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WATER SUPPLIES DEPARTMENT

STANDARD SPECIFICATION EM-01-01

ELECTRICALLY OPERATED OVERHEAD CRANES

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ELECTRICALLY OPERATED OVERHEAD CRANES

1. GENERAL DESIGN AND INSTALLATION STANDARDS

1.1 Water Supplies Department Standard Specifications

The following Standard Specifications shall be complied with:

EM-00-01	Inspection, Testing and Reporting
M-00-03	Supply of Mechanical Plant
E-00-01	Electrical Equipment - General
E-90-01	Drawing for Electrical and Instrumentation Equipment
E-90-02	Manual for Electrical and Instrumentation Equipment

In case of discrepancy in technical requirements, this Specification shall take precedence of the above WSD Standard Specifications.

1.2 Standards

The design and installation of the crane shall comply with the latest version of relevant International Electrotechnical Commission (IEC), British Standards (BS), Codes of Practice or other equivalent standards issued by internationally recognized engineering institutions or organizations.

The following standards, in particular, shall apply where appropriate:

BS 88	Cartridge fuses for voltages up to and including 1000V a.c. and 1500V d.c.
BS 466	Specification for power driven overhead travelling cranes, semi-goliath and goliath cranes for general use
BS 2573	Rules for the design of cranes
BS 4800	Schedule of paint colours for building purposes

BS 4999	General requirements for rotating electrical machines
BS 5000	Rotating electrical machines of particular types or for particular applications
BS 5395-3	Code of practice for the design of industrial type stairs, permanent ladders and walkways
BS 7262	Specification for automatic safe load indicators
BS EN 60898	Specification for circuit-breakers for overcurrent protection for household and similar installations
BS EN 60947-2	Specification for low-voltage switchgear and controlgear
BS 7671	Requirements for electrical installations
IEC 60034-1	Rotating electrical machines – Rating and performance

The IEC, BS and other standards referred to in this Specification shall also mean the equivalent standards issued by internationally recognized engineering institutions or organizations. Manufacturers offering equipment complying with other standards shall provide duplicate copies of such standards in English, together with full details of any deviations from the standards referred to in this Specification.

2. CRANE - MECHANICAL DESIGN

2.1 General

The crane shall be designed and constructed in accordance with BS 466 and BS 2573.

For the crane as a whole and the mechanism, the group, state of loading and class of utilisation classifications shall be defined according to BS 466 and BS 2573.

Unless otherwise specified in the Particular Specification, the following table shall apply:

Classification of Cranes and Mechanisms as per BS 2573

Location/ Application	Class of Utilisation		State of Loading		Group Classification	
	Crane as a Whole	Mechanism	Crane as a Whole	Mechanism	Crane as a Whole	Mechanism
Pumping Station-Pu mphall / Press house	U3	T3	Q3	L3	A4	M4
Workshop	U4	T4	Q3	L3	A5	M5
Chemical Handling	U5	T5	Q3	L3	A6	M6

The crane shall be manufactured to suit the building structure as stated in the Particular Specification. The crane shall be of a double-girder construction with the crab travelling on the girder rails, unless otherwise specified.

The hoist shall be equipped with a brake release mechanism to allow manual lowering of the load in the event of power failure. Facilities for converting downshop travel from electrically operated to manually operated on power failure shall also be provided. Conversion to manual operation shall be activated by a handwheel or lever.

The winding diameter of the hoist drum shall be not less than 20 times the nominal diameter of the wire rope. The winding drum of the hoist shall have deeply machined cable grooves to provide a true vertical lift.

The lifting hook must carry a self-activating safety latch. The factor of safety of the wire rope, which is determined by dividing the product of the minimum breaking strength of the rope and the number of falls by the safe working load (SWL) for the crane, shall be not less than 5.

A safe working platform shall be provided to enable access to the front and to both sides of electrical control cubicles, motors, brakes, limit switches and other areas where maintenance or inspection will be required. Steel plating shall be provided between the access point and the equipment over the whole of the exposed area. The steel plating shall not be less than 6.5 mm thick and not less than 450 mm wide. The platform shall be securely supported and fenced with tubular steel guard rails 1,000 mm high and toe boards provided along the outer edges of the platform. The design of the platform and guard railings shall be in accordance with BS 5395-3. Resilient

shock absorbing buffers at appropriate locations shall be provided.

