICAL CHECK-UPS

- o No leaks
- o No excess wear
- o No serious damage





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VISUAL CHECK-UP

Cord threads from the steel or Kevlar reinforcement may not protrude on the surface of the lifting bag. Visible imprints are acceptable, if rubber cannot be removed by a fingernail, that the rubber thickness is adequate.

FOREIGN BODIES ON SURFACE

Smaller foreign bodies may only be removed from the surface of the lifting bag, if they do not damage the surface on more than 1 square inch (25 x 25 mm) and if not too deeply imprinted in the surface. Small debris are allowed, while larger pieces of debris, stones etc. can change or affect the contact surface of the lifting bag. Recommend lifting bag be put out of operation.

BOILS

Boils that spoil the appearance and aggravate the efficiency of the lifting bag are not allowed.

Only boils with characteristics as stated below are allowed, on condition that their position does not affect the capacity, safety or efficiency of the product.

- a. firm, with a diameter of less than ¼ inch or 6.35 mm
- b. firm, 2 inches or 25.40 mm long and 1/8 inch or 3.175 mm or less wide
- c. firm, protruding from the surface less than 1/6 inch or 1.587 mm.

Soft and porous boils, bulges under a label, are grounds for inspection failure.

CRACKS

Cracks more than 1/32 inch or 0.794 mm wide and up to 1/32 inch or 0.794 mm deep with a visible edge and up to 4 inch or 101.60 mm long are acceptable, if their position does not affect the properties and safety of the product.

BLISTERS

Blisters are areas with soft edges and spongy to touch. Blisters are boils inside the lifting bag and do not spoil its appearance. If the feature exceeds the safety limits, the product is not acceptable.





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VOIDS

Voids will be described as areas that give the edges of the air bag a soft or spongy feeling. The void is a bubble inside the border of the air bag that does not disturb or disfigure the appearance of the air bag. These will not be accepted since they would detract from the safety margins designed into the product.

PLY SEPARATION

Visible ply separations are not acceptable. If the lifting bag armature contains a boil or a void, the bag should be rejected. If anywhere in the bag air or water remains captured, the bag should be put out of operation.

PLY INTERLACING

Acceptable, if it does not affect the capacity, safety and use of the product, even if wrinkles or uneven surface appear. If interlacing is too excessive, the bag should be rejected.

FOLDS ON BAG EDGES UNDER PRESSURE

Depth: a fold on the edge is acceptable if its depth does not exceed 3/8 inch or 9.525 mm.

Width: a fold on the bag is acceptable, if its width does not exceed 3/8 inch or 9.525 mm. It may appear only on one or two spots on the bag.

INFLATION PORT

Completely deflate the bag, check the inflation nipple and inside threads and possible damages.

AIR INLET FITTING

The brass fitting must not be worn, broken, cracked or cross threaded.

THREAD DAMAGE

If the threads are crossed or improperly tapped the bag fails the test.

