

### General

Fork correct dimensioning and conditions are essential for safe, cost-effective and damage-free pallet handling operations. Therefore, a regular fork inspection system should be put in place to ensure perfect operating conditions. Inspections, repairs or replacements shall be carried out as a pair.

### Inspections

Forks in use shall be inspected at intervals of 12 months or less depending on possible severe application, multi-shift operation and fork conditions. Regular inspections should be carried out by trained personnel. In case of detected damage, failures, deformations etc. forks shall be withdrawn from service and not be returned to service unless satisfactorily repaired or rerated.

### Cracks

Check visually inner heel and top and bottom hook areas to detect possible cracks. Apply non-destructive crack detection tests if necessary. If surface cracks are detected, forks should be withdrawn from service.

### Straightness

Check the straightness of the upper face of the blade and the front face of the shank. If deviation exceeds 0,5% of blade length or shank height, fork shall be withdrawn from service.

### Angle

Check the fork upper face of the blade to load face of the shank. If fork has a deviation greater than 3 degrees from original specifications, fork shall be withdrawn from service

### Height difference in fork tips

Check a pair of forks mounted on the fork carrier to detect difference in tip heights. If difference in tip heights exceeds 3% of the blade length, the pair of forks shall be withdrawn from service.

### Locking devices

Check the fork positioning locking to ensure their normal operation and wear conditions. If any fault is found, fork shall be withdrawn from service.

### Marking

Forks shall be marked with the nominal capacity and load center – according to ISO 2330. If marking is not clearly legible, fork shall be withdrawn from service.

### Hooks

Check the fork hooks for possible wear, damage and cracks. If clearance between fork and fork carrier is visually excessive, forks shall be withdrawn from service.

### Wear

Forks must be checked regularly to ensure the heel thickness is not less than 10% of the original thickness as per ISO 5057. If the fork thickness is less than 10%, the fork must be replaced or rerated.

### Repairs and tests

Repairs should be decided or carried out by authorized, expert personnel only, in accordance with recommendations of fork manufacturer. Do not repair surface cracks or wear by welding.

In case of repairs requiring fork re-setting, forks should be subjected to an appropriate heat-treatment.

Fork subjected to repairs different from repairs or replacements of the positioning lock and/or marking, can only return to service after having passed a yield test as described in ISO 2330.