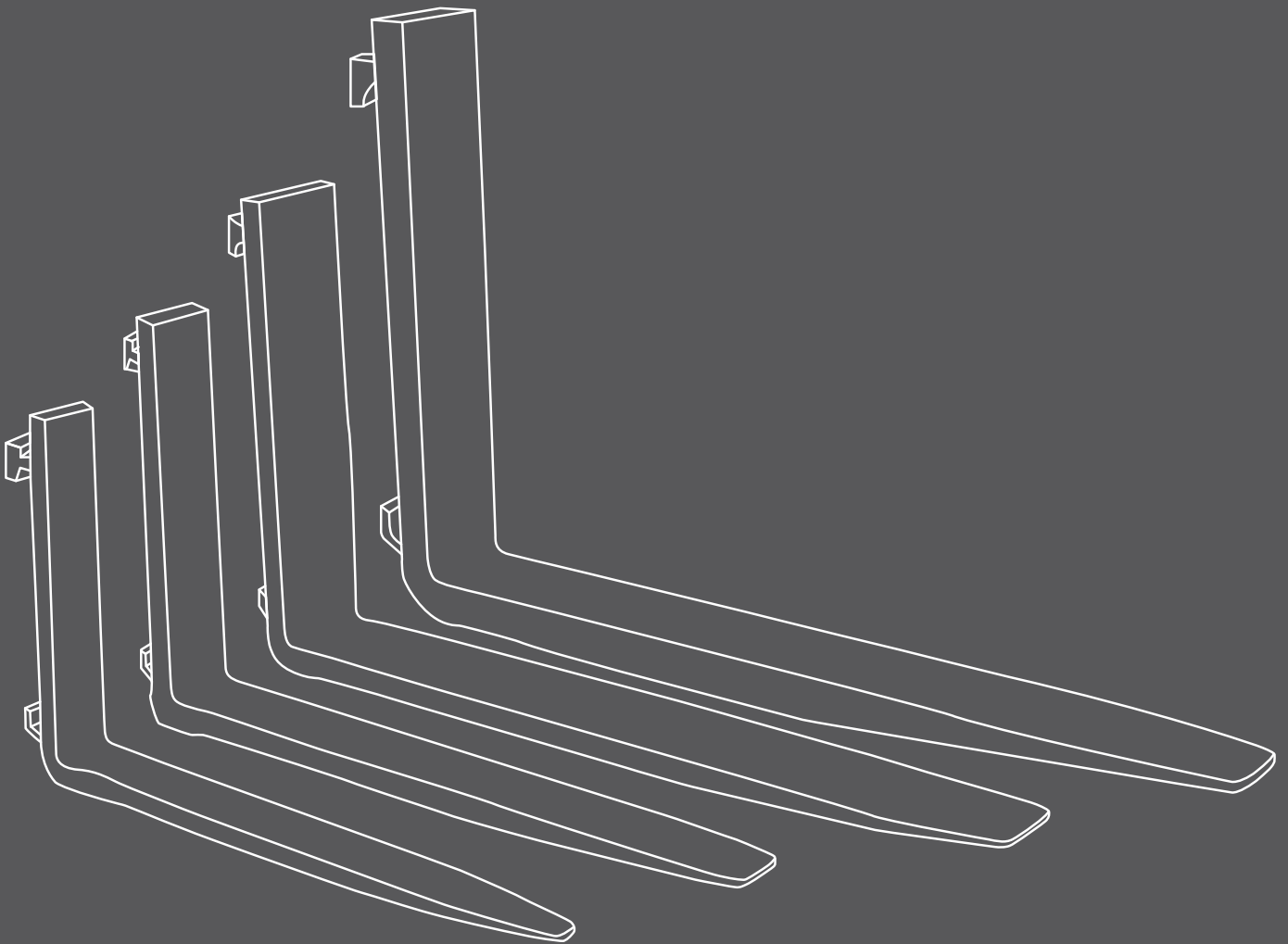


FORK GUIDE 2013

USA/CAN





With a brand which is synonymous with specialists in forest products handling attachments, BOLZONI AURAMO offers its expertise and market leading attachments for all requirements, from large paper rolls to pulp bales and cardboard packaging, from home appliances and beverage products to construction materials.

BOLZONI AURAMO is the world's leading supplier to the main lift truck manufacturers of factory installed products.

**BOLZONI AURAMO IS
A BOLZONI GROUP'S BRAND**



**BOLZONI IS ONE OF THE
WORLDWIDE LEADING
MANUFACTURERS OF LIFT TRUCK
ATTACHMENTS, FORKS AND
LIFT TABLES, WITH THE MOST
EXTENSIVE PRODUCT RANGE IN
THE MARKET.**

**WE ARE BOLZONI,
THE MATERIAL HANDLING GROUP**

Quality, safety, efficiency

Bolzoni Auramo offers complete range of forks for lift trucks, construction and agricultural material handling machines, in many different capacities, sections and lengths, ISO and special mountings.

Advanced production process

Production standards for all Bolzoni Auramo forks are based on common key- features:

- Innovative and highly automated production process.
- Prime quality steel offering good welding characteristics and strong resistance to wear.
- Automated welding of upper and lower hooks with a robotic system, granting better quality of the welding, quality repeatability and higher process speed.
- Complete heat treatment with hardening and tempering on the entire fork, providing the best quality and reliability characteristics.



Certified quality

Certified quality of chemical composition and of the heat treatment applied on raw material used. Bar coding allowing for the tracking of raw material back to source.

All forks produced comply with the parameters outlined in ISO 2328 and 2330.

In order to satisfy these standards, each different type of forks is subjected to the following tests:

- 1 fatigue test of 1,000,000 cycles at 25% overload.
- 1 static test of 2 cycles with triple nominal capacity.
- 1 resilience test at -20°C with a resulting value higher than 27 Joules.

FORK GUIDE



01	FEM/ISO Mounting Standards	page 6
02	Hook Forks - FEM/ISO Mounting	page 8
03	Tips and Tapers	page 12
04	Special Application Forks	page 16
05	Marking	page 36
06	Hook Pin Kits	page 37
07	Inspections and Maintenance	page 38

Note

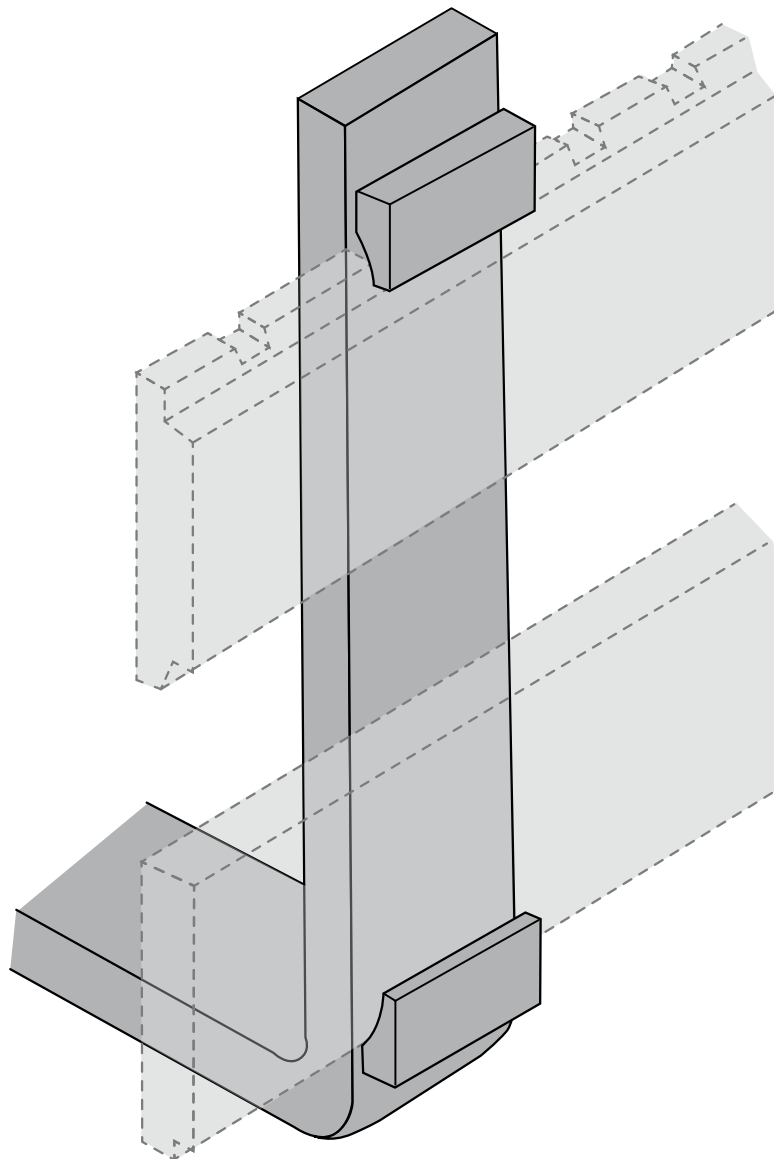
The purpose of this FORK GUIDE is to:

- Inform on the range of Bolzoni Auramo forks suitable for different fork applications.
- Drive on the choice of the correct fork type and dimensioning
- Support on fork safety maintenance procedures

Fork models and features included in this guide are informative only, shown as examples of the possible supply.
For any additional version, please consult Bolzoni Auramo concerning correctness of use and technical feasibility, supplying technical specifications and drawings.

01

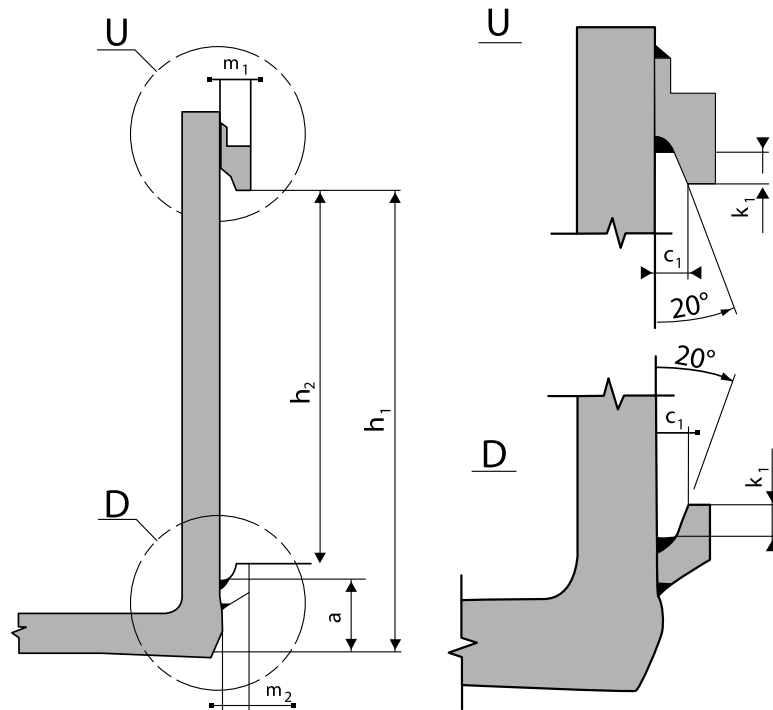
FEM/ISO Mounting Standards



The FEM / ISO mounting is the most common way of connecting forks to the lift-truck.

