

ASME HST-1–2017
(Revision of ASME HST-1–2012)

Performance Standard for Electric Chain Hoists

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AN AMERICAN NATIONAL STANDARD



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Mechanical Engineers**

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**The American Society of
Mechanical Engineers**

Two Park Avenue • New York, NY • 10016 USA

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FOREWORD

This Standard is one in a series that provides performance requirements for hoists; it was originally issued in 1982. It was developed by the ASME HST Standards Committee, Hoists — Overhead. It is intended to serve as a guide to manufacturers of the equipment and to the purchasers and users of the equipment.

Standards in this series are as follows:

Designator	Title
HST-1	Performance Standard for Electric Chain Hoists
HST-2	Performance Standard for Hand Chain Manually Operated Chain Hoists
HST-3	Performance Standard for Lever Hoists
HST-4	Performance Standard for Overhead Electric Wire Rope Hoists
HST-5	Performance Standard for Air Chain Hoists
HST-6	Performance Standard for Air Wire Rope Hoists

ASME HST-1-2012 incorporated an appendix that, in conjunction with ASME HST-1, was intended to replace MIL-H-15317, which was previously used by the Department of Defense (DoD) to procure electric chain hoists. ASME HST-1-2012 was rewritten and reorganized to harmonize with ASME B30.16 to eliminate duplication and conflicts in content. The requirements for this Standard shall be applied together with the requirements of B30.16 for the products covered.

ASME HST-1-2012 was approved by ANSI as an American National Standard on October 4, 2012.

This edition of ASME HST-1 includes revised definitions and other changes, and addresses two-speed and variable speed operation.

Following the approval of the ASME HST Standards Committee and ASME, and after public review, ASME HST-1-2017 was approved by the American National Standards Institute on November 17, 2017.

ASME HST COMMITTEE

Hoists — Overhead

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Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

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Requests for interpretation should preferably be submitted through the online Interpretation Submittal Form. The form is accessible at <http://go.asme.org/InterpretationRequest>. Upon submittal of the form, the Inquirer will receive an automatic e-mail confirming receipt.

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Subject:	Cite the applicable paragraph number(s) and the topic of the inquiry in one or two words.
Edition:	Cite the applicable edition of the Standard for which the interpretation is being requested.
Question:	Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. Please provide a condensed and precise question, composed in such a way that a "yes" or "no" reply is acceptable.
Proposed Reply(ies):	Provide a proposed reply(ies) in the form of "Yes" or "No," with explanation as needed. If entering replies to more than one question, please number the questions and replies.
Background Information:	Provide the Committee with any background information that will assist the Committee in understanding the inquiry. The Inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.

Requests that are not in the format described above may be rewritten in the appropriate format by the Committee prior to being answered, which may inadvertently change the intent of the original request.

Moreover, ASME does not act as a consultant for specific engineering problems or for the general application or understanding of the Standard requirements. If, based on the inquiry information submitted, it is the opinion of the Committee that the Inquirer should seek assistance, the inquiry will be returned with the recommendation that such assistance be obtained.

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Chapter 1-0

Scope, Definitions, References, and Appendices

SECTION 1-0.1: SCOPE

(a) This Standard establishes performance requirements for electric chain hoists for vertical lifting service involving material handling of freely suspended (unguided) loads using load chain of the roller or welded link types with one of the following types of suspension:

- (1) lug
- (2) hook or clevis
- (3) trolley

(b) This Standard is applicable to hoists manufactured after the date on which this Standard is issued. It is not applicable to

- (1) damaged or malfunctioning hoists
- (2) hoists that have been misused or abused
- (3) hoists that have been altered without authorization of the manufacturer or a qualified person
- (4) hoists used for lifting or supporting people
- (5) hoists used for the purpose of drawing both the load and the hoist up or down the hoist's own load chain(s)
- (6) hoists used for marine and other applications as required by the Department of Defense (DoD)

The requirements of this Standard shall be applied together with the requirements of ASME B30.16. Please also refer to ASME B30.16 for requirements pertaining to marking, construction, and installation; inspection, testing, and maintenance; and operation.

SECTION 1-0.2: DEFINITIONS

abnormal operating conditions: environmental conditions that are unfavorable, harmful, or detrimental to the operation of a hoist, such as excessively high or low temperature, exposure to weather, corrosive fumes, dust laden or moisture laden atmospheres, and hazardous locations.

ambient temperature: the temperature of the atmosphere surrounding the hoist.

beam: an overhead standard structural or specially fabricated shape, on which the trolley operates.

brake: a device, other than a motor, used for retarding or stopping motion by means of friction or power.

brake, holding: a friction brake for a hoist that is automatically applied and prevents motion when power is off.

brake, mechanical load: an automatic type of friction brake used for controlling loads in a lowering direction. This unidirectional device requires torque from the motor to lower a load but does not impose any additional load on the motor when lifting a load. This type of brake may also be used as a holding brake if designed as such by the manufacturer.

braking, control: a method of controlling speed by removing energy from the moving body or by imparting energy in the opposite direction.

braking, dynamic: a method of controlling speed by using the motor as a generator, with the energy being dissipated in resistors.

braking, mechanical: a method of controlling or reducing speed by friction.

braking, regenerative: a method of controlling speed in which the electrical energy generated by the motor is fed back into the power system.

chain, load: the load-bearing chain in a hoist.

chain, roller: a series of alternately assembled roller links and pin links in which pins articulate inside the bushings, and the rollers are free to turn on the bushings. Pins and bushings are press-fit in their respective link plates.

chain, welded link: a chain consisting of a series of interwoven links formed and welded.

NOTE: Load chain properties do not conform to those shown in ASME B29.1 or ASME B30.9.

contactor: an electromechanical device for opening and closing an electric power circuit.