The certified SWL shall be painted in a conspicuous manner on the crane girder so as to be visible to persons at the station floor. Lettering shall be painted both in Chinese and English.

The supply of the crane shall also include the gantry rails and anchors for fixing to the reinforced concrete beams. The rails shall be supplied complete with end stops, grade 316 stainless steel holding down bolts, tapered washers, etc. and shall be suitable for connection to the station earth.

For application of crane in chlorine store, retaining brackets shall be designed and provided at the end carriages to enhance the prevention of the crane from coming off its rails.

Access to the crane shall be by a galvanized steel ladder to BS 5395-3, with necessary safety hoops to be supplied with the crane for installation at one end of the building.

2.2 Design Calculation

Calculations in accordance with BS 2573 verifying the stress and structural compatibility of the crane assembly shall be checked and certified by a qualified independent checking engineer. The certified calculations shall be submitted to the purchaser prior to the commencement of manufacture.

The design calculations shall verify the following:

(a) Vertical Deflection

The configuration of the crane bridge shall be designed so that the vertical deflection due to the weight of the crane assembly, the SWL and other horizontal loads due to crane motions shall conform to Clause 7 of BS 466.

(b) Stress in Structures

For the purpose of stress calculations, the impact factor and duty factor as mentioned in BS 2573-1 shall be taken as 1.3 and 0.95 respectively. For the assessment of the horizontal loads which may arise from the crane motions, the proposed hoisting and crane travel speeds and the crane configuration shall be taken into account.

2.3 Crane Operational Speeds

Unless otherwise specified in the Particular Specification, the powered operating speeds of the crane shall be within the following ranges:

Hoist Speed, high	4 m/minute $\pm 30\%$
Hoist Speed, low	0.63 m/minute $\pm 50\%$
Cross Travel (Traverse)	6.3 m/minute $\pm 30\%$
Downshop Travel (Long Travel), high	16 m/minute $\pm 30\%$
Downshop Travel (Long Travel), low	5 m/minute $\pm 30\%$

2.4 Finishing and Painting

All surfaces of the structural steel work shall be thoroughly cleaned, dried, free from loose scale and blemishes, grit oil and grease before the application of first coat of primer.

Painting shall be applied to all surfaces to give the dry film thickness (DFT) in accordance with the following painting schedule:

<u>Painting System</u>	<u>DFT per Coat</u>
One coat of two-pack chemical-resistant primer	70 microns
One coat of two-pack chemical-resistant undercoat	100 microns
Two coats of two-pack chemical-resistant top coat	100 microns

The total DFT of the protection system shall not be less than 370 microns and the final colour shall be to BS 4800 08E51 safety yellow. The coating system shall be applied by airless spray or in accordance with the paint manufacturer's instructions and recommendations. Brush or roller application shall be limited to the touch-up of small areas. Manufacturer's literatures for the coating system shall be submitted to the Engineer prior to application of the paint.

3 CRANE - ELECTRICAL DESIGN

3.1 General

The electricity supply to the crane will be 380V 3-phase 50Hz with the neutral point solidly earthed. The electrical design shall be based on BS 466. The normal variation limits will be $\pm 6\%$ for supply voltage and $\pm 2\%$ for supply frequency.

The crane shall be electrically operated and motorised in all directions of travel. Crane control shall be by means of a single pendant control unit suspended from the crane bridge. The control pendant shall be free to move along the crane bridge independent of the movement of the crab suitable for operation from floor level.

Electrical equipment for the control of the crane shall be housed in control cubicles mounted on the crane bridge and the crab as appropriate.

3.2 Power Supply

Power shall be supplied to the crane through a modular system of copper bar conductors enclosed in an earthed galvanised steel track or a PVC insulating shroud. The conductors shall have a nominal current rating not less than 63A. All associated fixing accessories shall include mounting brackets, hangers, fastening bolts and nuts etc.

A 63A TP&N on-load isolator switch, lockable in the 'off' position, shall be provided for controlling the power supply to the conductors. This isolator switch is to be located close to the access ladder at a level between 900mm to 1500mm above finished floor level.

