



User manual

DoTEXTreme

- Textile lifting sling with eyes on both sides
- Textile grommet with eyes on both sides
- Textile double grommet with eyes on both sides
- Textile grommet
- Textile double grommet



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1 Foreword

1.1 About this guide

These operating instructions are part of the scope of delivery.

Always keep the operating instructions within reach.

Read the operating instructions carefully before first use and observe the information when using Dolezych products.

Observe the safety instructions in the operating manual to avoid personal injury and damage to property.

1.2 Symbols in the instructions

Warnings against personal injury



This safety warning symbol and the associated signal word indicate important information for avoiding hazards that can lead to injuries or even death. The meaning of this signal word is explained in more detail below.

DANGER!	Extremely dangerous situation. Failure to observe the safety instruction will result in death or serious injury.
WARNING!	Dangerous situation. Failure to observe the safety instruction may result in death or serious injury.
CAUTION!	Dangerous situation. Failure to observe the safety instruction may result in minor injuries.

Property damage warnings



This symbol indicates important instructions to avoid damage to the product or other objects.

Other information



This symbol indicates other helpful information. This information is additionally marked with a frame.

1.3 Limitation of liability

Dolezych GmbH & Co KG accepts no liability for damage caused by:

- Non-compliance with these operating instructions
- unintended use
- Use of the product by untrained personnel
- Use of non-approved accessories / fitting parts
- unauthorised modifications

1.4 Special regulations and guidelines

For the safe handling of the product, special reference is made to the following applicable regulations and technical rules:

- DIN EN 1492-4 – Lifting slings for general service made from natural and man-made fibre ropes
- DIN EN ISO 10325 – High modulus polyethylene – 8-strand braided ropes, 12-strand braided ropes and covered ropes
- ISO 18264 – Textile slings – Lifting slings for general purpose lifting operations made from fibre ropes – High modulus polyethylene (HMPE)
- DGUV Regulation 109-006 – Use of sling fibre ropes
- DGUV Regulation 109-017 – Operation of work equipment
- DGUV Information 209-013 – Lifting devices
- DGUV Information 209-061 – Use of lifting slings and round slings made of man-made fibres
- Machinery Directive 2006/42/EC

If necessary, special regulations beyond this must be observed, e.g., for the transport of dangerous goods.

2 Safety instructions

2.1 Intended use

The product is used for slinging and lifting loads and may:

- only be used for loads that are suitable for this purpose due to their nature.
- may only be used by authorised and instructed persons.
- only be used in compliance with the applicable regulations.

It is expressly forbidden to:

- modify the product.
- repair the product by non-specialist personnel.
- lengthen the product by knotting or interlocking it with other lifting devices.

2.2 General safety instructions

When lifting loads with slings, the persons under or next to the load are particularly at risk. There are residual dangers when handling slings. These are in particular:

- insufficiently secure connection from the sling to the load,
- swinging load when lifting and
- falling loads.

For safe handling of the product, the following instructions must be observed.

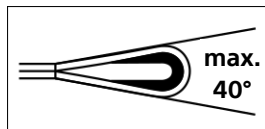
- Observe the working load limit (WLL)! The product must never be loaded beyond the specified load capacity.
- In the case of multi-strand hangers, the maximum total load-bearing capacity of the strands used must not be exceeded.
- Observe temperature ranges.
- Avoid contact with chemicals.
- Do not load the product when it is knotted.
- Do not load the product if it is twisted.

- For sharp-edged loads, edge protectors must be used.



A sharp edge is already present if the edge radius of the load is smaller than the thickness of the product (see also p. 15).

- Splices must not be placed on edges of the load, into crane hooks or into the twist of the choker.
- Do not shorten sling fibre ropes by looping around the load hook.
- Ropes that are laid several times around the load must not cross each other.
- Sling fibre ropes must be attached in such a way that the opening angle of the end loops at the joints does not exceed 40°.
- Avoid tearing or jerky loads.
- Do not place loads on the product if this may damage the product.
- Never drag the load over the product.
- Do not pull the product out from under the load when the load is still on.
- Do not drag the product over floors or rough surfaces.
- Never leave the load in the sling if damage can result.
- Protect the product against flying sparks during cutting, grinding or welding work.
- Fittings must be freely movable when assembled. Suspension links must be freely movable on the crane hook.
- If more than one sling is used to lift the load, they must be made of the same material (due to e.g., the same elongation values).