According to the lift truck capacity, the ISO standards are divided into 5 classes, each of them having a „A“ and „B“ version. The difference between version „A“ and „B“ is the clearance from the lower hook to the floor. Measurements are defined by the International Standard ISO 2328.

Main measurements are listed in the following chart:

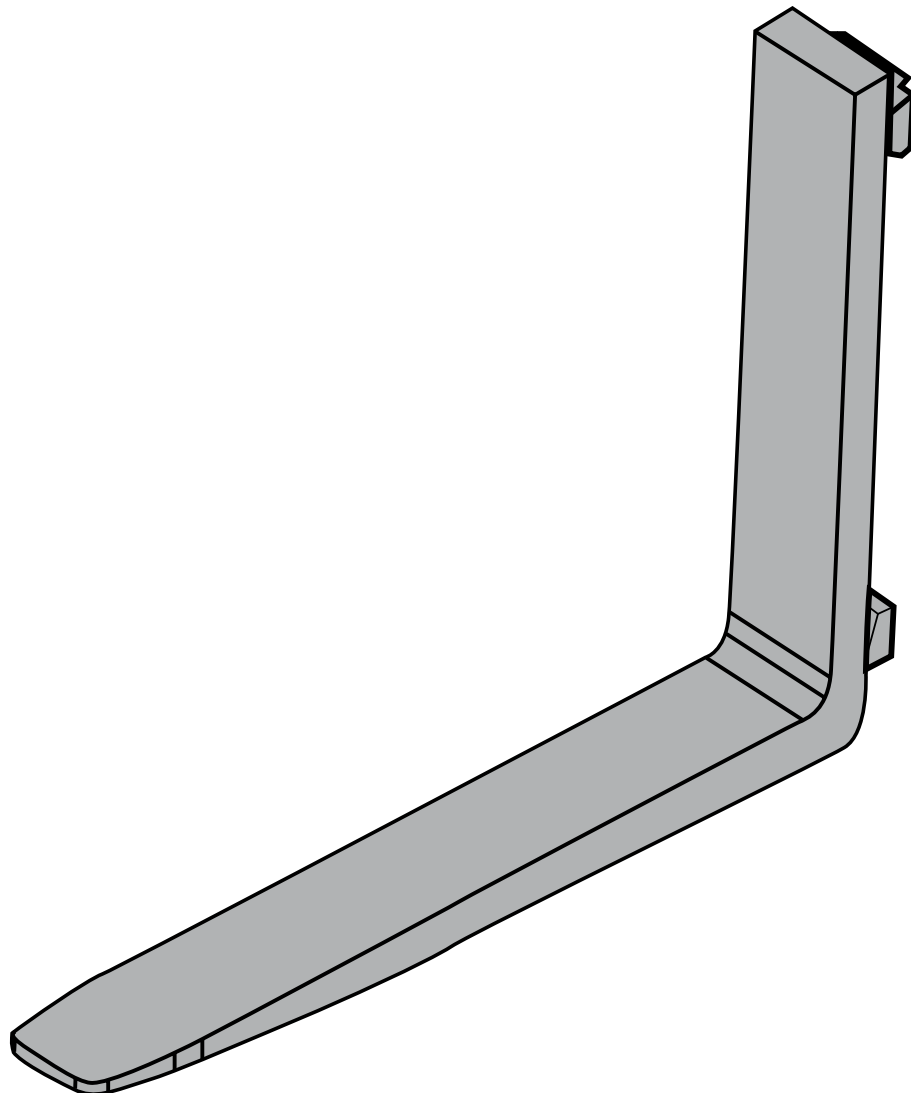


Class	Truck Rated capacity	Rated load center distance	Fork arm type	a	c ₁	h ₁	h ₂		m ₁	m ₂	k ₁
	lb						in.	in.			
1	0-1,999	24	A	3.00	0.65	15.50	12.05	+0.04/-0.00	1.10	1.03	0.55
			B	4.50		17.00					
2	2,000-5,500	24	A	3.00	0.65	18.50	15.04	+0.04/-0.00	1.22	1.14	0.55
			B	6.00		21.50					
3	5,501-10,000	24	A	3.00	0.87	22.36	18.78	+0.06/-0	1.57	1.50	0.67
			B	8.00		27.36					
4	10,001-17,500	24	A	5.00	1.03	29.25	23.54	+0.06/-0	1.85	1.78	0.79
			B	10.00		34.25					
5*	17,501-24,000	24	A	5.00	1.38	32.67	26.77	+0.06/-0	2.56	2.48	1.03
			B	10.12		37.80					

* Capacity ISO 5 are still often included in ISO 4.

02

Hook Forks FEM/ISO Mounting



Chapter Description**Page**

Class 2 / Class 3

page 10

Class 3 / Class 4

page 11

02**General Information**

Hook FEM / ISO mounting forks for forklift trucks of all brands, in many different capacities, sections and lengths.

For dimensions not included in the present Fork Guide, please consult Bolzoni Auramo.

Lock pin assembly included on all FEM / ISO 2328 hook forks.

On request:

- ISO 2328 Class B mounting
- Different fork section and lengths
- Forks for special applications

02

Capacity per pair Q Lbs	Load Center BP inches	Mounting Class ITA Class	Fork Section AxE Inches	Fork Length L Inches	Fork Weight (ea.) W Lbs
3.700	24"	2	4" x 1.25"	36"	79
				42"	86
				48"	93
5.500	24"	2	4" x 1.50"	36"	88
				42"	95
				48"	104
				54"	115
				60"	128
5.500	24"	2	4" x 1.75"	36"	101
				42"	108
				48"	117
				54"	130
				60"	143
5.500	24"	2	5" x 1.50"	42"	128
				48"	134
				54"	152
5.500	24"	2	5" x 1.75"	42"	139
				48"	150
				54"	165
				60"	176
				72"	220
5.500	24"	2	5" x 1.50"	54"	143
7.600	24"	3	5" x 1.75"	42"	150
				48"	163
				60"	192
9.500	24"	3	5" x 2"	42"	165
				48"	179
				54"	194
				60"	212
				72"	245
				84"	289

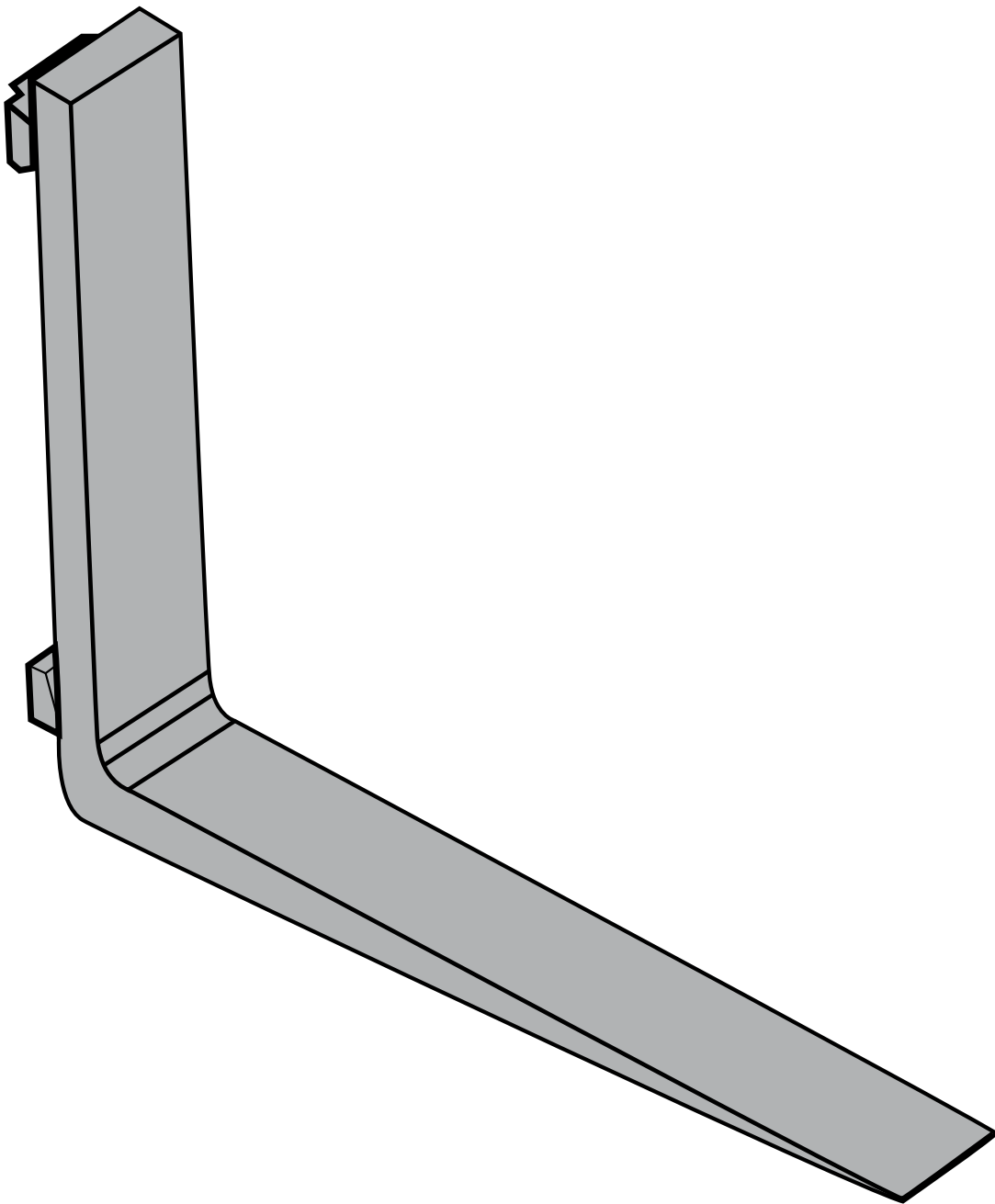
Capacity per pair	Load Center	Mounting Class	Fork Section	Fork Length	Fork Weight (ea.)
Q	BP	ITA	AxE	L	W
Lbs	inches	Class	Inches	Inches	Lbs
10.000	24"	3	6" x 2"	42"	194
				48"	209
				54"	229
				60"	249
				72"	304
				84"	346
				96"	386
12.000	24"	4	6" x 2"	48"	258
				72"	344
				96"	425
15.000	24"	4	8" x 2"	48"	337
				72"	443
				96"	564
17.500	24"	4	6" x 2.50"	48"	324
				60"	377
				72"	430
				96"	540

On request:

- Class B mounting
- Different fork sections and lengths
- Forks for special applications