The current collectors shall be of the sliding contact type with replaceable contact shoes. The contact head shall be shrouded to prevent accidental contact and mounted on self-adjusting spring loaded arms to maintain constant contact with the conductor bars. The capacity of the contact head shall be compatible with the conductor.

The supply system shall have four conductors - three for the three-phase supply and one for the earth. Where a single phase supply is also required for the crane equipment, a fifth conductor shall be provided for the neutral connection.

The electrical connections between the crane platform and the cross travel hoist assembly shall be through PVC-insulated flat cables on rail-runners. Cables which

require no movement shall be enclosed, positioned or constructed to protect against mechanical damages. All the cables and associated fixing accessories from the on-load isolator switch to the motors, limit switches and control cubicles shall be furnished with the crane.

3.3 Control of Travel

Each movement of the crane shall be operated by a separate motor. All movements shall start smoothly and inching in any direction shall be possible. If more than one driving motor is used for motion in any direction, the motors shall be synchronised.

Limit switches shall be provided for limiting long (down-shop) travel, cross travel, and vertical hook travel in both directions. Limit switches shall reset automatically on reversal of motion. The switch endurance test severity shall be one million operation at 120 on-load operating cycles per hour.

Control of travel shall be by means of push buttons in the pendant control unit. Constant pressure on the corresponding push button shall be required for the entire duration of travel in any direction, i.e. latching contacts shall not be provided in the motor starter circuits to bridge the control push buttons.

An emergency stop push button to interrupt the control supply to all motor circuits shall be provided at the pendant control unit. After the emergency stop push button is pressed, the pendant control unit shall only be operational after the pressing of a 'Reset' push button.

3.4 Pendant Control Unit

The pendant control unit shall be ergonomically designed for easy operation with one hand and its enclosure shall be made of die-cast metal or impact resistant plastic with a degree of protection of IP65. Push buttons shall be provided for the following functions:

Main hoist	:	Fast Raise, Slow Raise, Fast Lower, Slow Lower
Cross Travel	:	Left, Right
Long Travel	:	Fast Forward, Fast Reverse, Slow Forward, Slow Reverse
Control	:	Emergency Stop, Reset

The push button contacts for opposite motions shall be electrically interlocked.

Electricity supply to the pendant control unit shall not exceed 50V 50 Hz a.c..

The pendant control unit shall be suspended from a 316 stainless steel wire to prevent any strain on the supply/control cable. If this straining wire is integral with the cable, the wire shall be terminated in a crimped-on ring terminal rigidly fixed at both ends such that the weight of the pendant is not carried by the conductors of the cable at any time.

Labels shall be of laminated plastic with white engraved legends on black surface or black engraved legends on white surface.

3.5 Electrical Control Cubicles

The control cubicles shall be of 316 stainless steel sheet of minimum thickness 1.5 mm with a degree of protection of IP54.

The control cubicles shall be located in such a way that a front clearance space of not less than 450 mm shall be provided.

The arrangement of the cubicle components shall be such that all normal maintenance work can be carried out through a hinged and lockable front access door. The door shall be fitted with gaskets. Components shall be of robust construction to withstand the effects of intense vibration.

The power supply for the control cubicles shall be protected by an earth leakage moulded case circuit-breaker of sensitivity 300mA and of service breaking capacity not less than 6 kA to BS EN 60947-2.

The control voltage shall not exceed 50V 50 Hz a.c., which shall be supplied from the secondary winding of an isolating transformer.

The control cubicle shall be fitted with an anti-condensation heater and an adjustable thermostat.

A control push-button, lockable with a key, shall be provided on the cover of the electrical control cubicle to preclude operation by the pendant control unit while retaining the main power supply to the control cubicle for circuit checking. A lockable isolator shall also be provided for the isolation of the main power supply.

Each component within the control cubicle shall be identified with an engraved label adjacent to the component. Labels at cubicle interior shall be fixed by screws or adhesive. Labels on the cubicle exterior shall be fixed with chromium plated screws or fixed by manufacturers standard method for components with integral labels.

3.6 Brakes

3.6.1 Brakes - General

Automatic spring held brakes shall be provided for all drives. Release of brakes shall be by electromagnetic means and designed for fail-safe operation.