2.3 Safety instructions for multi-leg suspensions

In addition to the general safety instructions, the following specifications apply to multi-leg suspensions:

- If not all legs are used in a load-bearing manner, the unused legs must be hung up in the suspension head. This prevents the legs from being damaged.
- If not all legs are used in a load-bearing manner, the load-bearing capacity is reduced to the load-bearing capacity of the legs used.

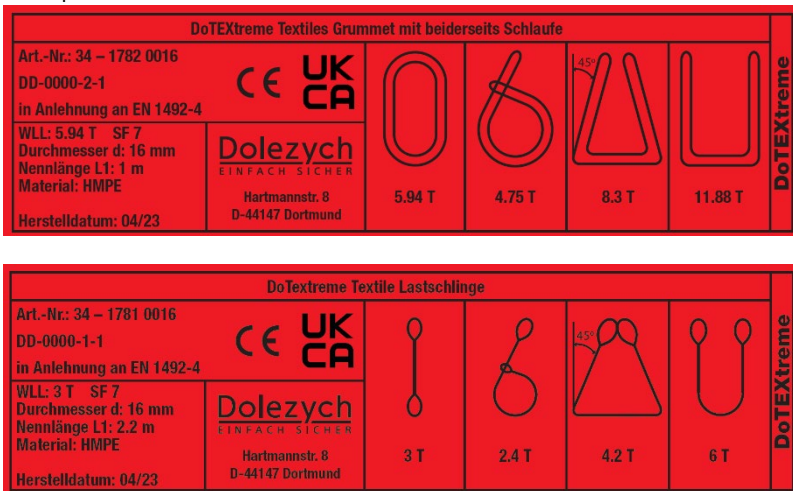
3 Product description

Do *TEXtreme* load slings are made from 12-strand braided fibre ropes, which are made from high molecular weight polyethylene (HMPE) and individually coated through a 360° process.

3.1 Product identification

The label prescribed by DIN EN 1492-4 is sewn into all Dolezych Do *TEXtreme* load slings. In accordance with ISO 18264, the label is coloured signal red. The information on the label is:

- Article number
- Indication of the valid standards
- CE mark
- UKCA sign
- WLL = Working Load Limit = Load capacity in the stop type direct, specified in tonnes
- Safety factor (SF)
- Nominal diameter d: specified diameter of the rope
- Nominal length in metres (L1)
- Material
- Date of manufacture
- Manufacturer's mark DD
- Traceability code
- Load capacities with different types of lifting



*Fig. 1: Label faces for textile grommets (top)
and lifting slings or grommets with eyes on both sides (bottom)*



Due to splicing as well as the additional HMPE protection on the eyes, the stated diameter d may differ from the actual outer diameter.

3.2 Markings on the product

The markings on the back of the label attached to the product have the following meaning.









	Carry out visual inspection before use
	Read user manual
	Inspection according to checklist
	WLL = Working Load Limit Never exceed the working load limit
	Adhere to specified operating temperatures
	Do not use if there are cuts or knots.
	Observe the "sharp edge rule"
	Beware of chemical contamination. Consult manufacturer



Fig. 2: Back of label

3.3 Application-oriented product selection

The following points must be observed for the selection of a suitable sling for the application:

- Load mass
- Position of the centre of gravity of the load
- Position of the anchor points
- Intended lifting procedure
- Diameter of the lifting points

The sling must be selected so that it can take the load in such a way that it does not make any unwanted movements.

Criteria for the correct choice of product are:

- the type of product,
- the length of the product and
- the method of attachment to the load.

The sling must be selected so that it is suitable for the environmental conditions at the place of use. Special environmental conditions can negatively affect the performance and stability of the product, so that failure of the product is possible.

Special environmental conditions are:

- Influence of chemical substances, especially acids, alkalis and solvents
- Extreme temperatures
- Radiation

Chemical resistance

The material from which the product is made has a selective resistance to chemicals. The material-dependent resistances are described below.

Material	Resistance at room temperature
High molecular weight polyethylene (HMPE)	Very resistant to acids. Very resistant to alkalis (lyes).



NOTE! Harmless alkaline or acid solutions can become so concentrated through evaporation that they can cause damage to the product. This damage can significantly reduce the load-bearing capacity of the product.