Tips and Tapers

03



Chapter Description

Page

Tips

page 14

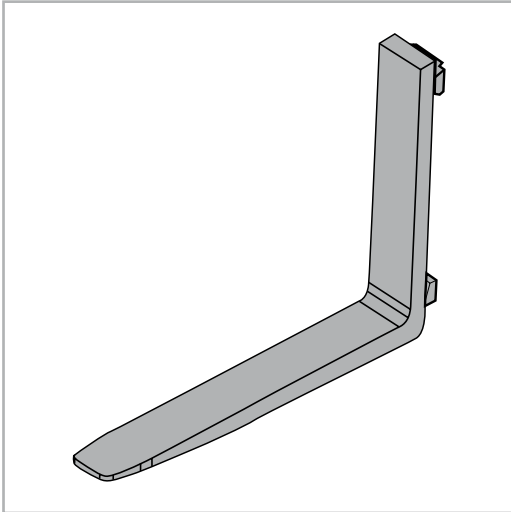
Tapers

page 15

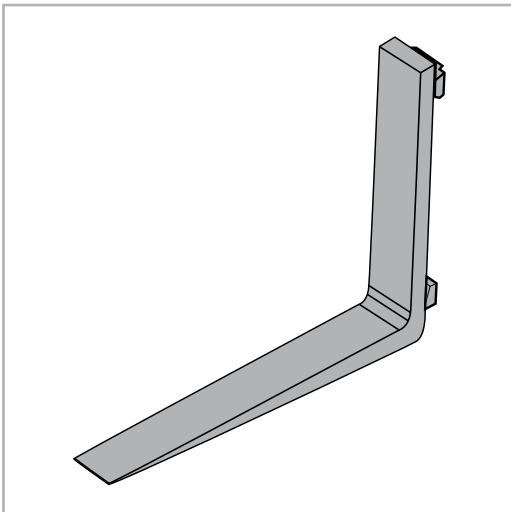


Fork tips are suitable to make the insertion into loads easier.

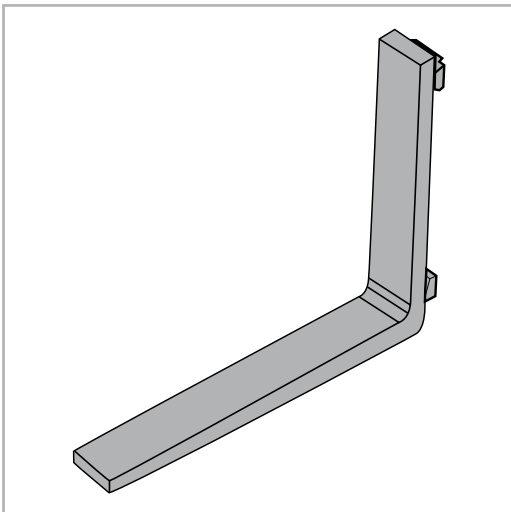
03



Standard tip



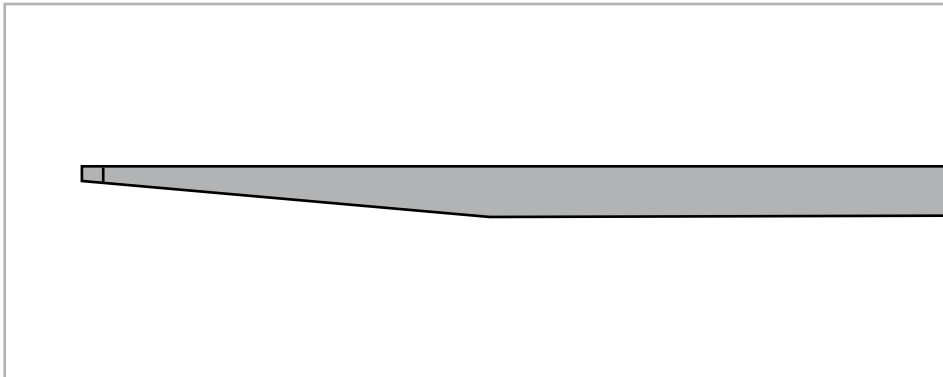
Square tip with reduced thickness
for easier penetration into loads



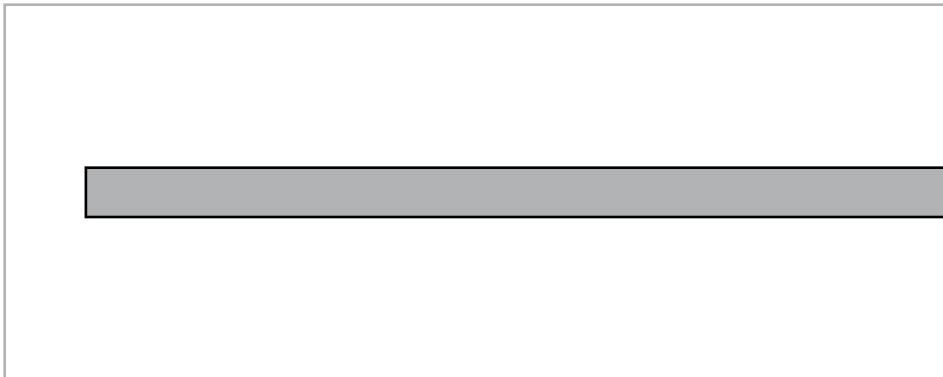
Square tip for special applications

For any further tip versions, please consult Bolzoni Auramo, providing specifications and drawings.

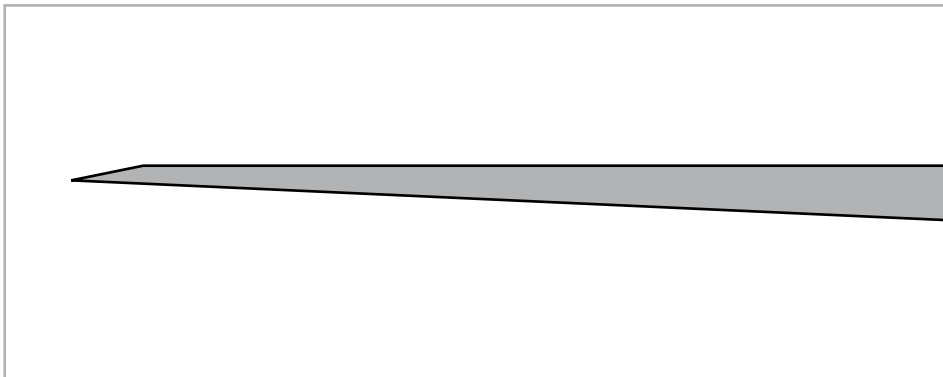
Fork tapers are suitable to make fork use easier when forks are loaded.



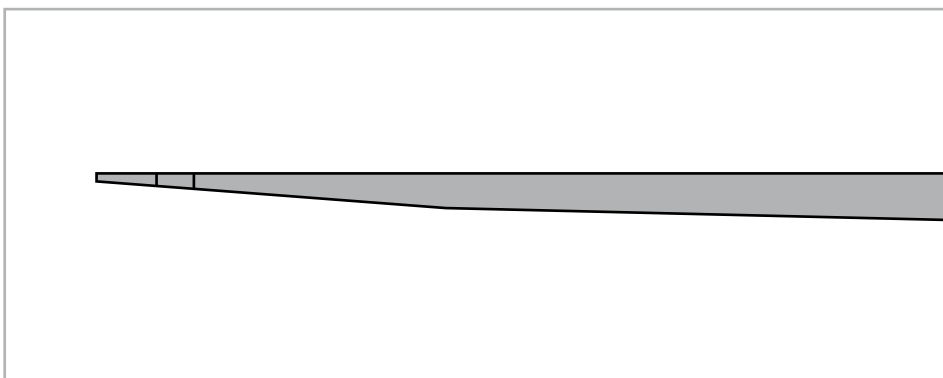
Standard taper,
no bevel



No taper



Full taper with top bevel

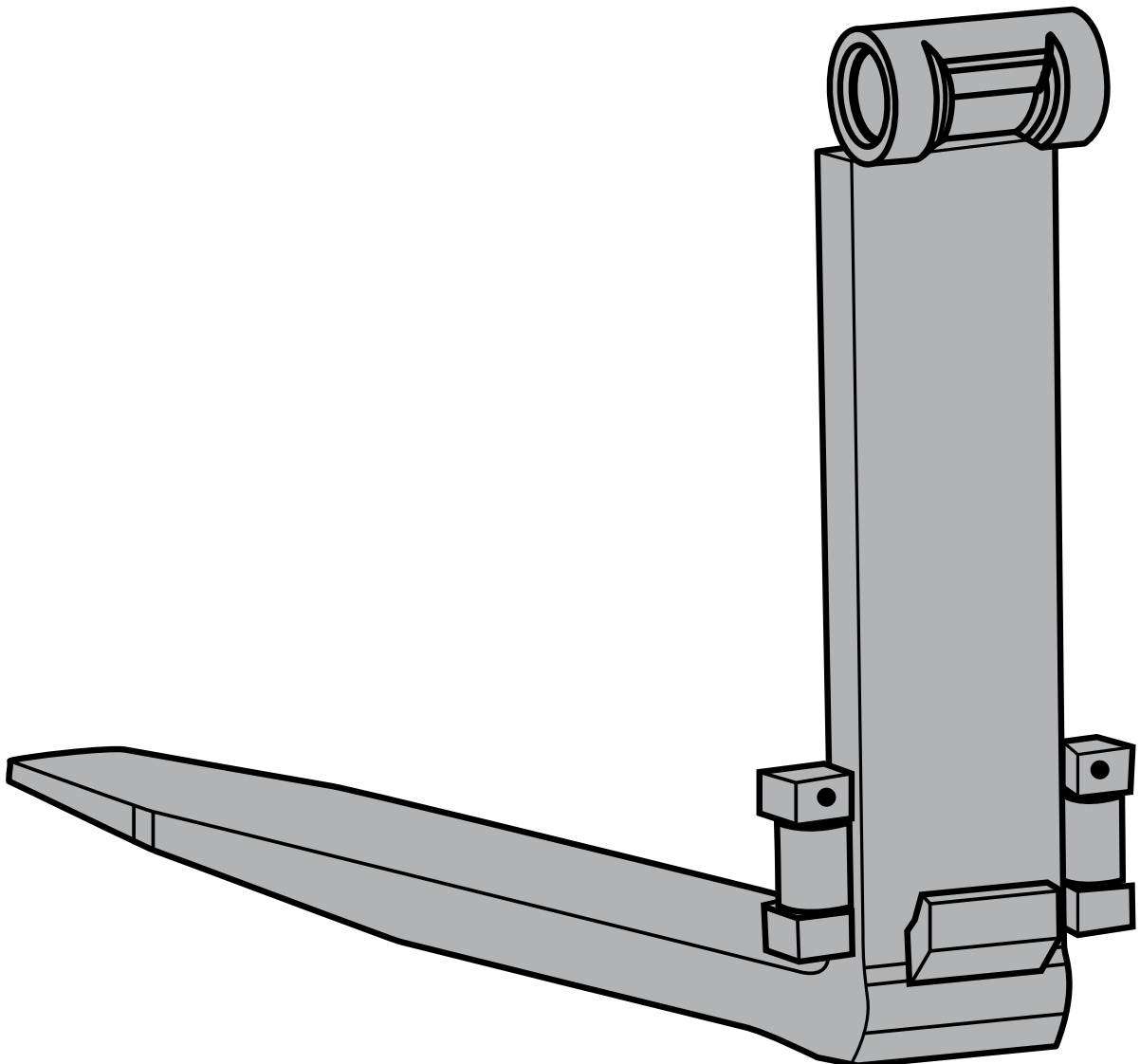


Two stage taper

For any further taper versions, please consult Bolzoni Auramo, providing specifications and drawings.