The brakes shall be applied smoothly and automatically without snatching when the power supply to the driving motor is cut off and the braking torque shall be at least 200% of the full load torque of the motor. Where more than one motor is used to control motion in any direction, each motor shall have an individual brake with its release coil energised from the supply to that motor.

Brakes with more than one shoe shall be self-centering such that wear of the brake lining is evenly distributed between shoes.

Long travel (down-shop) and cross travel brakes may either be integral with each driving motor or be separate drum brakes. Hoist brake shall incorporate mechanical or hydraulic manual release facilities. Motor with integral brakes shall incorporate manual release devices for use during maintenance.

3.6.2 Release Coils

Electromagnetic release coils shall be of continuous rating and shall be suitable for the specified power supply.

Coils shall be vacuum impregnated with a non-hygroscopic insulating varnish or shall be epoxy resin encapsulated.

It shall be possible to replace a defective coil without dismantling the brake mechanism.

4. COMPONENT SPECIFICATIONS

4.1 Motors

Electric motors shall be of high efficiency type squirrel-cage induction type complying with BS 4999 & BS 5000 as appropriate. The motors shall operate at the electricity supply of 380V $\pm 6\%$ 3-phase 50 Hz $\pm 2\%$.

Motor enclosures shall have a degree of protection of IP54.

Motor windings shall be of Class B or Class F insulation design with Class B maximum temperature rise limit at rated operating conditions.

Motors shall be rated for intermittent duty type S3 to IEC 60034-1, with a cyclic duration factor of not less than 40% at rated output and a starting class not less than that of the mechanism group classification specified for the crane.

Motor bearings shall be of standard ball or roller type with a minimum working life of 40,000 hours. Special bearings and Imperial bearings will not be accepted.

4.2 Motor Starters

Starters shall be mounted in the electrical control cubicles.

Reversing contactors shall have mechanical and electrical interlocks.

The utilization category for contactors shall be AC4. The electrical durability of the contactors shall be not less than 1 million operating cycles at an intermittent class not lower than 300 operating cycles per hour and 40% on-load factor.

Protection against thermal overload, single-phasing and earth fault shall be provided for each motor.

4.3 Cables

Minimum cross-sectional areas of conductors shall be 2.5 mm² copper for power cables and 1.5 mm² copper for control cables. All cables shall be PVC-insulated.

4.4 Electrical Auxiliaries

Miniature circuit-breakers shall comply with BS EN 60898 and shall have a breaking capacity not less than 6 kA.

Fuse switchgear and isolators shall comply with BS EN 60947-3.

Fuses and fuse holders for short circuit protection shall be high breaking capacity (HBC) fuses to BS 88.

Indicating lamp units shall have a degree of protection of IP54. Push button units and limit switches shall have a degree of protection of IP65.

4.5 Earthing Requirement

Provisions of M10 stud terminals shall be made for the connection of earthing conductors to the rail, girder and hoist units. Each flat cable shall have a circuit protective conductor of the same material and size as the current carrying conductors.

4.6 Automatic Safe Load Indicator (ASLI)

4.6.1 General

The ASLI shall comply with the requirements of the Factories and Industrial Undertakings (Lifting Appliances and Lifting Gear) Regulations (CAP. 59 sub. leg.J) and BS 7262.

The ASLI shall function automatically once the crane is energized. The operation of the ASLI shall be independent of the motion or combination of motions of the crane.

4.6.2 Design and Construction

The ASLI shall be sufficiently robust in construction and protected to prevent damage from shock vibration and the general rigours of crane duties including erection, rope changing, use and dismantling or maintenance on the crane.

The settings and functioning of the ASLI shall not be affected by mechanical shocks and vibration transmitted by the crane assembly during transportation and operation. The design and construction of the ASLI should also minimize the risk of accidental and inaccurate changing of any manual setting device.

The load transducers of the ASLI shall be of tension load cell type unless otherwise specified. The operation of the load transducers, associated conductors and connections shall be continuously monitored for out-of-range condition. Should a fault occur, the ASLI shall default to a safe condition.

The ASLI shall be designed and constructed to operate in an ambient temperature between 0°C and 60°C and relatively humidity up to 100%. It shall be protected against condensation, frost, dirt, dust and other adverse condition.

The installed ASLI shall enable overload testing of the crane without any disconnection or adjustment.

The enclosure of ASLI shall be fabricated to the same requirements of the electrical control cubicles.

