



GENERAL NOTES:

1. WELDING PER AWS D1.1.
2. ENSURE BASE STRUCTURE IS CAPABLE OF HANDLING FORCES APPLIED BY PADEYE.
3. ORIENT PADEYE IN DIRECTION OF SLING TO MINIMIZE SIDE LOAD.
4. PADEYE TO BE WELDED USING A MIN. 70 KSI YIELD ELECTRODE.
5. PADEYE MATERIAL IS GROUP II DESIGNATION AS PER AWS D1.1.
6. FINAL LOAD TEST SHALL BE PERFORMED TO 2.0 X RATED CAPACITY AFTER WELDUP IS COMPLETE.
7. 100% MAGNETIC PARTICLE INSPECTION FOR FILLET WELDS AND 100% ULTRASONIC WELD INSPECTION FOR PENETRATION WELDS TO BE COMPLETED AFTER LOAD TEST IN ACCORDANCE WITH ASME SPECIFICATIONS.
8. BREAK ALL EDGES AND CORNERS UNLESS OTHERWISE SPECIFIED, CHAMFER EDGES APPROX. 1/8".
9. THIS PADEYE MEETS OR EXCEEDS ANSI/ASME B30.20 BELOW THE HOOK LIFTING DEVICES REQUIREMENTS.
10. COATING SYSTEM SHALL BE COLD GALVANIZED.
11. DESIGN TEMP. -20 DEG F TO 150 DEG F.
12. REQUEST ALL MTR'S W/ CHEMISTRY, MECHANICAL & TESTING REPORTS.

TOLERANCE UNLESS NOTED
ALL FRACTIONAL $\pm 1/8"$
.0 ± 0.1
.00 ± 0.02
.000 ± 0.005

ANGULAR TOLERANCE
UNLESS NOTED
ALL ANGULAR DIM. $\pm 1^{\circ}$

UNLESS NOTED
ALL MACHINED
SURFACES PER
ASME/ANSI B46.1
125 μ in

PROJECT: REF # XXXX

BISHOP
LIFTING

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DATA CONTAINED WITHIN IS TO BE USED FOR INTENDED
PURPOSES ONLY. NO DUPLICATION OR DISCLOSURE ALLOWED
WITHOUT PRIOR WRITTEN CONSENT FROM BISHOP LIFTING
PRODUCTS INC. ALL DUPLICATES SHALL BE RETURNED OR
DESTROYED IMMEDIATELY UPON REQUEST!

CHECK OFF			TITLE		
ACTION	APP.	DATE	BLP STANDARD PADEYE 25 METRIC TONS		
DESIGN	HP	8-16-05	THIRD ANGLE PROJECTION	DWG NO.	REV.
DRAWN	AQ	4-3-23		UPE-02500	3
ENG.	HP	8-16-05			
CHK.	CH	4-3-23	B SIZE	SCALE:NTS	EST. WT. 26.8 lbm
					SHEET 1 OF 1

DRAWING APPROVAL
BY _____
DATE _____
____ AS DRAWN ____ AS NOTED