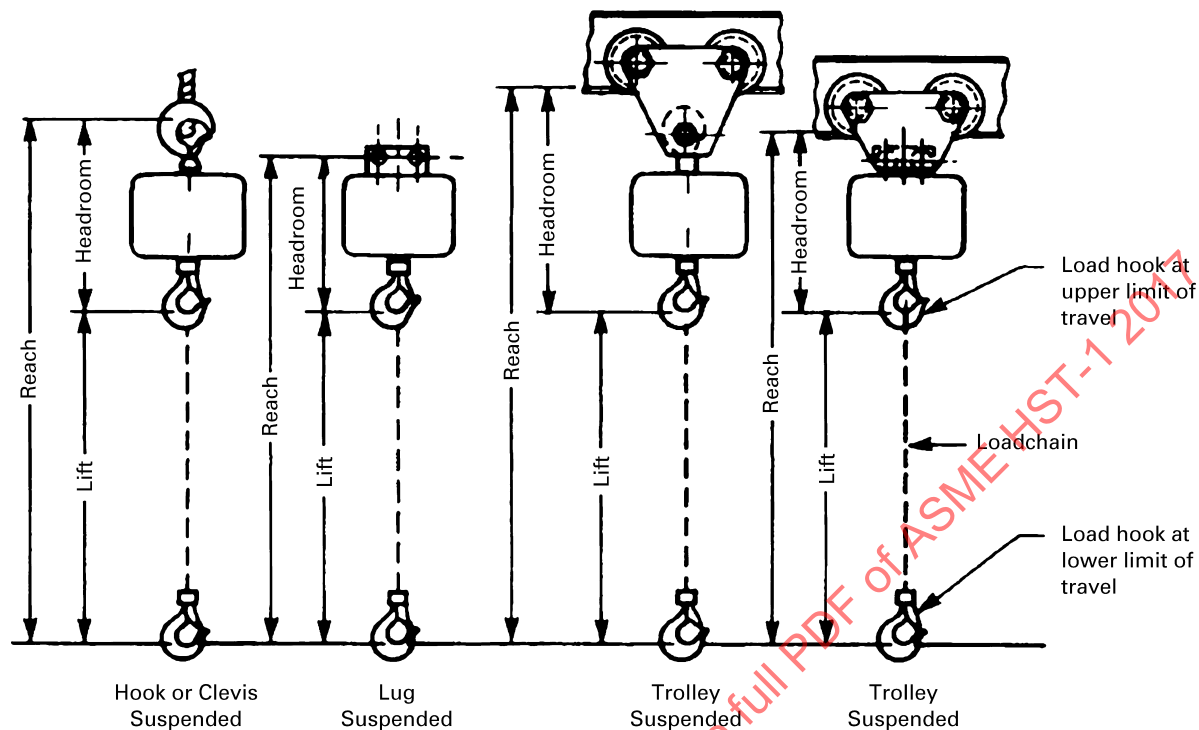
control actuator: a manual means at the operating station by which hoist controls are energized.

control enclosure: the housing containing the electrical control components.

cushioned start: an electrical or mechanical method for reducing the rate of acceleration of trolley motion.

hazardous (classified) locations: locations where fire or explosion hazards may exist. Locations are classified depending on the properties of the flammable vapors, liquids or gases, or combustible dusts or fibers that may be present, and the likelihood that a flammable or combustible concentration or quantity is present. Refer to NFPA 70.

Figure 1-0.2-1 Headroom, Lift, and Reach



headroom: headroom is measured with the load hook at its upper limit of travel and is the distance from the saddle of the load hook to the following locations (see Figure 1-0.2-1):

- (a) saddle of the top hook on hook suspended hoists
- (b) centerline of the suspension holes on lug suspended hoists
- (c) wheel treadline on trolley suspended hoists

hoist: a machinery unit that is used for lifting or lowering a freely suspended (unguided) load.

hoist speed: the rate of motion that the load hook obtains while lifting rated load.

hook suspended: suspension of hoist from a trolley or rigid structure by means of a hook at top of hoist.

idler sprocket: a freely rotating device that changes the direction of the load chain. This device is sometimes called idler wheel, idler sheave, pocket wheel, or chain wheel (see Figure 1-0.2-2).

lift: the maximum vertical distance through which the load hook can travel, and is the total hook movement between its upper limit of travel and its lower limit of travel (see Figure 1-0.2-1).

lifting devices, below-the-hook: devices that are not normally reeved onto the hoist chains such as hook-on buckets, magnets, grabs, and other supplemental devices used for handling certain types of loads. The

weight of these devices is to be considered part of the load to be lifted.

limit device: a device that limits equipment motion or takes control of particular functions without action of the operator when a limiting condition is reached.

load, rated (capacity): maximum load designated by the manufacturer for which the hoist is designed and built.

load, working: the external load applied to the hoist, including the weight of load-attaching equipment such as shackles and slings.

load block: the assembly of hook or shackle, swivel, bearing, pins, sprocket, and frame suspended by the load chain. This shall include all appurtenances reeved in the load chain.

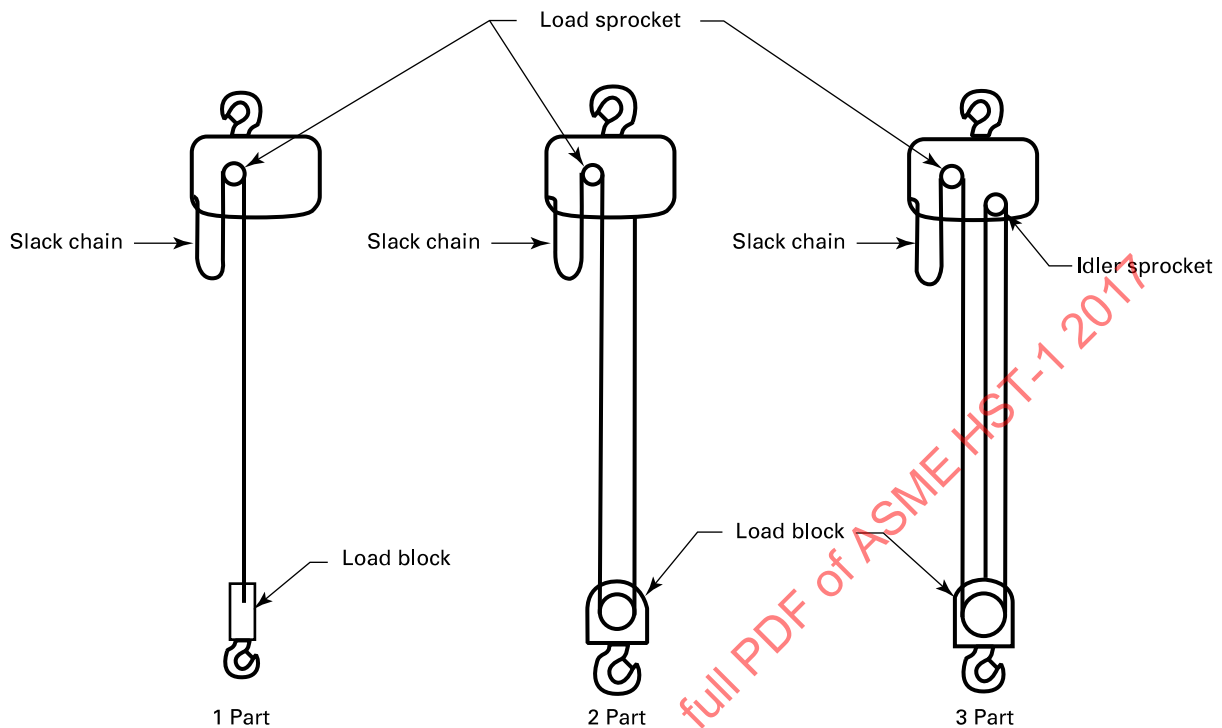
load chain container: a device used to collect the slack load chain.