4.6.3 Warnings and Indications

The ASLI shall be set to give warnings and indications of loads on the crane for all permitted crane motions, which have reached the pre-determined load settings as follows:

(a) Warning of Approach to Safe Working Load (SWL)

The ASLI shall give a clear and continuous warning when the load of the crane approaches 95% with a tolerance limit of $\pm 2\%$ of the SWL.

(b) Warning of Overload

The ASLI shall give a clear and continuous warning of overload when the load of the crane exceeds 100% but not more than 105% of the SWL.

(c) Form of Warnings

The warning of approach to SWL and warning of overload shall be given in the following fashions:

<u>Function</u>	<u>Audible Warning</u>	<u>Visual Warning</u>
Approach to SWL	Intermittent Buzzer	Flashing Amber Lamp
Overload	Continuous Buzzer	Flashing Red Lamp

The warning signals shall continue to function until the load falls below the respective value at which it is initiated. The audible warnings for approaching SWL and overload shall be clearly distinguishable from each other and other environmental sound such as fire alarms which may exist within the plant room where the crane is to be installed. Manual-test push buttons or self-test function activated by switching on the power supply of ASLI for the audible and visual warnings shall be provided.

The audible warning for approaching SWL and overload shall be clearly audible by persons at 10 m away from the load being lifted under all conditions.

5. **SPARES**

The following spares, where applicable, shall be supplied with the equipment:

- 1 - Brake release coil for each type of driving motor
- 100% - HBC fuses
- 1 - Contactor for each type and size used
- 1 set - Crane power supply collector contact shoes
- 1 - Crane power supply collector contact head
- 1 - Timer for each type and range used
- 1 - Printed circuit board for each type used
- 1 - Limit switch for each type used
- 1 set - Brake shoes and linings for each driving motor

6. **WORKS TESTS, INSPECTION AND SITE TESTS**

6.1 **Works Tests**

All electrical and mechanical equipment shall be tested in accordance with the appropriate International Standards at either the crane maker's or Contractor's works.

In addition, all plant supplied will be subject to inspection and tests duly arranged and carried out by the crane maker or Contractor. All the inspection and tests shall be witnessed by an Independent Inspection Body (IIB). The requirements associated with the inspection, testing of the crane and associated equipment and reporting thereon shall comply with the requirements stipulated in Water Supplies Department (WSD) Standard Specification EM-00-01.

All the costs associated with the appointment of IIB and the provision of the necessary equipment for the inspection and witnessed tests shall be borne by the Contractor.

The works inspection and tests shall include, but are not limited to, the following:

- (a) Dimensional verification against approved drawings of the equipment to be supplied;
- (b) Verification of the correct use of materials;
- (c) Verification of the correct quantities of components to be supplied, which shall include integral, loose items and spares;
- (d) Correct painting process (where applicable) and the measurement of DFT of the painting system;

- (e) Verification of the correct functioning of the equipment to be supplied; temporary wiring up of the control cubicles, hoisting unit, safety devices including limit switches and the ASLI shall be required.

6.2 Test on Purchaser's Premises

Upon completion of the installation of the crane at the Purchaser's premises, the Contractor shall arrange to carry out the functional, vertical deflection and overload tests of the crane.

The functional tests shall demonstrate the correct operation of the crane including lifting, lowering of the hook, travelling of the crane, functioning of the hook and crane travel limit switches and the ASLI.

The Contractor shall carry out a vertical deflection and a overload test of the crane installed. The tests shall fully conform to the current statutory requirements as specified in the Factories and Industrial Undertakings (Lifting Appliances and Lifting Gear) Regulations (CAP. 59 sub. leg.J). Test certificate shall be issued by an approved IIB (who can be a different person for carrying out witnessed test at manufacturer's works) or crane surveyor and delivered to the Purchaser within the specified period after the test.

The requirements associated with the inspection, testing of the crane and associated equipment at the Purchaser's premises and reporting thereon shall comply with the requirements stipulated in WSD Standard Specification EM-00-01.

The IIB or crane surveyor shall be appointed and nominated by the Contractor. All the costs associated with the appointment of IIB or crane surveyor and the provision of necessary equipment for the tests and the issue of test certificate shall be borne by the Contractor.