If the product has been contaminated, then:

- Take contaminated product out of service immediately.
- Clean contaminated product with cold water.
- Allow the product to air dry afterwards.
- Do not accelerate drying artificially (e.g., by heating).
- Have the product inspected by a competent person before using it again.



If it is highly likely that the product will come into contact with chemicals during use, additional information should be obtained from the Dolezych Service Team before use.

Operating temperatures

Depending on the material the sling is made of it may only be used and stored in the following temperature ranges.

Material	Suitable temperature range
High molecular weight polyethylene (HMPE)	-40 °C to +70 °C



NOTE! If moisture is present, ice can form at low temperatures. Ice crystals in the fabric can damage it. This damage can also occur invisibly inside the product. The damage can reduce the load-bearing capacity. Ice can reduce the flexibility of the product and make it unusable.

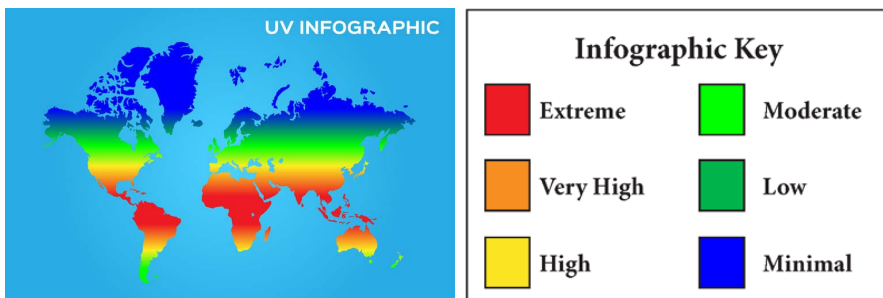
Only use the product when it is completely dry!

Radiation

The product is made of man-made fibres whose properties deteriorate when exposed to ultraviolet light. Ultraviolet radiation from sunlight can cause brittleness and thus weakening of the outer rope strands of polyolefin fibres.

Do *TEXtreme* products have UV stabilizers within the yarn itself. This UV protection is in the yarn itself and in the coating applied to each individual yarn. Exposure to direct sunlight or other sources of ultraviolet radiation should be limited to necessary quantities. The product must always be stored away from such sources of UV radiation.

For more information on UV resistance and possible damage, see p. 29.



4 Testing and maintenance

4.1 Initial commissioning

Before putting the sling into operation for the first time, make sure that:

- identification and dimensions of the product correspond to the specifications,
- the certificate issued by the manufacturer is present,
- the marking and working load limit (WLL) affixed to the sling correspond to the information in the certificate.

If one of these criteria is not met, the product must not be used.

4.2 Before each use

Before any further use of the sling, make sure that:

- the marking on the product is present and legible,
- the product has no damage or defects,
- the product is not ready for discarding (see page 13).

If one of these criteria is not met, the product must not be used.

4.3 Regular testing

The product must be inspected at intervals of no more than one year. The inspection must be carried out by a competent person and must be documented.



Dolezych GmbH & Co KG offers a testing service for slings.

The slings can be tested either in the test centre in Dortmund, in the company or directly at the place of use.

Depending on the conditions of use of the product, tests may be required at intervals shorter than one year.

This applies, for example, to:

- particularly frequent use,
- increased wear,
- Corrosion or heat exposure or
- if, based on operating experience, an increased risk of damage is to be expected.



Carry out regular visual inspections during the period of use. This is the only way to detect damage at an early stage that affects the safe use of the product.

Must be audited:

- Fittings
- Connecting elements
- Labelling

The product must be taken out of service immediately for examination by a competent person if:

- there are doubts as to the suitability for use,
- the required marking is missing (label or tag),
- damage or special incidents have occurred that may affect the load-bearing capacity.

Examples of faults and damage that affect durable and safe use are:

- Scuff marks on the surface,
- Longitudinal or cross cuts,
- chemical influence,
- Damage due to heat or friction,
- Damage to or deformation of fitting parts,
- Damage to abrasion or edge protection hoses.

