



EARLS INDUSTRIES LTD.

1616 Kebet Way, Port Coquitlam B.C., CANADA V3C 5W9

Bus: 604.941.8388 Fax: 604.941.8302

Web: www.earlsindustries.com

EARLS Industries Ltd. Twistlock Pin Manufacturing Procedure

It is important to note that **EARLS Twistlocks** are somewhat “different” from many others.

1. the pin is machined from a solid billet of alloy bar (4340HTSR) that has been heat-treated-stress-relieved in the steel mill manufacturing process
2. each order of pins includes a copy of the steel mill certificate with the chemical analysis & heat number for QC traceability
3. all pins are individually pull tested (with the nut) at 200% of the SWL
4. the pins & nuts are stamped with a pull test ID number and this data is recorded in our log book
5. the pins have a long working life design that requires an annual NDT inspection and allows re-use if no defects are identified, ... and so on ..., and so on ..., et cetera
6. once a specific pin has been produced, we can normally offer very quick deliver for repeat orders of that pin/nut combo, depending on WIP at that particular time



CAMERON COATTA – Sales Representative

EMAIL: cbjcoatta@telus.net

TEL: +1-604-941-8388

FAX: +1-604-941-8302

WEB: www.earlsindustries.com



EARLS INDUSTRIES LTD.

1616 Kebet Way, Port Coquitlam B.C., CANADA V3C 5W9

Bus: 604.941.8388 Fax: 604.941.8302

Web: www.earlsindustries.com

EARLS Industries Ltd. Twistlock Pin and Nut Re-Certification

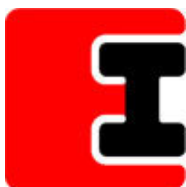
The estimated price for re-certification is \$85.00 net per pin/nut set (doing a minimum of four pin/nuts sets per inspection) and it includes the following process:

1. Mechanic – clean and perform a quick 1st visual inspection to look for obvious problems
2. Machinist – perform a comprehensive 2nd visual inspection to confirm integrity of threads, keyways, et cetera
3. Welder – perform a 1st Mag Particle test on the pin to look for pre-existing fatigue cracks at the head or threads areas
4. Mechanic – perform a proof-load test equal to 200% of the SWL on our certified load tester
5. Welder – perform a 2nd Mag Particle test on the pin to look for any cracks that might have been induced by the proof-load test
6. Mechanic – record the ID numbers and record the re-certification details in our log book
7. Engineer - issue a Test Certificate (one cert per “series” tested)

If at any time the pin/nut set fails to pass, the process is stopped, the pin/nut should be discarded, and the charge is reduced to \$35.00, unless we are consequently supplying a new replacement pin/nut set, in which case there is no charge for the test failure.

Turn-around time is in & out within 2-to-3 full working days.

Please ensure that all pins/nuts sent for inspection are clearly tagged to indicate your company name, the date sent, and the identification of the spreader or headblock Make & Model numbers.



CAMERON COATTA – Sales Representative

EMAIL: cbjcoatta@telus.net

TEL: +1-604-941-8388

FAX: +1-604-941-8302

WEB: www.earlsindustries.com