load hook: the hook used to connect the load to the hoist.

load sprocket: a hoist component that transmits motion to the load chain. This component is sometimes called load wheel, load sheave, pocket wheel, chain wheel, or lift wheel (see Figure 1-0.2-2).

load suspension parts: the means of suspension (hook or lug), the structure or housing that supports the load sprocket, the load chain, the sprockets, and the load block or hook.

Figure 1-0.2-2 Reeving



lug suspended: suspension of the hoist from a trolley or permanent structure by means of a bolt(s) or pin(s) through a rigid- or swivel-type lug.

magnetic control: a means of controlling the direction and speed of the hoist and trolley by using magnetic contactors and relays.

minimum radius: the smallest radius of the beam, measured to the centerline of the web of the beam, on which the trolley will operate.

normal operating conditions: conditions during which a hoist is performing functions within the scope of the original design.

overload: any load greater than the rated load.

parts (lines): number of lines of chain supporting the load block or hook.

pendant station: electrical controls suspended from the hoist for operating the unit from the floor.

power transmission parts: the machinery components, including the gears, shafts, clutches, coupling, bearings, motors, and brakes.

qualified person: a person who, by possession of a recognized degree in an applicable field or a certificate of professional standing, or who, by extensive knowledge, training, and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter and work.

rated frequency: the electrical operating frequency listed on the hoist nameplate or the hoist motor nameplate.

reach: the distance from saddle of load hook at its lower limit of lift to the upper point of the headroom measurement. Reach is equal to lift plus headroom (see Figure 1-0.2-1).

reeving: a system in which a chain travels around sprockets (see Figure 1-0.2-2).

shall: a word indicating a requirement.

should: a word indicating a recommendation.

STOP-START, OFF-ON, POWER OFF-POWER ON control functions: control functions that are used to close and open a mainline contactor that provides or removes line power to or from all other function contactors.

switch: a device for making, breaking, or for changing the connections in an electric circuit.

trolley: a wheeled mechanism from which a hoist is suspended to provide horizontal motion of the hoist along a beam.

trolley speed: the rate of motion that a motor-operated trolley (and hoist) obtains while traveling along a beam.

trolley suspended: suspension of a hoist from a trolley. The hoist can be connected to the trolley by hook, clevis, or lug suspension, or the hoist can be integral with the trolley.

SECTION 1-0.3: REFERENCES

The following is a list of publications referenced in this Standard. The latest edition shall apply.

ASME B29.1, Precision Power Transmission Roller Chains, Attachments, and Sprockets

ASME B30.9, Slings

ASME B30.16, Overhead Underhung and Stationary Hoists
Publisher: The American Society of Mechanical Engineers (ASME), Two Park Avenue, New York, NY 10016-5990 (www.asme.org)

NFPA 70, National Electrical Code

Publisher: National Fire Protection Association (NFPA), 1 Batterymarch Park, Quincy, MA 02169-7471 (www.nfpa.org)

SECTION 1-0.4: APPENDICES

[Nonmandatory Appendix A](#) applies to the performance requirements for hoists used in marine and other applications.

The requirements stated in [Nonmandatory Appendix A](#) are in addition to the requirements of ASME HST-1 and ASME B30.16 and must be invoked separately.

[Nonmandatory Appendix B](#) includes examples of hoist applications as an aid to users in making the selection of the proper hoist for the application.

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Chapter 1-1

Performance

SECTION 1-1.1: GENERAL

All equipment selected in accordance with this Standard is designed to perform satisfactorily when used in accordance with Chapters 16-2 through 16-4 of ASME B30.16 and used within the rated load and hoist duty service classification. All equipment shall provide speeds, lifts, and headroom in accordance with the manufacturer's specifications or to specifications agreed upon by the manufacturer and the user.

SECTION 1-1.2: HOIST DUTY SERVICE CLASSIFICATION

Service conditions have an important influence on the performance of the wearing parts of a hoist, such as gears, bearings, load chain, sprockets, electrical equipment, brake linings, load and lift limiting devices, and wheels. Careful consideration of the hoist duty service classifications described in this Section will enable the user to evaluate the application, and to obtain a hoist designed for optimum performance and minimum maintenance. If doubt exists regarding hoist selection, the hoist supplier should be consulted. Many factors enter into the selection of the proper hoist to perform a given function. Hoisting equipment consists of both mechanical and electrical components and both must be considered when analyzing the service the hoist must perform.

The factors that influence the mechanical and electrical performance of any hoist include the following:

(a) *Load Distribution.* The actual distribution or proportion of full and partial loads to be handled by the equipment, including lifting devices, has an important effect on the life of power transmission components. For example, ball-bearing life varies according to the cube of the load. A 2-ton (1 814.4-kg) hoist operated at a mean effective load of 1 ton (907.2 kg) will have a ball-bearing life eight times that of the same hoist used steadily at its rated load.

(b) *Operational Time.* Operational time is the total running time of the hoist per hour or per work period.

(c) *Work Distribution.* This is determined by whether the operational time is uniformly distributed over the work period or concentrated in a short time span. Work distribution generally does not appreciably affect mechanical wear, but does materially affect the electrical components such as motors, brakes, and controls. For

example, a hoist motor designed to operate 15 min out of each hour of an 8-hr shift cannot handle 2 hr of steady run and 6 hr of idle time even though either condition only requires 2 hr of operational time per 8-hr shift.

(d) *Number of Starts and Stops.* This directly affects all electromechanical devices, such as motors, contactors, brakes, and solenoids.