4.4 Discarding criteria

The product must not be further used if one or more of the following discarding criteria are met:

- Missing or illegible marking
- Breakage of one or more strands
- Yarn breaks in large numbers, e.g., more than 10 % of the total yarn count in the most damaged cross-section.
- Significant reduction of the cross-section of a stranded wire
- Loosening of the splices
- Damage due to the influence of heat (friction, radiation). This damage is recognisable by:
 - glossy appearance of the fibres of the wrapping
 - fused fibres
- Damage caused by the action of aggressive substances. This damage is recognisable by:
 - the flaking off of fibres of the sheathing
 - Fibres that can be pulled out or rubbed off
- Deformations, cracks, fractures or other damage to fitting parts

In the appendix to this operating manual from page 23 more detailed examples of signs of use and damage to the product are shown.

5 Instructions for use



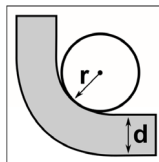
NOTE! Woven material is coloured. Direct contact with surfaces can transfer colour pigments from the rope material to the surface of the load.

➤ Avoid possible staining or marks by using suitable intermediate layers.

5.1 Protection from sharp edges



NOTE! Sharp-edged loads and lifting equipment can damage the product and lead to failure! A sharp edge is already present if the edge radius r of the load is smaller than the thickness d of the product.



5.2 Product differentiation

In general, ISO 18264:2022 differentiates between the construction types of sling fibre ropes in *lifting slings* and *grommets*. The relevant differences are shown below.

Lifting sling

The eye-and-eye sling constructions are characterised by the following features:

- Formed from a single rope,
- With shaped eyes at the end,
- Eyes with or without thimble,
- Spliced at each eye.

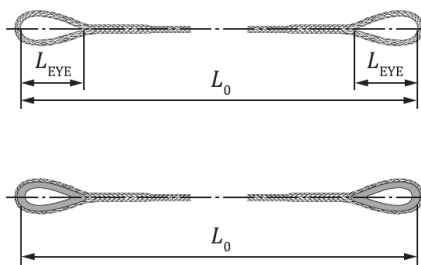


Fig. 3: Load sling without thimble (top) and with thimble (bottom)

Grommet

A grommet is also called an "endless construction". A grommet is characterised by the following features:

- Formed from a single rope,
- With or without shaped eyes,
 - Eyes with or without thimble,
 - When forming the eyes, the grommet is tied with an additional rope so that eyes are formed. These eyes are additionally provided with HMWPE protection as standard.
- The ends are spliced together.

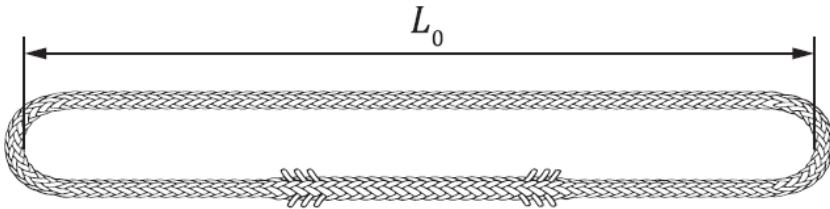


Fig. 4: Grommet

5.3 Lifting factors and working load limit (WLL)

The working load limit (WLL) indicated on each product applies to the "direct" hitch type. The load capacity of the product depends on the type of hitch used. On each *DoTExTreme* product there is a label showing the load capacities for the common hitch types.

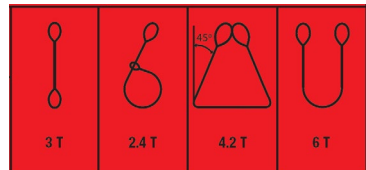


Fig. 5: Load capacity data for common hitch types



Not every type of hitch shown is suitable for every load.

Selection of fittings

In order to be able to assume the load-bearing capacity shown on the product, according to ISO 18264:2022, the load-bearing capacities given in Table 1 and Table 2 apply for the relationship between the diameter of the fittings (**D**) and the stated diameter of the fibre rope (**d**).

