

SPECIFICATION S024			MFA Open Link Chain Cable and Catfaces	
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Revision	Date	Written by	Checked by	Approved by

1 SCOPE

This Specification comprises the manufacture, inspection, testing and finishing of open link chain and catfaces for use in Trinity House Lighthouse Service (THLS) major floating aids (MFA) moorings.

2 REFERENCE DRAWINGS AND STANDARDS

The chain, shall be sized and formed in accordance with the relevant TH Drawing(s) listed below:

Open Link Chain

Drg. No. 204/382

Where called for all chain shall conform to the recommendations of the following international and British Standards:

BS EN 10083-1: Steels for quenching and tempering
BS 3416 Bitumen-based coatings for cold application
ISO 1704: Stud link anchor chains

3 MATERIAL SPECIFICATION

All items to be made from steel grade U3 to Lloyds Rules

4 FORM

4.1 Open Link Chain

OPEN LINK – manufactured in accordance with Drg. No. 204/382 sheet 1.

Tolerances to be as per ISO 1704 stud link chain

Unless otherwise stated the cable length for lightvessel Hawse is 10 metres.

4.2 MFA CATFACES

The catface is shown on THLS Drg. No. 204/382 sheet 2. It should be profile cut from suitable steel with the holes radiused as shown and fitted with end links from 44mm chain.

5 HAWSE CABLE

Hawse chain is to be manufactured to the dimensions given in 204/382 sheet 1.

6 PROOF AND BREAKING LOAD TESTS

Each length of cable or catface is to be examined, tested, weighed, marked and certified by a Lloyds Examiner.

The chain marking is to indicate the following:

1. Manufacturer's mark
2. Manufacturer's Serial Number
3. The month and year of manufacture
4. The metric tonne proof load applied

One three link sample of chain is to be selected from **each length** of chain manufactured and subject to the breaking load specified for U3.

7 GENERAL

7.1 Inspection, Testing and Certification

All items shall be inspected, tested and certificated by an Inspector of IACS. Certificates of Conformity shall be provided including:

- Manufacturer's name
- Drawing/Specification numbers and issues
- Material Certificates: original material analysis and results of mechanical properties tests on samples of the finished items following heat treatment
- Proof test and examination certificates
- Break load test results
- Identification of test houses used
- Identification of inspectors
- Identification marks on items
- Confirmation that the material form, dimensions and test results comply with the specification

Items approved by the Inspector are to be recommended to the GLA Engineer(s) for acceptance subject to final finishing treatment being satisfactorily carried out. Certification should be returned to the GLA Engineer(s) for final approval and items should not be dispatched until this approval is received.

GLA Engineers may wish to witness the inspection and testing and are to be given, where possible one weeks notice of the commencement of proof testing. A minimum of 48 hours notice **must** be given.

7.2 Finish

Following inspection and test, all items are to be wire brushed and painted with black bitumastic paint complying with BS 3416 Type 1.