(e) *Repetitive Long Lowering Operations.* Such operations generate heat in control braking means.

(f) *Environmental Conditions.* Hoist equipment is designed to operate in ambient temperatures between 0°F (–18°C) and 104°F (40°C) and in atmospheres reasonably free from dust, moisture, and corrosive fumes unless otherwise specified.

(g) *Hazardous Locations.* If hoists are used in hazardous locations as defined by NFPA 70 or other special codes, modifications or additional precautions not covered by this Standard may be required. In these locations, only hoists designed in a manner suitable for the conditions encountered shall be used.

SECTION 1-1.3: DUTY CLASSIFICATION

While all the factors listed in [Section 1-1.2](#) must be considered in selecting the proper class of hoist, most industrial applications, having randomly distributed loads or uniform loads up to 65% of rated load handled periodically throughout the work period, can be generalized according to the type of work shop or area of application. Listed in Column 1 of [Table 1-1.3-1](#) are the three duty classes that have been established for electric chain hoists. In Column 2 are listed typical areas of application where each class can normally be applied. The majority of hoist applications will fall into one of the two categories, H2 or H3, and the use of the generalized description in Column 2 of [Table 1-1.3-1](#) for selection of the hoist will be adequate.

1-1.3.1 Operational Time Ratings

If in doubt as to the required duty classification for an application, refer to the data in Columns 3 through 6 of [Table 1-1.3-1](#), which show the operational time ratings for each class.

Table 1-1.3-1 Duty Classifications

Hoist Duty Class (Column 1)	Typical Areas of Application (Column 2)	Operational Time Ratings at $K = 0.65$ [Note (1)]			
		Uniformly Distributed Work Periods		Infrequent Work Periods	
		Max. On Time, min/hr (Column 3)	Max. No. of Starts/hr (Column 4)	Max. On Time From Cold Start, min (Column 5)	Max. No. of Starts (Column 6)
H2	Light machine shop, fabricating service, and maintenance. Loads and utilization randomly distributed. Rated loads infrequently handled.	7.5 (12.5%)	75	15	100
H3	General machine shop, fabricating, assembly, storage, and warehousing. Loads and utilization randomly distributed.	15 (25%)	150	30	200
H4	High-volume handling in steel warehouses, machine shops, fabricating plants and mills, and foundries. Manual or automatic cycling operations in heat treating and plating. Loads at or near rated load frequently handled.	30 (50%)	300	30	300

GENERAL NOTES:

- (a) *Two-Speed Operation.* Unless otherwise specified by the hoist manufacturer, electric chain hoists should not be operated in the low speed for more than one-third of the maximum on time for any duty classification. Also, each transition from low to high speed or high to low speed should be considered a motor start when calculating the maximum number of starts per hour. For slow speed operation beyond one-third of maximum on time, consult the hoist manufacturer.
- (b) *Variable Speed (VFD) Operation.* For this Standard, the variable speed operation is categorized as follows:
- (1) slow speed: operation at 25% to 50% of rated frequency
 - (2) normal speed: operation at 50% to 100% of rated frequency
 - (3) overspeed: operation above 100% of rated frequency

Unless otherwise specified by the hoist manufacturer, slow speed operation of VFD-equipped electric chain hoists should be limited to no more than one-third of the maximum on time for any duty classification. For regular operating speeds below 25% of rated frequency or for low speed operation beyond one-third of the maximum on time or for overspeed operation, consult the hoist manufacturer. For calculation of the maximum number of starts per hour, a "motor start" is the starting of the motor from a stationary state. Any instances of starting the motor from a nonstationary state should not be considered in the calculation.

NOTE: (1) See paras. 1-1.3.1 and 1-1.3.2.

(a) *Uniformly Distributed Work Periods*

(1) *Maximum On Time in Minutes per Hour (Column 3).* The maximum running time in minutes per hour permitted for duty class when hoist utilization is uniformly distributed over a given work period.

(2) *Maximum Number of Starts per Hour (Column 4).* The maximum number of motor starts per hour permitted for the duty class when hoist utilization is uniformly distributed over a given work period.

(b) *Infrequent Work Periods*

(1) *Maximum On Time From Cold Start in Minutes (Column 5).* The maximum total running time for hoist utilization for the duty class starting with hoist at ambient temperature. These values cover infrequent periods of extended use and are applicable only with hoist at ambient temperature and cannot be repeated unless hoist is allowed to cool down to ambient temperature between periods. Typical examples would include setting machinery in place, unloading a truckload of steel, filling a stock order from a stock room, etc.

(2) *Maximum Number of Starts (Column 6).* The maximum total number of motor starts permitted for infrequent work periods specified in Column 5.

1-1.3.2 Mean Effective Load

Mean effective load denotes a theoretical single load value that has the same effect on the hoist as various loads actually applied to the hoist over a specified period of time. K is the mean effective load factor and is expressed as

$$K = \sqrt[3]{W_1^3 P_1 + W_2^3 P_2 + W_3^3 P_3 \dots W_n^3 P_n}$$

where

K = mean effective load factor. Mean effective load factor is the ratio of mean effective load to rated load.

P = load probability. Load probability is the ratio of running time under each load magnitude condition to the hoist total running time. The sum total of all load probabilities used in the above equation must equal 1.0.

W = load magnitude. Load magnitude is the ratio of the hoist operating load to the hoist rated load. Operation with no load must be included along with the weight of any dead load such as lifting attachment of devices.

1-1.3.3 Randomly Distributed Loads

Randomly distributed implies that loads applied to the hoist are assumed to be evenly distributed within the rated load of the hoist in decreasing steps of 20% of the previous load value. Random loads are, therefore, considered as 100%, 80%, 64%, 51%, 41%, 33%, 26%, etc., of rated load. Operation with random loads is considered on an equal-time basis for the operating time remaining after accounting for the time the hoist is operating at no load and with rated load. Randomly distributed loads will result in a mean effective load factor of 0.65.

SECTION 1-1.4: APPLICATION ANALYSIS

1-1.4.1 General

(a) If the operation consists of lowering loads over long distances of more than 50 ft (15 m), the mechanical load brake heat dissipation capability (overheating) may become a factor. Consult manufacturer for particulars.

(b) Motor heating generated by the number of starts is not appreciably affected by the load on the hook and therefore the limits imposed by Columns 3 through 6 of [Table 1-1.3-1](#) are applicable for the motor regardless of the load being handled.