Table 1: Diameter ratio of the fitting part/lifting rope for lifting slings


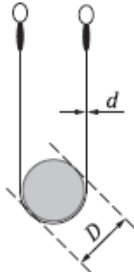
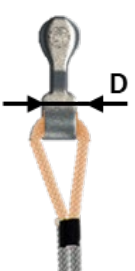
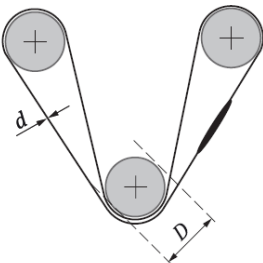
Version	Lifting sling	
Hitch type	Direct	Basket
		
Ratio D/d	$D \geq 2 \times d$	$D \geq 8 \times d$

Table 2: Diameter ratio of fitting part/lifting rope for grommets

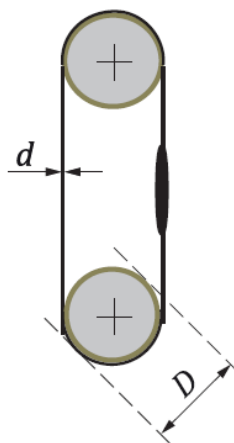
Version	Grommet	
Hitch type	Direct	Basket
		
Ratio D/d	$D \geq 8 \times d$	$D \geq 8 \times d$

Load capacity reduction according to ISO 18264

The following regulation only applies to a sling on crane hooks. If the ratio between the diameter of the fitting (**D**) and the diameter of the stop rope (**d**) of $D \geq 8 \times d$ given in Table 1 and Table 2 cannot be met, a reduction in the load capacity must be made in accordance with ISO 18264. The following Table 3 shows the necessary reduction.

Table 3: Load capacity reduction according to ISO 18264

Ratio D/d	Maximum load capacity
< 1	Not permissible
1	0.50 x WLL
1.5	0.59 x WLL
2	0.65 x WLL
2.5	0.68 x WLL
3	0.82 x WLL
4	
5	
6	
7	
≥ 8	No reduction



When using a thimble, the ratio D/d does not have to be observed!

5.4 Twisting of the rope

When using the Do *TE*Xtreme sling, excessive twisting of the rope must be avoided. Twisting of the lifting sling leads to a reduction in load capacity and damages the product.

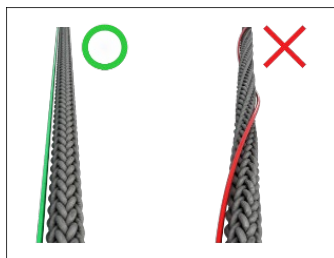


Fig. 6: Avoid twisting

5.5 Lifting configuration

Basket hitch



WARNING!

Risk of injury from falling load!

In the basket hitch, the slings can slip together. The load can shift and fall out of the slings.

- Only attach large loads in the basket hitch if the slings cannot slip together and the load cannot shift.
- Use spacers to prevent the slings from slipping together.



WARNING!

Risk of injury from falling load!

When slinging long, bar-shaped loads under a lifting beam in the basket hitch, the load or parts of the load can shoot out sideways or bend in such a way that they slip out of the slings.

- Support the load so that it cannot bend.
- Forcibly prevent the lifting beam from tilting.

OR

- Use the condition and surface of the load for slinging in such a way that the load or parts of it cannot shoot out.



Due to the existing hazards with the basket hitch, this type of hitch should only be used in exceptional cases! Instead, it is recommended to use the choker hitch.

Choker hitch

When using the product in the choker hitch, the working load limit (WLL) of the product is only **80 %!**



NOTE! When taking up a load, the product may be jerkily tied up. The resulting friction can damage the product.

- Manually constrict the unloaded load sling as far as possible before lifting.

5.6 Attaching to the load

When slinging the product, arrange it on the load so that:

- a uniform load is applied across the entire width of the product,
- there are no seams or splices over the hook area or other lifting equipment,
- the seams and splices are always in the straight part of the product,
- damage to the label is avoided by keeping it away from the load, hook and choke.



WARNING!

Risk of injury from falling load!

Strappings are not suitable anchor points.

- Never reach under strappings!

5.7 Balancing the load

In order to lift the load without it twisting or turning over, the following conditions must be observed:

- For single-leg suspensions, the anchor point must be vertically above the load's centre of gravity.
- For 2-leg suspensions, the attachment points must be evenly spaced on both sides and above the load's centre of gravity.
- For 3- and 4-leg suspensions, the attachment points must be equally distributed in a plane around the load's centre of gravity and must be above the load's centre of gravity.



NOTE! It is essential to observe the angle of inclination β : The greater the angle of inclination, the lower the load-bearing capacity.

- Angles of inclination exceeding 60° are not permitted!

- In the case of 3- and 4-leg suspensions and uneven loading, only the load-bearing capacity of a 2-leg suspension may be assumed on the largest angle of inclination.