Special Application Forks

04

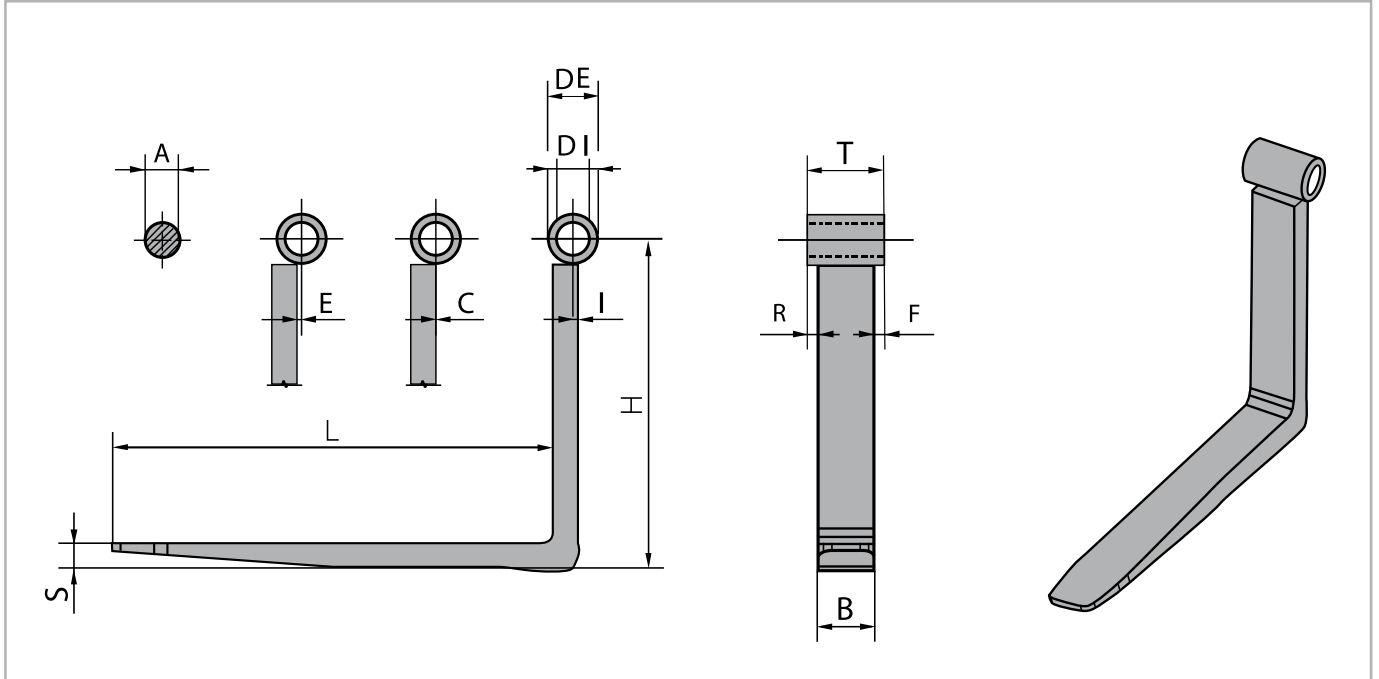


Chapter Description	Page
Pin-Type Forks	page 18
Pin-Type Forks with lower hooks	page 19
Pin-Type Forks for Bolzoni Auramo fork positioners FP-FN Series	page 20
Pin-Type Forks with lower hook sliding on rollers for Bolzoni Auramo fork positioners FP-FN Series	page 21
Forks with load-bearing lower hooks	page 22
Drum handling Forks	page 23
Coil handling Forks	page 24
Forks with 3rd hook	page 25
Forks with explosion proof cladding	page 26
Stainless Steel forks for the food industry	page 27
Forks with polished surface	page 28
Forks polished and full tapered	page 29
Bolt-on Forks	page 30
Blank Forks	page 31
Terminal West Forks	page 32
Peek-A-Boo Forks	page 33
Lumber Forks	page 34

For any further fork versions, please consult Bolzoni Auramo, providing specifications and drawings.

Pin-type forks are guided on a shaft. Mainly used on larger lift trucks and on industrial and construction machines.

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

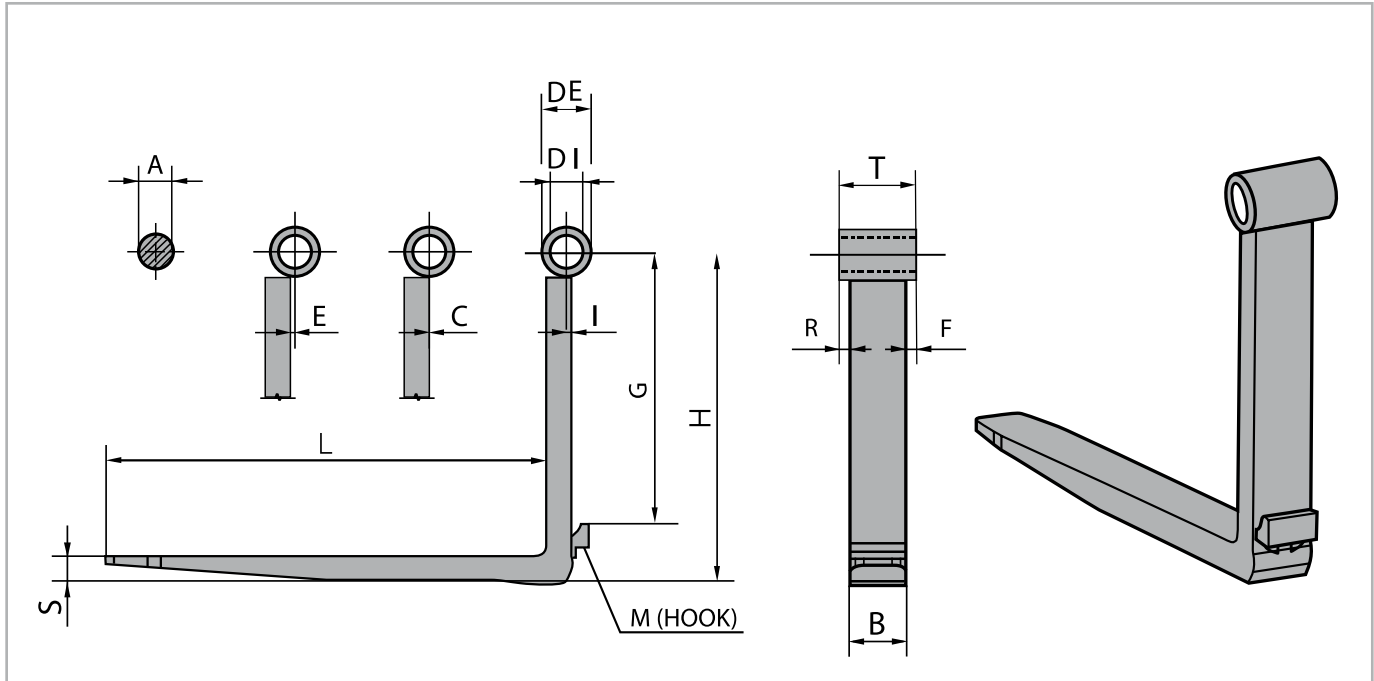
Contact:

Other info:

Technical Data

Length (L)	in.	
Width (W)	in.	
Thickness (S)	in.	
Back height (H)	in.	
Tube width (T)	in.	
Tube int. diameter (DI)	in.	
Tube ext. diameter (DE)	in.	
Bar pin diameter (A)	in.	
Tube inset (I)	in.	
Tube offset (E)	in.	
Tube inline (C)	in.	
Tube position right (R)	in.	
Tube position left (F)	in.	

Pin-type forks are guided on a shaft. Mainly used on larger lift trucks and on industrial and construction machines, this model is suitable for Bolzoni Auramo fork positioner FP-FN series.



04

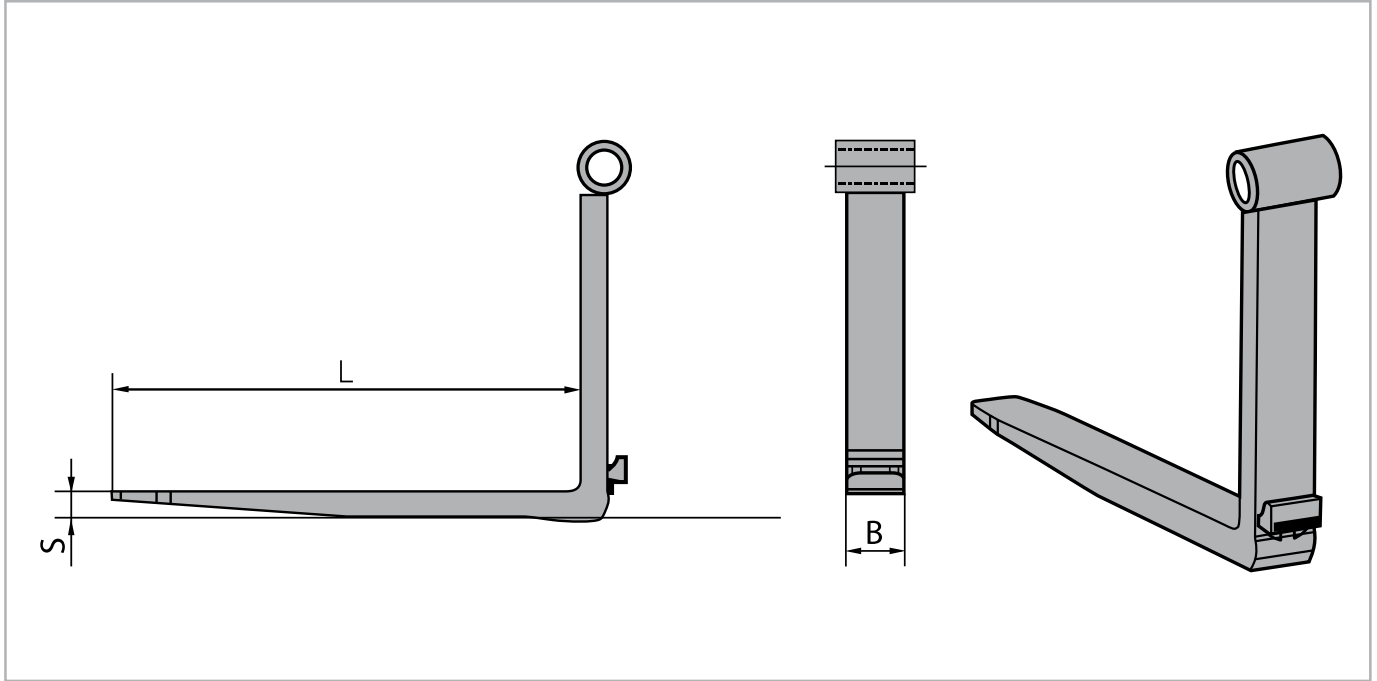
Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (W)	in.	
Thickness (S)	in.	
Back height (H)	in.	
Lower hook position (G)	in.	
Tube width (T)	in.	
Tube int. diameter (DI)	in.	
Tube ext. diameter (DE)	in.	
Bar pin diameter (A)	in.	
Tube inset (I)	in.	
Tube offset (E)	in.	
Tube inline (C)	in.	
Tube position right (R)	in.	
Tube position left (F)	in.	
ISO 2328 hook type (M)	in.	