1-1.4.2 Fundamental Application Analysis

It is not necessary to perform a detailed application analysis or calculate mean effective load factor if all of the conditions listed below are met.

(a) The hoist is operating at no load during one-half of its operating time (load probability equals 0.5).

(b) The hoist is operating with rated load for a period of time not exceeding 20% of its operating time (load probability equal to or less than 0.2).

(c) Other loads applied to the hoist during the remainder of its operating time are randomly distributed.

Conditions wherein the above operating criteria are met will result in a mean effective load factor of 0.65 or less. If any one of these conditions cannot be met, or if a below-the-hook lifting device is attached to the load hook, a detailed application analysis using a calculated mean effective load factor should be conducted.

1-1.4.3 Detailed Application Analysis

The following general method may be used to make a detailed application analysis. Several examples of this detailed analysis method are given in [Nonmandatory Appendix B](#).

(a) Select a hoist class from [Table 1-1.3-1](#) based on the general descriptions given in Column 2.

(b) Select a hoist with a rated load equal to or greater than maximum load to be lifted.

(c) Using the information in Columns 3 through 6, select the hoist speed that will meet the operational time ratings for hoist duty class.

(d) Determine value of K . If K is greater than 0.65, select a hoist with a higher rated load rating and recalculate K to make sure it is equal to or less than 0.65.

(e) If the requirements of the operational time values in [Table 1-1.3-1](#) and K equal to or less than 0.65 cannot be met, contact the manufacturer.

SECTION 1-1.5: SPECIFICATION OF LIFT, HEADROOM, AND REACH

1-1.5.1 Lift

Most electric chain hoists are manufactured with standard lifts of 10 ft (3.1 m), 15 ft (4.6 m), and 20 ft (6.1 m). One of these standard lifts will normally be adequate for the particular requirement. It is recommended that the purchaser specify the required lift on his/her inquiry or bid request.

1-1.5.2 Headroom

Headroom should be specified if it is important to the application.

1-1.5.3 Reach

Reach should be specified if important to the application.

SECTION 1-1.6: SPEEDS: HOIST AND TROLLEY

Hoisting equipment is available over a wide range of hoist and trolley speeds. Listed in [Table 1-1.6-1](#) are typical speed ranges commonly available. Hoist and trolley speeds may vary $\pm 10\%$ from the specified speed.

NOTE: [Table 1-1.6-1](#) is to be used as a guide only and is not intended to restrict either the manufacturer or buyer from offering or specifying speeds outside the ranges shown, nor should it be inferred that speeds above or below the range shown are not compatible with the required class of hoist.

SECTION 1-1.7: TROLLEYS

Hoist trolleys are available in plain, hand-chain-operated, and motor-driven types. Selection of each type depends upon the application.

1-1.7.1 Plain Trolleys

This type is recommended where trolley motion is infrequent or relatively short. Due to the required force to manually operate this type of trolley, it is also

Table 1-1.6-1 Typical Hoist and Motorized Trolley Speeds

Rated Load		Hoist Speed ft/min (m/min) [Note (3)]	Motorized Trolley Speed ft/min (m/min) [Note (3)]
tons (kg) [Note (1)]	tonnes (kg) [Note (2)]		
1/8 (114)	1/8 (125)	16-64 (5-20)	30-100 (9-30)
1/4 (227)	1/4 (250)	7-64 (2-20)	30-100 (9-30)
1/2 (454)	1/2 (500)	7-64 (2-20)	30-100 (9-30)
1 (908)	1 (1 000)	7-64 (2-20)	30-100 (9-30)
1 1/2 (1 361)	1 1/2 (1 500)	4-40 (1-12)	30-100 (9-30)
2 (1 815)	2 (2 000)	4-40 (1-12)	30-100 (9-30)
3 (2 722)	3 (3 000)	4-40 (1-12)	30-100 (9-30)
4 (3 629)	4 (4 000)	4-24 (2-7)	30-100 (9-30)
5 (4 536) and over	5 (5 000) and over	4-24 (2-7)	30-100 (9-30)

GENERAL NOTES:

- (a) Hoist and trolley speeds should be determined by an analysis of the number and length of cycles required for the work period.
 (b) For trolley speeds above 100 ft/min (30 m/min) or for use on beams with curved sections, it is recommended that a cushioned start or multispeed drive be specified.
 (c) In applications requiring close load spotting for hoist or trolley, refer to manufacturer for reduced speed or multiple speed control.

NOTES:

- (1) 1 tonne = 2,000 lb
 (2) 1 ton = 1 000 kg
 (3) Ranges shown are for single-speed hoists and trolleys.

recommended that use of plain trolleys be limited to a maximum load of 3 tonnes (3 000 kg) with the elevation of the beam not more than 20 ft (6 m) above the operator's floor level.

1-1.7.2 Hand-Chain-Operated Trolleys

Motion is obtained by pulling on the hand chain that is connected to trolley wheels through gears or sprockets. This type is recommended where trolley motion is relatively infrequent or short, and especially for those loads and beam heights where a plain-type trolley would be impractical.

The hand-chain-operated trolley provides good load spotting ability.

The hand chain shall be guarded to prevent hand chain disengagement from the hand chain wheel.

The hand chain shall withstand, without permanent distortion, a force of three times the pull required to traverse the trolley with rated load.

1-1.7.3 Motor-Driven Trolleys

This type is recommended where operating frequency, distance of travel, or the type of load to be handled would cause unsatisfactory operation if trolley were plain or of the hand-chain-operated type. Design of motor-operated trolleys shall be based on intermittent operation on a straight beam, unless otherwise specified. Where trolley travel involves curved beam, beam switches,

exceptionally long runs, or near continuous operation, a special design may be required and full particulars should be provided with inquiry.

Brakes, when specified, may be actuated by mechanical or electrical means and shall have the following characteristics:

(a) Brakes shall have sufficient capacity to stop the trolley within a distance in feet (meters) equal to 10% of the rated load speed in ft/min (m/min) when traveling at rated speed with rated load.

(b) Brakes shall have heat dissipation capability for the specified frequency of operation.

(c) Brakes shall have provision for adjustment where necessary to compensate for wear.

1-1.7.4 Trolley Wheels

When a trolley is required for use with a hoist, the type and size of support beam must be specified to ensure the trolley wheel contour is suitable for the contour of the beam.