If different angles of inclination occur with 2-leg suspensions (Fig. 7), only the load-bearing capacity of a single leg may be taken as a basis.

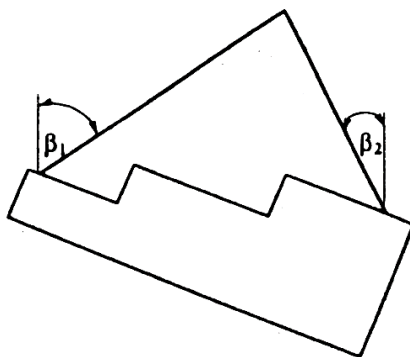


Fig. 7: Example for unequal inclination angles β

Uneven load distribution is always to be expected when:

- the load is inelastic (e.g., concrete parts, castings, short beams).
- the position of the centre of gravity is not known.
- the load is unevenly shaped.
- different angles of inclination occur.

5.8 Setting down the load

When setting down the load, the following specifications must be observed:

- Prepare the set-down location so that the product is not trapped under the load (e.g., use dunnage).
- Ensure that the load is secure!
- Do not remove the product until the load is secured against tipping over and slipping.

6 Storage and care

6.1 Storage

Before storing the product, inspect it for any damage that may have occurred during use.

Do not store damaged products.

Store the product on a shelf

- in a clean, dry and well-ventilated environment,
- away from heat sources.

During storage, contact must be avoided with

- Chemicals,
- flue gases,
- corroding surfaces,
- direct sunlight,
- other sources of ultraviolet radiation.

6.2 Cleaning

Clean the product with clear water only.

Do not use any chemical additives.

If the product has become wet due to cleaning or use, hang the product in the air to dry.

Do not artificially accelerate the drying of the product (e.g., by heating).

7 Disposal instructions

After meeting discarding criteria, these Do *TE Xtreme* lifting slings must be disposed of properly and in accordance with the locally applicable legal requirements.



8 Appendix

8.1 Examples of harmful influences

The influences described in the following can impair the long-term and safe use of the sling rope. The illustrations of the damage patterns are intended to help find the cause of damage.

External wear

Some types of rope may develop a "fur" or "pile" on the rope surface when pulled over a rough surface. Some disarrangement or breakage of fibres is to be expected when used in certain ways. This is normal and will not significantly weaken the rope if it does not occur excessively.



Fig. 8: Example of slight damage due to external wear and tear

Excessive wear is shown by the fact that a large part of the cross cuts of the yarns are rubbed off on the outside of the rope. If the cross-section in a strand is significantly reduced (more than 10 %), the lifting sling must be discarded.



Fig. 9: Example of severe damage due to external wear and tear

Such wear is usually most obvious on the strand heads and on the inside of eye splices, especially under a rope thimble, if present.

If all the threads on the outside of a sling rope are broken, it is recommended that the rope be discarded.

Inner wear

Internal wear of the lifting sling can occur in different ways:

- Repeated loading and bending of the lifting sling when it is under tension.
- When used in a dirty environment, coarse granular debris (e.g., sand or sharp grit) can get inside the lifting sling.

Internal wear and tear is recognisable by:

- Excessive loosening of the strands
- Occurrence of fibre dust inside the rope

If these signs appear, the rope must be opened and inspected between the strands for such damage. This inspection may only be carried out by trained personnel to avoid further damage to the lifting sling (e.g., by kinking and distorting the strands).

Cuts and other mechanical damage

Mechanical damage always weakens a sling. The weakening depends on the severity of the damage. The smaller the rope diameter of the sling, the stronger the effects of mechanical damage, especially chafing.

Cuts must be examined closely to determine how deep they are and how badly the cross-section of the rope has been damaged. The cuts shown in Fig. 10 ensure that the sling is ready to be discarded.



Fig. 10: Example of cut strands

Compression

Compression on the rope may be visible as a flattened area. This compression has no influence on the wear of the lifting sling but is a normal behaviour of the sling rope during use. Compression areas can be "repaired" by hand, by gentle bending of the rope.



Fig. 11: Example of compression

Pulled strands and yarns

Pulled strands or yarns are caused when they get stuck on the equipment or surfaces. Pulled strands can easily be pulled back into the rope. It is necessary to find the area with tightened strands and slacken the strand again.

It is necessary to check the course of the rope and find the source of the getting stuck to prevent the strands/yarns from getting stuck again and to avoid even worse damages.