Pin-Type Forks with lower hook for Bolzoni Auramo fork positioners FP-FN Series

Pin-type forks are guided on a shaft. Mainly used on larger lift trucks and on industrial and construction machines, this model is suitable for Bolzoni Auramo fork positioner FP-FN series.

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

Contact:

Other info:

Technical Data

Length (L)

in.

Width (B)

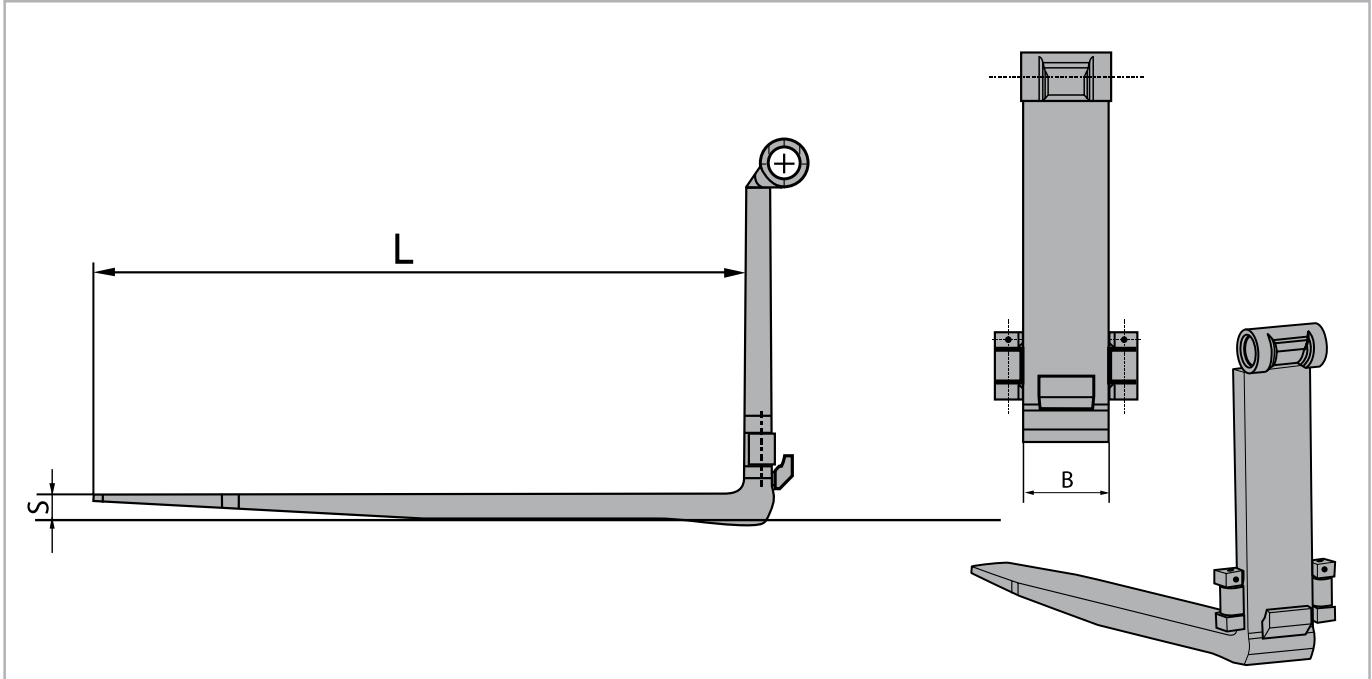
in.

Thickness (S)

in.

ISO 2328 Class

Pin-type forks are guided on a shaft. Mainly used on larger lift trucks and on industrial and construction machines, this model is suitable for Bolzoni Auramo fork positioner FP-FN series.



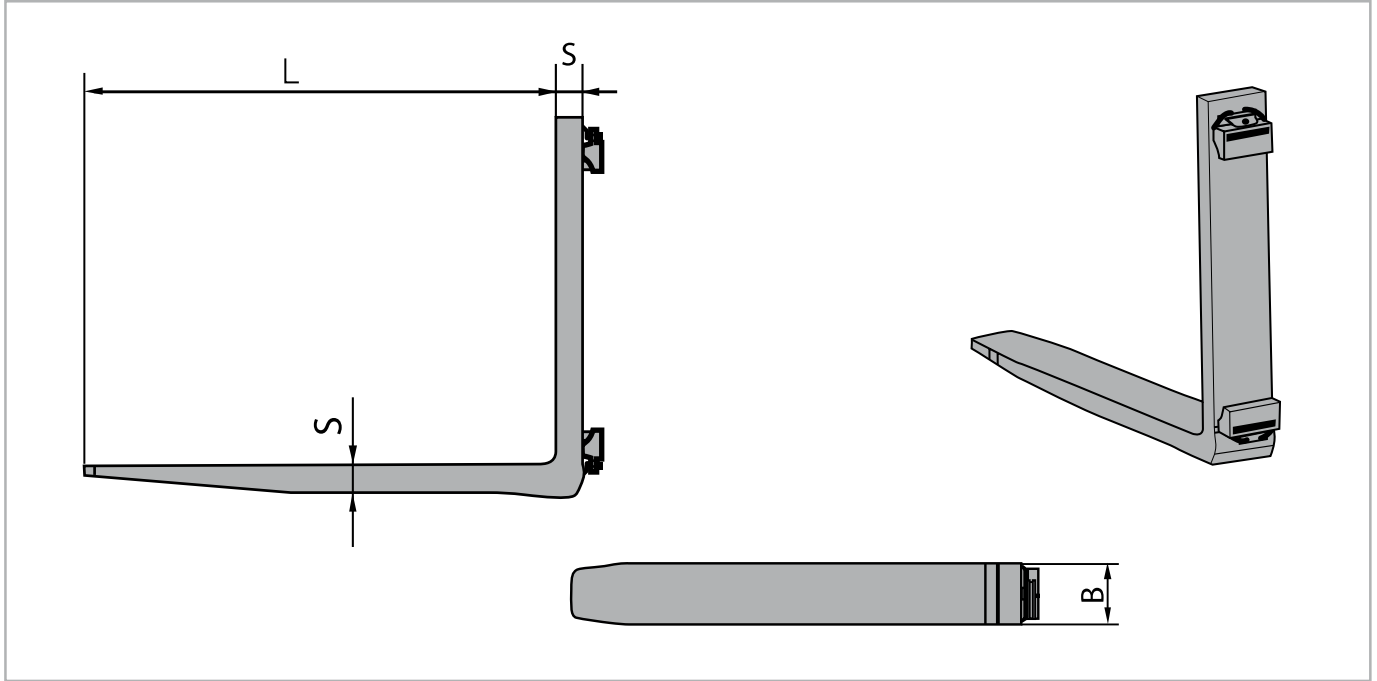
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
ISO 2328 Class		

Forks with load-bearing lower hook are used with a rotator for container rotating or emptying.

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

Contact:

Other info:

Technical Data

Length (L)

in.

Width (B)

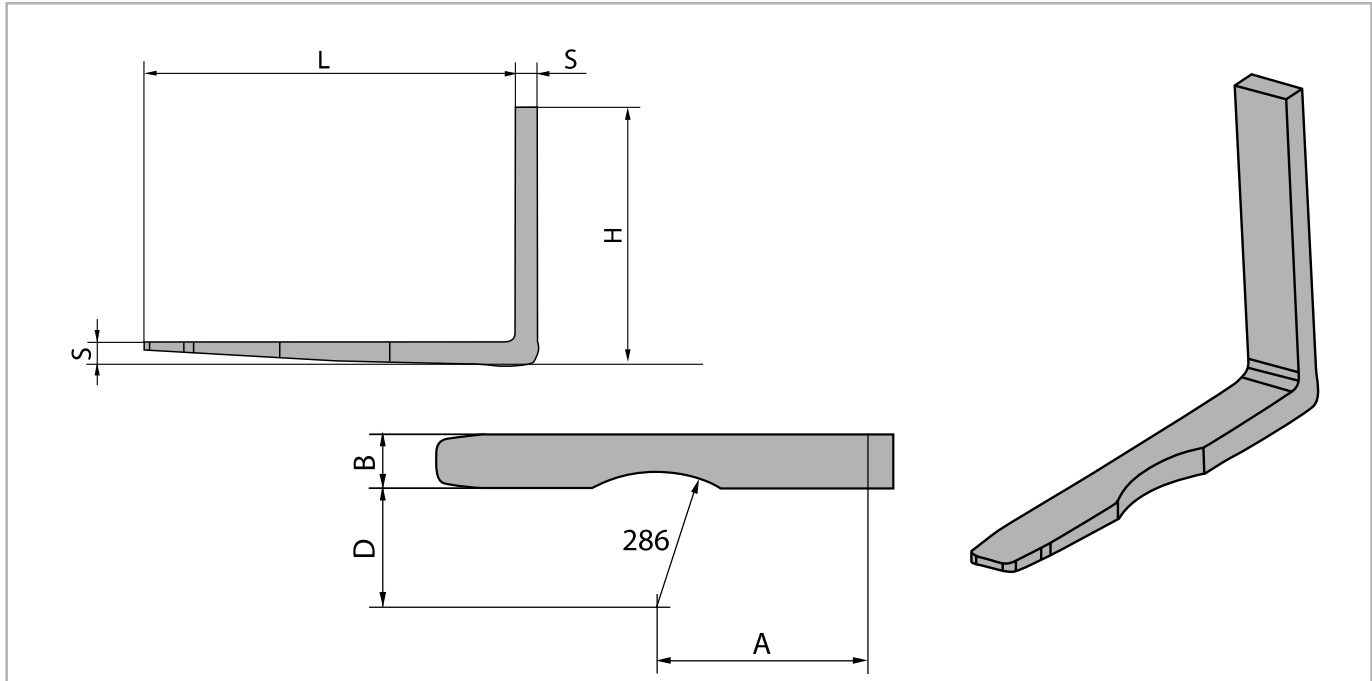
in.

Thickness (S)

in.

ISO 2328 Class

Drum handling forks are used for lifting one or two drums at one time.