1-1.7.5 Current Conductor Systems

A length of flexible power cord shall be provided unless otherwise specified. The user should contact hoist manufacturer for special arrangements to accommodate systems such as the following for trolley suspended hoists:

- (a) flexible cable
 (b) coiled cord

- (c) festooned cable
- (d) cable reel
- (e) rigid conductor

SECTION 1-1.8: OVERLOAD LIMITING DEVICE

An overload limiting device, when furnished, shall be designed to permit operation of the hoist within its rated load and to limit the amount of overload that can be lifted by a properly maintained hoist under normal operating conditions.

The overload limiting device may allow the lifting of an overload, but shall be designed to prevent the lifting of an overload that could cause damage to the hoist. This does not imply that any overload is to be intentionally applied to the hoist.

The overload limiting device is an emergency device and shall not be used to measure the maximum load to be lifted, and shall not be used to sense the overload imposed by a constrained load.

SECTION 1-1.9: PULL CORD CONTROL

Pull cord control, when furnished, shall consist of a self-centering, return-to-neutral controller or master switch for the motion of hoist or trolley. Two nonconducting pull cords with suitable handles, clearly marked for direction, shall be provided for operation of each controller or master switch. Unless otherwise specified, the standard pull cord control shall have a cord length that will locate the control handles approximately 4 ft to 5 ft (1.2 m to 1.5 m) above the lower limit of lift.

SECTION 1-1.10: TYPICAL HOIST AND TROLLEY INQUIRY DATA

See [Form 1-1.10-1](#) and [Table 1-1.6-1](#). An editable digital copy may be found at the following link: <http://go.asme.org/HSTForms>.

Form 1-1.10-1 Typical Hoist and Trolley Inquiry Data Form

HOIST

Quantity required _____

Rated capacity _____ tons (_____ kg)

Lift [Note (1)] _____ ft (_____ m)

Reach _____ ft (_____ m)

Headroom _____ in. (_____ mm)

Distance from operating floor to underside of beam or to point of support: _____ ft _____ in. (_____ mm)

Hoisting speed _____ ft/min (_____ m/min)

Type of control: ☐ Single-speed ☐ Two-speed
☐ Other _____

POWER SUPPLY

Voltage	Phase	Hertz	Control Voltage
☐ 200	3	60	☐ 24
☐ 230	3	60	☐ 115
☐ 460	3	60	☐ Other _____
☐ 575	3	60	
☐ 115	1	60	
☐ 230	1	60	
☐ _____	_____	_____ Other	

Performance Requirements (see Chapter 1-1 and Nonmandatory Appendix B):

Average lift _____ ft (_____ m)

Number of lifts/hr _____

Number of starts/hr _____

Shift hrs/day _____

Hoist service classification H _____

Furnish complete information regarding any abnormal operating conditions: _____

Type of Suspension:

☐ Lug ☐ Hook ☐ Clevis
☐ Plain trolley ☐ Hand chain operated trolley
☐ Motor operated trolley
☐ Other _____

TROLLEY (See Section 1.1-7)

Travel speed _____ ft/min (_____ m/min)

☐ Trolley brake required

Type of control

☐ Single-speed ☐ Two-speed ☐ Cushioned-start
☐ Other _____

Type and size of beam _____

Width of running flange _____ in. (_____ mm)

Minimum radius of beam curves

_____ ft _____ in. (_____ m)

Clearance dimensions of interlocks, switches, or beam splices (if used) _____

Current conductor system:

☐ Flexible cable or ☐ Festooned cable
☐ Cable reel ☐ Rigid conductor ☐ Coiled cord
☐ Other _____

Type of conductors (manufacturer) _____

Location of conductors on beam (use sketch if necessary)

OPTIONAL EQUIPMENT

NOTE: (1) Refer to manufacturer's catalog for standard lift that will meet the application requirement.

NONMANDATORY APPENDIX A

PERFORMANCE REQUIREMENTS FOR ELECTRIC CHAIN HOISTS USED IN MARINE AND OTHER APPLICATIONS AS REQUIRED BY THE U.S. DEPARTMENT OF DEFENSE (DoD)

A-1 GENERAL

A-1.1 Scope

This Appendix provides performance requirements beyond those cited in ASME HST-1-2017 for electric chain hoists for use in marine and other applications as required by the Department of Defense (DoD).

This Appendix, in conjunction with ASME HST-1-2017, is replacing the requirements of MIL-H-15317 for electric chain hoists.

A-1.2 Classification

Chain electric-powered hoists shall be of the following types, as specified [see [para. A-6.1\(b\)](#)]:

- (a) Type I — electric chain hoist, lug suspension, double-acting
- (b) Type II — electric chain hoist, lug suspension, single-acting
- (c) Type III — electric chain hoist, parallel or right angle geared, or plain trolley suspension
- (d) Type IV — electric chain hoist, two-wheel tandem
- (e) Type V — electric chain hoist, hook suspension
- (f) Type VI — electric chain hoist, powered trolley

A-1.3 Definitions

brittle material: material showing less than 10% elongation in gauge length for the tensile test specimen.

continuous operation: lifting and lowering through the full hoisting range a rated load at the specified lifting and lowering speeds.

excessive wear: wear that is sufficient to impair safe operation of the hoist. The following conditions define excessive wear:

- (a) increase in chain wheel pocket dimension in excess of 10%
- (b) increase in clearance tolerance between shaft and bearing in excess of 15%
- (c) life-lubricated bearings requiring lubrication
- (d) load-brake lining reduced in excess of 50% of useful life

(e) reduction of bar diameter of link chain in excess of 10%

(f) reduction of wall thickness for rollers and pins of roller chain in excess of 10%

(g) reduction in gear tooth thickness of reduction gear drive in excess of 10%

recovered materials: materials that have been collected or recovered from solid waste and reprocessed to become a source of raw materials, as opposed to virgin raw materials.

A-1.4 References to Other Codes and Standards

Refer to the following publications, copies of which may be obtained from the publisher as indicated. The latest edition shall be used.