Fig. 12: Example of pulled yarns/strands

Uneven deformations

In this type of damage, one or more strands are not the same length and are stretched tight in the rope. This can be an indication of a cracked or broken strand in the rope. It is crucial to find the point of origin of this deformation. If the strand is broken, the lifting sling should be discarded.



Fig. 13: Example of non-uniform deformation

Damage due to heat exposure

Damage due to heat exposure can occur in two ways:

- by external heat sources, e.g., hot loads or high ambient temperatures
- due to the friction that occurs in ropes made of synthetic fibres under high tension during work.

In both cases, fibres, yarns or strands can begin to melt or fuse together due to the heat that occurs.

During an inspection, the sling should be checked for melting points (see Fig. 14 and Fig. 15) or charring. If in doubt, the lifting sling must be discarded.

Heat damage - melted or glazed fibres

Melted areas of the rope are usually easy to spot. They may contain melted fibres, yarns or even whole strands. The surface may have a glazed characteristic where the yarns are sealed into a compact "rod". Depending on the type of overheating, decomposition can be observed on the surface, which can cause a brown or even black discolouration. In this area, the fibres and yarns are usually weak and can be broken by hand (depending on the temperature and the degree of decomposition).

Depending on the extent of the heat damage, it is advisable to remove the affected area or discard the entire lifting sling.



Fig. 14: Example of heat damage - melted fibres

A glazed surface of the rope is created when the rope is moved under tension over a smooth surface.

It does not affect the life of the rope or the strength of the rope. In some cases, glazed areas of the rope have improved abrasion resistance.



Fig. 15: Example of heat damage - glazed fibres

Humidity

Ropes made of synthetic fibres are usually not affected by wetness or moisture. Nevertheless, wet or damp synthetic fibre ropes should not be stored lying on the floor, as this can cause coarse-grained particles and dirt to adhere to them.

Wet ropes should be hung in freely circulating air and allowed to dry naturally. If this is not possible, the ropes should be stacked loosely on pieces of wood or other suitable materials that are not on damp ground or "sweating" concrete.

Under no circumstances should drying be artificially accelerated, e.g., by heating.

Chemical degradation

Some chemicals can cause damage to the rope.

This damage can show up as black spots, frayed/fuzzy areas, colour changes or brittle fibres (see Fig. 16).

Depending on the extent of the damage, it is advisable to remove the affected area or discard the lifting sling.



Fig. 16: Example of damage due to chemical influence

Damage due to UV radiation

UV radiation can cause discolouration of the rope material, but this does not necessarily result in a loss of strength. Double braided ropes are only affected by UV radiation to a limited extent, but may lose abrasion resistance. Long-term exposure to strong UV radiation will damage the product.

UV damage can be recognised by the brittleness of the yarns. In some ropes that are overexposed to UV radiation, dust particles may increasingly detach from the surface yarns. Depending on the colour, the rope may lose its colour tone and even take on a white or yellowish colour. If this is the case, the rope must be withdrawn from further use.

The most important points regarding UV damage to ropes are:

- Discolouration of the material can be caused by UV radiation, but this does not necessarily lead to a loss of strength.
- UV radiation affects all ropes, including ropes with a diameter of more than 24 mm.
- Sheathed ropes are affected by UV radiation and may lose some abrasion resistance and breaking strength on the surface.
- When the ropes are submerged, UV radiation is very limited.
- Long-term exposure to high UV radiation changes the condition of a rope.
- When not in use, ropes should be covered with a thick tarpaulin.

8.2 EC Declaration of Conformity

In the sense of the EC Machinery Directive 2006/42/EC

We,

Dolezych GmbH & Co KG

Hartmannstraße 8

44147 Dortmund



hereby declare, that the Do *TEXtreme* lifting sling fibre ropes designed for lifting loads comply with the following relevant provisions in the standard version:

EC Machinery Directive 2006/42/EC

DIN EN ISO 12100 Safety of machinery - general principles for design

In accordance with DIN EN 1492-4 - Lifting slings for general service made from natural and man-made fibre ropes

ISO 18264 - Textile slings – Lifting slings for general purpose lifting operations made from fibre ropes – High modulus polyethylene (HMPE)

Dortmund; 27.09.2023


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Dipl. Ing. Thomas Schade
(authorised representative)