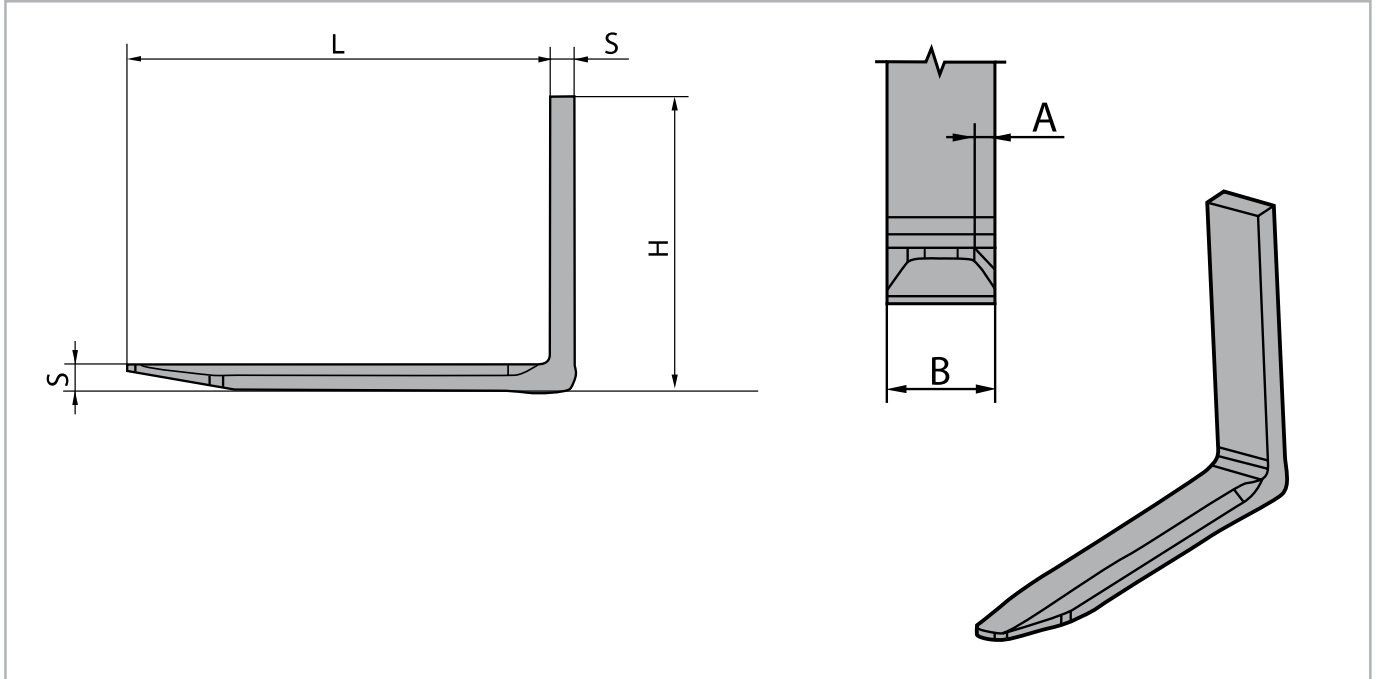
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Back height (H)	in.	
Drum position in depth (A)	in.	
Drum inset in the fork blade (D)	in.	

Coil handling forks are used to handle steel coils, reels etc

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

Contact:

Other info:

Technical Data

Length (L)

in.

Width (B)

in.

Thickness (S)

in.

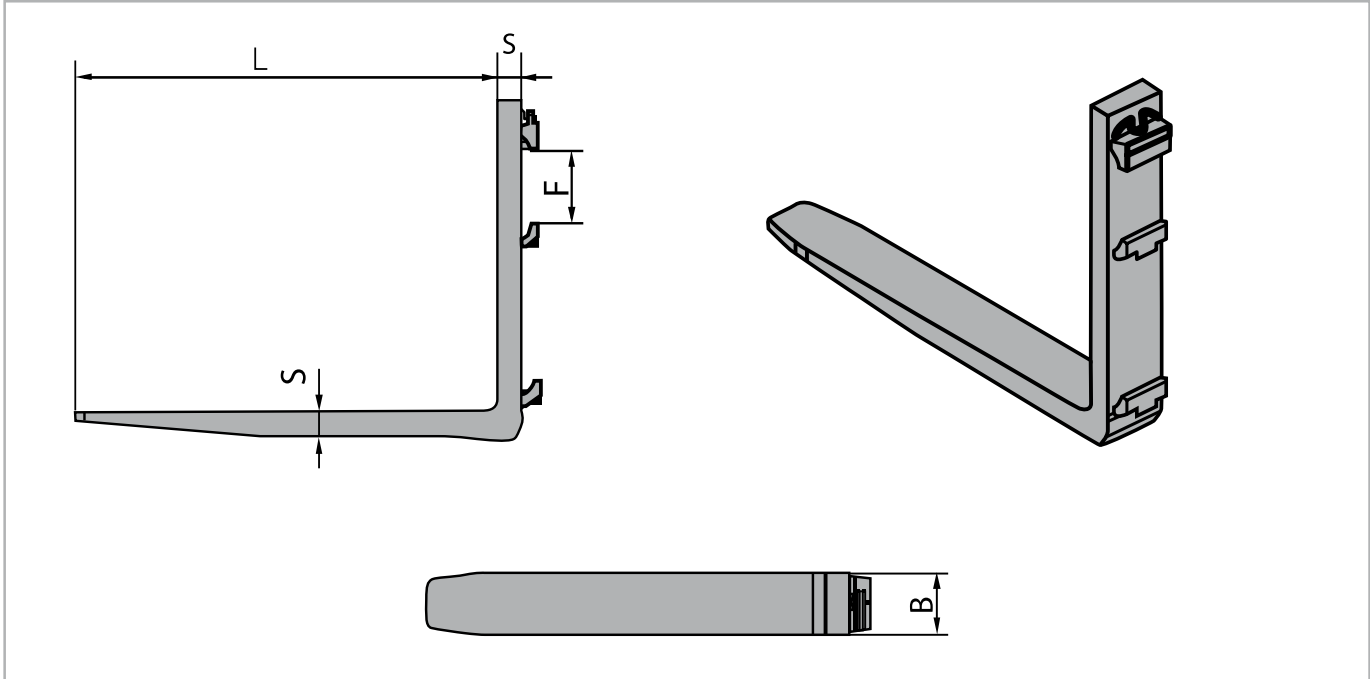
Back Height (H)

in.

Chamfer depth 45 degree (A)

in.

Forks with 3rd hook are used with a rotator for container rotating or emptying.



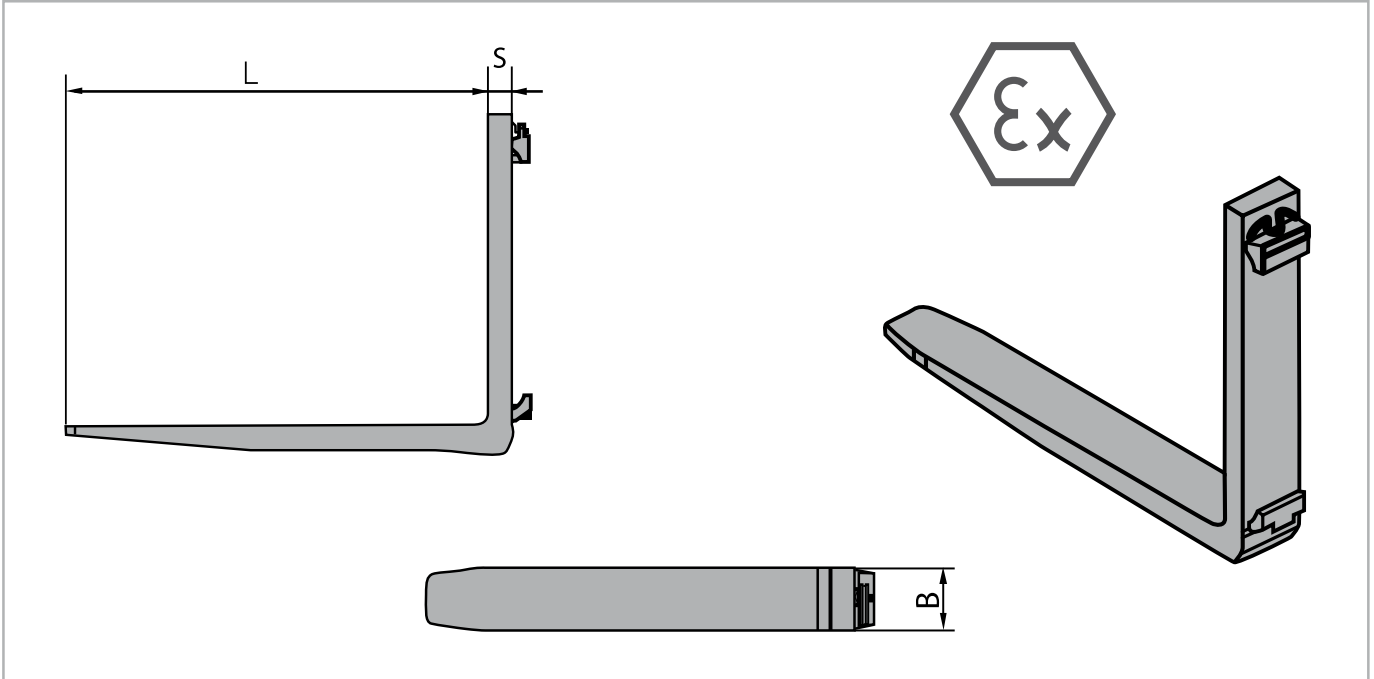
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Third hook (F)	in.	
ISO 2328 Class		

Forks with explosion proof stainless steel cladding are used on lift trucks operating in dangerous environments that must be kept spark free such as chemical and painting plants, weapons and munitions manufacturing plants, mines etc.. Fixed cladding of fork blade and / or fork shank. Stainless steel coating 0,08 inch.