AGMA 6010, Standard for Spur, Helical, Herringbone, and Bevel Enclosed Drives

AGMA 6034, Practice for Enclosed Cylindrical Worm Gear Speed Reducers and Gear Motors

Publisher: American Gear Manufacturers Association (AGMA), 1001 North Fairfax Street, Suite 500, Alexandria, VA 22314 (www.agma.org)

ASTM A48, Standard Specification for Gray Iron Castings (DoD adopted)

ASTM A143, Standard Practice for Safeguarding Against Embrittlement of Hot-Dip Galvanized Structural Steel Products and Procedure for Detecting Embrittlement (DoD adopted)

ASTM B26, Standard Specification for Aluminum Alloy Sand Castings (DoD adopted)

ASTM B633, Standard Specification for Electrodeposited Coatings of Zinc on Iron and Steel (DoD adopted)

Publisher: American Society for Testing and Materials (ASTM International), 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959 (www.astm.org)

IEEE Std. 45, Recommended Practice for Electric Installations on Shipboard

Publisher: The Institute of Electrical and Electronics Engineers (IEEE), 445 Hoes Lane, Piscataway, NJ 08854-4141 (www.ieee.org)

MIL-C-24643, Cables, Electric, Low Smoke, for Shipboard Use, General Specification for

MIL-DLT-917, Electric Power Equipment Basic Requirements

MIL-S-901, Shock Tests, H.I. (High Impact) Shipboard Machinery, Equipment, and Systems, Requirements for
 Publisher: Department of Defense (DoD), Standardization Documents Order Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094 (www.dsp.dla.mil/Specs-Standards)

UL 991, Tests for Safety-Related Controls Employing Solid-State Devices

Publisher: Underwriters Laboratories, Inc. (UL), Publication Stock, 333 Pfingsten Road, Northbrook, IL 60062-2096; Order Address: Comm 2000, 151 Eastern Avenue, Bensenville, IL 60106 (www.ul.com)

A-2 PERFORMANCE REQUIREMENTS

A-2.1 General

Performance requirements shall be in accordance with ASME HST-1-2017 and as specified in this Appendix.

A-2.2 Application

Metals susceptible to corrosion attack in a seawater environment shall be treated, plated, or painted to provide corrosion resistance. In order to minimize electrolytic corrosion between dissimilar metals in contact with each other, metal-to-metal contacts shall be limited to those metals which, when coupled, are in accordance with sea water corrosion of galvanic couples requirements of MIL-DLT-917. If a metal is coated or plated, the coating or plating metal rather than the base metal shall be considered in metal-to-metal contact between parts that depend upon coating or plating for corrosion resistance.

When specified [see [para. A-6.1\(c\)](#)], hooks shall be zinc plated. Zinc plating shall be in accordance with ASTM B633, Type I, Class Fe/Zn12. The hook throat safety device shall be constructed of noncorrosive material or treated for corrosion resistance.

When specified [see [para. A-6.1\(d\)](#)], the load chain shall be protected from corrosion by zinc plating in accordance with ASTM B633, Type II, Class Fe/Zn.

The safeguarding against and procedure for detecting embrittlement of zinc coating shall be in accordance with ASTM A143.

A-2.3 Characteristics

A-2.3.1 Weight and Dimensions. Maximum weight and envelope dimensions of hoists shall be specified if important to the application [see [para. A-6.1\(e\)](#)].

A-2.4 Emergency Manual Operation

When specified [see [para. A-6.1\(f\)](#)], hoist shall be equipped with a handwheel attached to an extension of the electric motor shaft for emergency manual operation of the hoist. It shall be possible to declutch the handwheel when it is not in use. An interlock shall be provided to prevent operation of the hoist electrically while the handwheel is engaged. A pull of not more than 1 lb per 200 lb (0.45 kg per 90.7 kg) of total hoist load shall be required to initiate movement.

A-2.4.1 Hand Chain. The handwheel described in [para. A-2.4](#) shall be operated by a removable chain, which when fitted, will have a drop of approximately 2 ft (0.61 m) less than the specified lift of the hoist.

A-2.5 Load Positioning Control

Hoist control systems shall vertically position a load to within $\pm \frac{1}{4}$ in. (± 6.4 mm).

A-2.6 Lubrication

Lubricants used shall be readily available and free of ozone depleting chemicals (ODC).

A-2.7 Painting

Paints and coatings shall be lead and chromate free.

A-2.8 Workmanship

The hoist shall withstand any operation specified herein without malfunction or component failure caused by faulty workmanship. Edges and surfaces exposed to operating and maintenance personnel shall be smooth and rounded so that a hazardous surface does not exist. See [Table A-2.8-1](#) for hook throat openings.

A-2.9 Interchangeability

In no case shall parts be physically interchangeable or reversible unless such parts are also interchangeable or reversible with regard to function, performance, and strength. Component parts for the same hoist types from the same manufacturer shall be interchangeable to the greatest extent possible.

Table A-2.8-1 Hook Throat Openings

Hoist Rated Load, lb	Minimum Hook Throat Opening, in.
1,000	0.75
2,000	0.906
3,000	1.0
4,000	1.125
5,000	1.125
6,000	1.5
7,500	1.375
10,000	1.625
11,000	2.0
13,000	2.063
15,000	2.063
17,000	2.063
20,000	2.25
25,000	2.25
30,000	2.75
40,000	3.0

A-3 MECHANICAL REQUIREMENTS

A-3.1 Design Stresses

Maximum combined stress in component parts shall not exceed 35% of the tensile yield strength of the material for hoist operation at rated capacity. Combined stresses in component parts shall not exceed 70% of its tensile yield strength, when the hoist is subjected to static or dynamic overload tests. For hoists requiring repair parts, all wear parts shall be readily accessible for replacement. For hoist operation, a pull of not more than 1 lb per 200 lb (0.45 kg per 90.7 kg) of total hoist load shall be exerted to initiate movement, and not more than 1 lb per 300 lb (0.45 kg per 136 kg) of total hoist load shall be required for manual operations of the trolley.

A-3.2 Load Hooks

Hook throat openings shall be in accordance with the dimensions shown in [Table A-2.8-1](#). The hook shall be clearly marked with manufacturer identification and allowable hook load or allowable hook load designator.

Positive means shall be provided to prevent the load hook from loosening due to rotation of the load. Load hooks shall be readily detachable from the load chain.

A-3.2.1 Range of Load Hooks. Load hooks for hoists Types I, II, III, V, and VI shall pick up a load with the hook anywhere within a radius of 3.5 ft (1.07 m) below the wheel, without jamming or jumping the pockets of the load wheel.