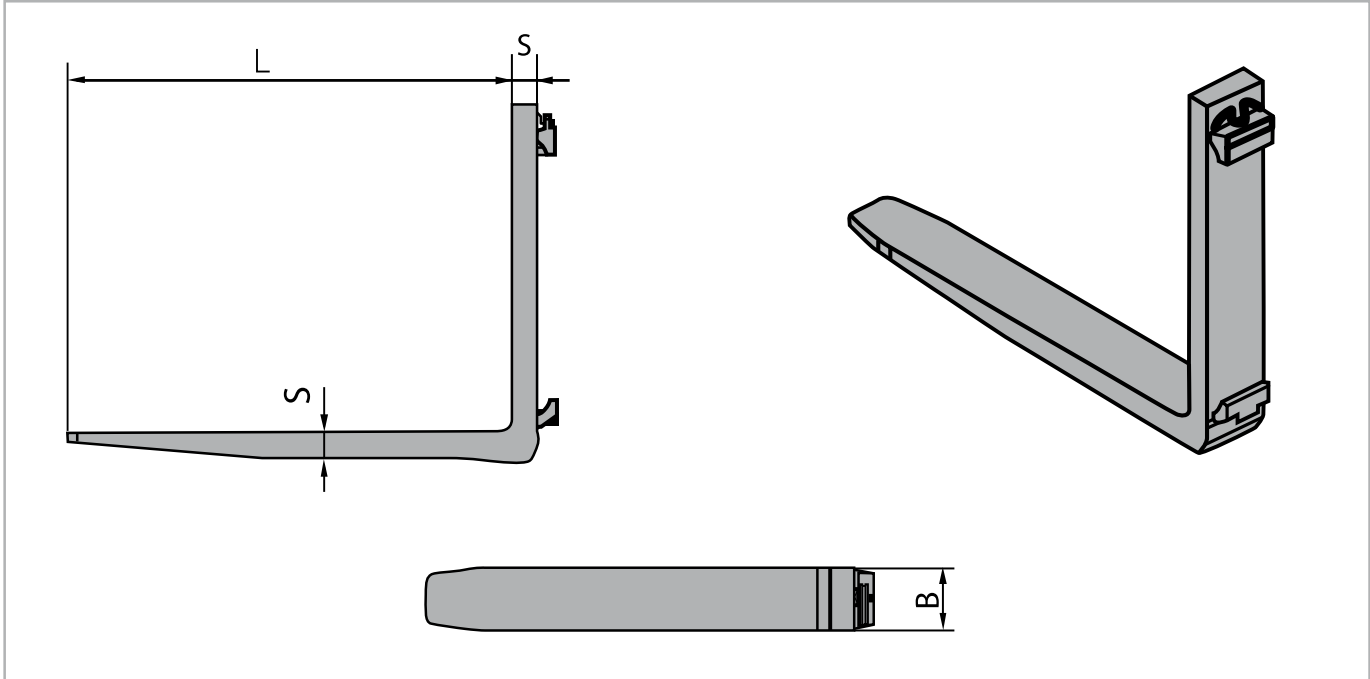
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
ISO 2328 Class		

Forks with stainless steel cladding for food industry are used on lift trucks for applications requiring sanitary wash down for constant cleanliness typical in food and pharmaceutical industries. Fixed cladding of fork blade and / or fork shank. Stainless steel coating 0,08 inch.



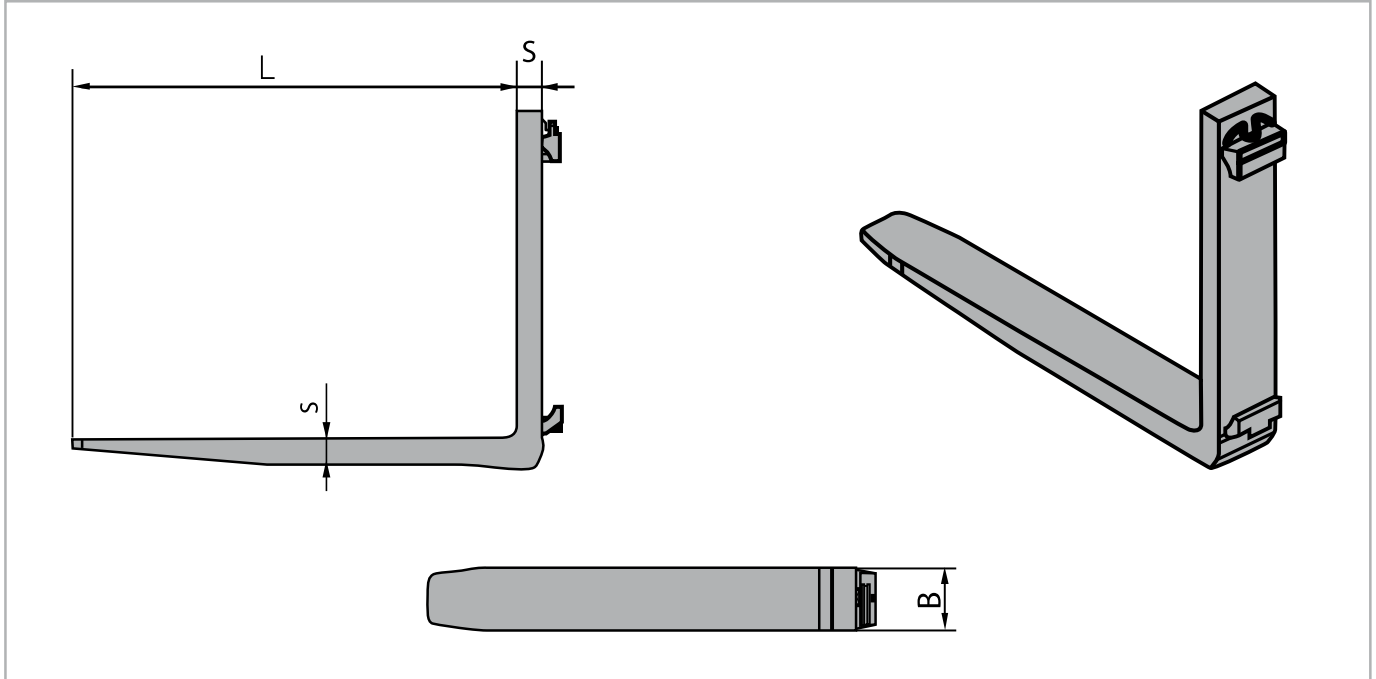
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
ISO 2328 Class		

Forks having the top of the blade polished to reduce friction when handling a load.

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

Contact:

Other info:

Technical Data

Length (L)

in.

Width (B)

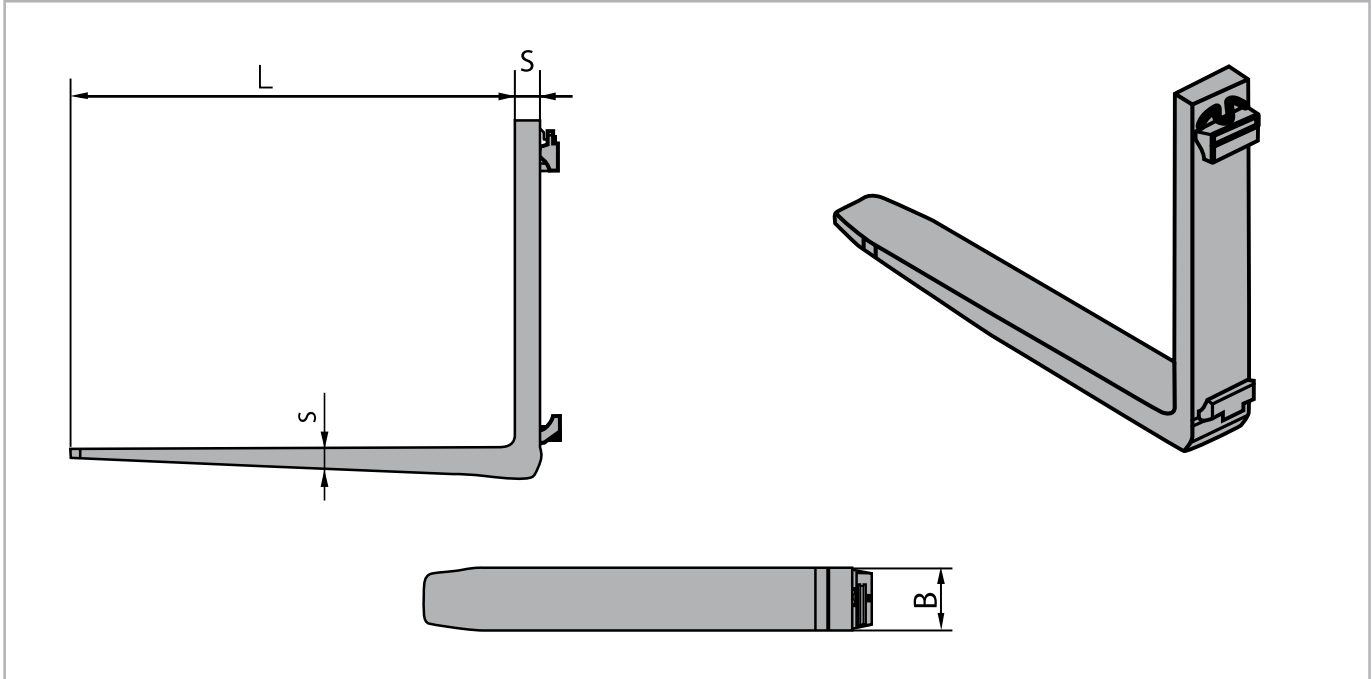
in.

Thickness (S)

in.

ISO 2328 Class

Forks having the top of the blade polished to reduce friction when handling a load, and full bottom taper for easier insertion into a load.



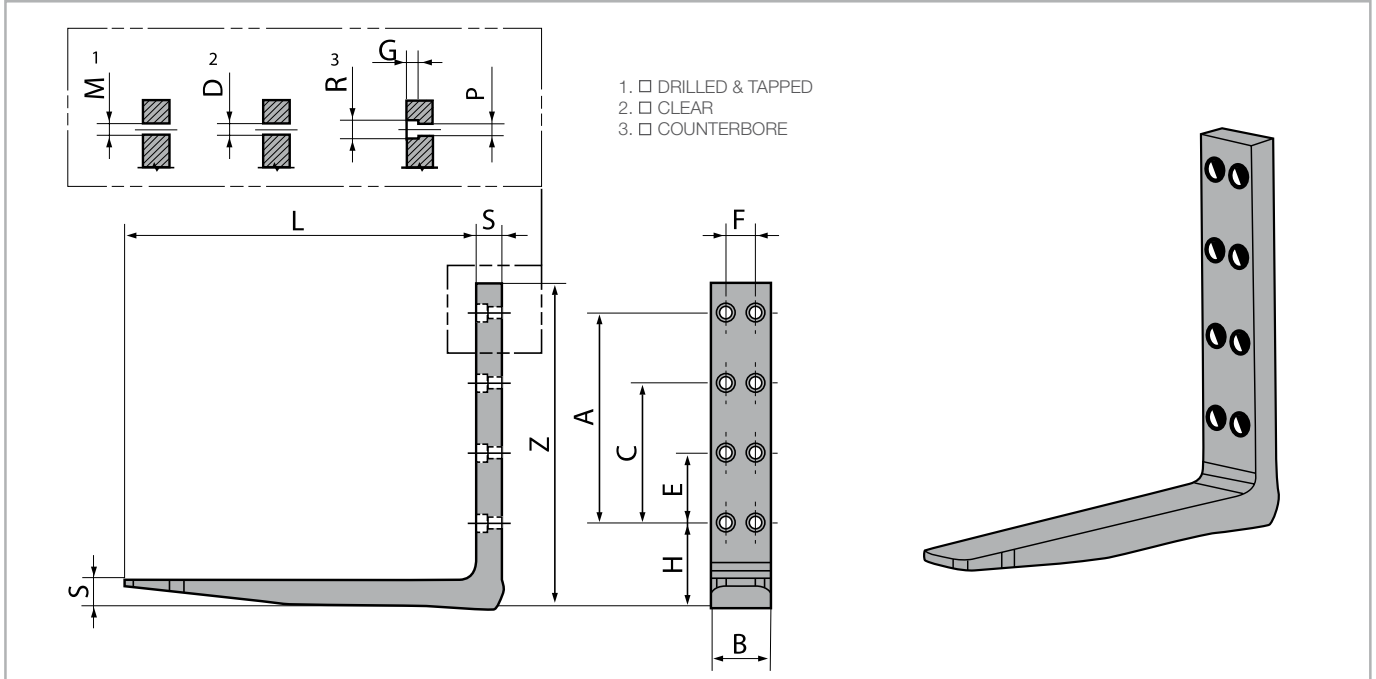
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
ISO 2328 Class		

Bolt-on forks are fixed to the lift truck carriage/fork carrier with bolts.