Load hooks for hoists Type IV (with the arrangement specified in [para. A-3.7.3](#) and with the trolley oscillating about the wire rope on which it operates) shall be capable of picking up a load from any point within a 19-in. (482.6-mm) radius, from an imaginary perpendicular, from the point of hoist suspension to a horizontal plane 7 ft (2.1 m) below this point (an angle of approximately 15 deg).

A-3.3 Construction

Rotating shafts shall be supported in antifriction bearings or bushings or both and shall be enclosed against entry of foreign matter. Rotating and sliding surfaces shall be lubricated. Hoists shall operate through a temperature range of -20°F to 103°F (-29°C to 39.4°C) for a minimum of 3,000 cycles without a failure. Gears shall be totally enclosed in a readily accessible casing that will permit examination, servicing, and cleaning. Positive means shall be provided to prevent any component working loose. Hoist parts shall be readily accessible for servicing and replacement as required.

A-3.3.1 Load Chain. The chain shall provide a safety factor of at least five for the rated load based on the ultimate strength of the material.

A-3.3.2 Gearing. Gears shall be manufactured in accordance with AGMA 6010 and AGMA 6034.

A-3.3.3 Overtravel Protection. The lift limiting device specified in paras. 16-1.2.13 and 16-1.2.14 of ASME B30.16 shall protect against upper and lower limits of travel. Type I hoists shall not have these devices (see [para. A-4.2.4](#)).

A-3.3.4 Overload Protection. Mechanical overload limiting devices shall not be permitted in naval applications unless the hoist is provided with a mechanical load brake and the mechanical overload limiting device is not installed on the load side of the hoist.

A-3.3.5 Load-Chain Container. When specified, the hoist shall be equipped with a container attached to the hoist for receiving the chain as it is reeved in by the chain wheel.

A-3.3.6 Trolley Track. Trolley tracks for Types III and IV hoists shall be I-beam of the size and radius specified.

A-3.4 Type I Electric Chain Hoist, Lug Suspension, Double-Acting

A-3.4.1 Double-Acting Feature. The double-acting feature shall be obtained by arranging a load chain having two free ends, to operate back and forth over a power-driven chain wheel. Either end of the chain, when fitted with a load hook, shall handle the load for which the hoist is rated. The hoist will not be required to handle load on both hooks simultaneously. Separation of the load chains, when hanging vertically,

shall be a maximum, to permit free passage of the empty and loaded hooks when traveling in the hoisting or lowering directions.

A-3.4.2 Control Stations. Controllers shall be operated by two pendant-type push-button stations, separately suspended from the hoist. Push-button stations shall be connected in series, thus making it necessary that corresponding push buttons be depressed simultaneously at each station, to move the load hooks in either direction. Length of one of the control cables shall be as specified [see para. A-6.1(g)]. The other cable shall be of a length equal to the lift of the hoist. Each push-button station shall be provided with indicating lights. These lights shall be arranged to indicate to the controls operator which push button has been depressed at any other station. Enclosure shall be spray tight.

A-3.5 Type II Electric Chain Hoist, Lug Suspension, Single-Acting

A-3.5.1 Control Stations. Control stations shall be pendant control type or bulkhead mounted as specified [see para. A-6.1(h)].

A-3.6 Type III Electric Chain Hoist, Parallel or Right Angle Geared or Plain Trolley Suspension

A-3.6.1 Trolleys. Trolleys shall be geared or plain, as specified [see para. A-6.1(i)].

A-3.6.1.1 Trolley Wheels. Trolley wheel spacing shall be suitable for use on an applicable standard I-beam flange size. Means shall be provided to prevent the trolley wheel flanges from riding up onto the supporting beam.

A-3.6.1.2 Trolley Equalizers. Means shall be provided for distributing the hoist load equally into trolley side frames.

A-3.6.1.3 Trolley Track Clamps. Quick acting track clamps shall be provided for locking fully loaded hoists to the track. Hand pull required to set or release the track clamps shall not exceed 80 lb (36.3 kg). Chain drop from beam shall be approximately 2 ft (0.61 m) less than the specified lift of the hoist.

A-3.6.2 Cable Reel. An automatic, clock spring-type cable takeup reel for ceiling mounting shall be furnished for the hoist motor power supply cable.

A-3.6.3 Control Stations. Control stations shall be pendant control type or bulkhead mounted as specified [see para. A-6.1(h)].

A-3.7 Type IV Electric Chain Hoist, Two-Wheel Tandem Trolley Suspension

A-3.7.1 Load-Lifting Medium. Close link, coil-type load chains shall be the load-lifting medium.

A-3.7.2 Hoist Trolley. Trolleys shall operate on high grade plow steel, constant tensioned wire rope, as specified [see para. A-6.1(j)]. The trolley shall not jump or fall from the wire rope under any condition. The trolley assembly shall be quickly removed from the rope for storage purposes. A hole shall be accessibly located at each end of the trolley structure to permit making a clevis connection, the clevis being located at the end of the ropes used to tow the trolley along the wire suspension. The trolley structure around the hole shall be reinforced so that pull on the clevis connection will not cause any permanent distortion.

A-3.7.3 Trolley Connection to Hoist. Trolleys shall be pin connected to the hoist with a degree of freedom to permit the hoist to swing forward or backward in the direction of trolley travel. Hoist swing angle shall be limited by stops on the trolley, to prevent the hoist from making contact with the trolley wire suspension.

A-3.7.4 Control Station. Motor controllers shall be operated from a pendant suspended, retractable, three element push-button station. The retractable feature shall be provided through use of a clock spring actuated cable reel, which shall be included as part of the motor control enclosure. Push-button enclosure shall be fitted with a handle to enable the hoist operator to conveniently hold the push-button station at proper operating height.

Enclosure shall be fitted with an eyebolt or other means for securing a reach rope, which will be used to haul the control station down to the operator. When three elements are required, the push buttons shall be legibly and permanently marked "HOIST," "LOWER," and "EMERGENCY RUN," to indicate hoist operation. The function of the "EMERGENCY RUN" push button shall be to bypass the thermal overload device.

A-3.8 Type V Electric Chain Hoist, Hook Suspension

A-3.8.1 Mounting. Mounting hooks shall have a spring-loaded-type safety gate resting against the tip of the hook. Safety gate shall be of sufficient strength to withstand a pull against the safety gate equal to the weight of the fully loaded hoist.

A-3.8.2 Control Stations. Control stations shall be pendant control type or bulkhead mounted as specified [see para. A-6.1(h)].