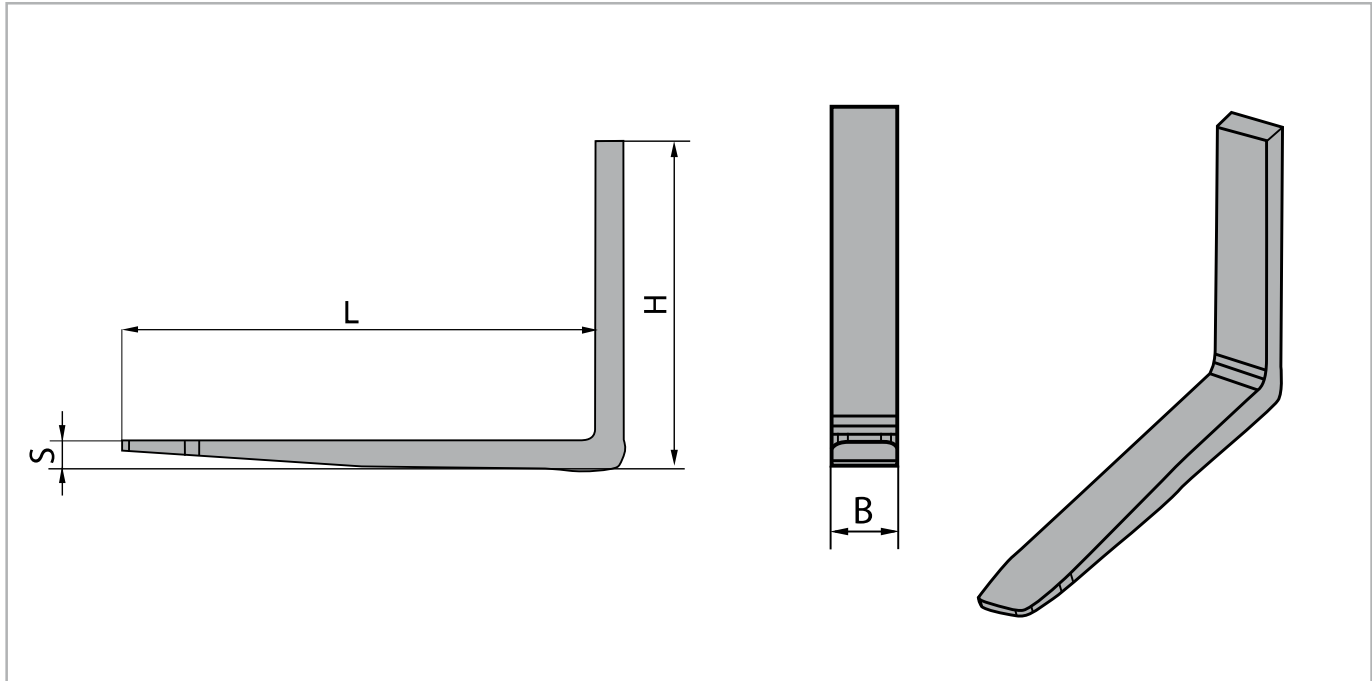
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Back height (Z)	in.	
Drilling height (H)	in.	
Drilling height (E)	in.	
Drilling height (C)	in.	
Drilling height (A)	in.	
Drilling c/c position (F)	in.	
Thread (M)	in.	
Drilling diameter (D)	in.	
Head diameter (R)	in.	
Head height (G)	in.	
Drilling diameter (P)	in.	

Blank forks are without hooks. Welded or bolt-on, they are used on clamping or fork positioning attachment or for special mounting applications.



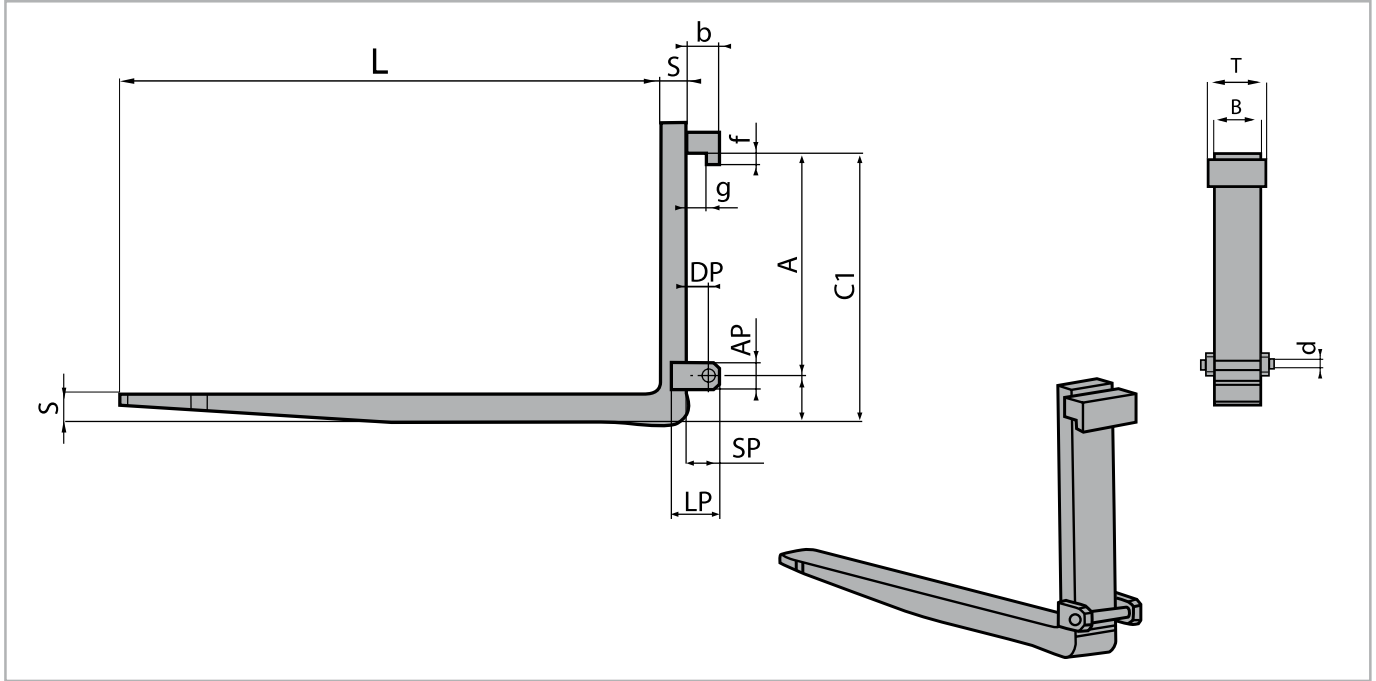
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Back height (H)	in.	

Terminal West forks are suitable for quick interchangeability between forks and attachments. The system allows the driver to change forks quickly on his own during a shift without any additional equipment.

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

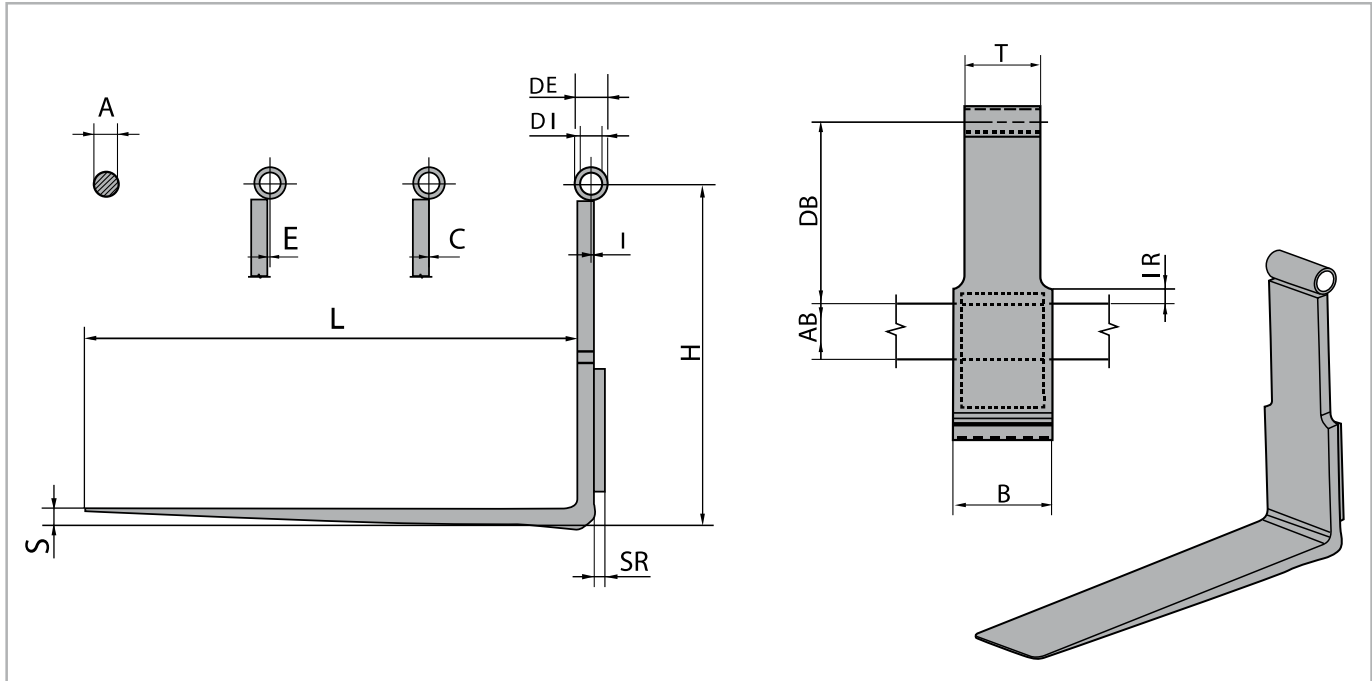
Contact:

Other info:

Technical Data

Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Hook width (T)	in.	
Upper hook thickness (b)	in.	
Hook height from ground (C1)	in.	
Hook and pin distance (A)	in.	
Tooth height (f)	in.	
Tooth width (g)	in.	
Plate height (AP)	in.	
Plate length (LP)	in.	
Plate overhang (SP)	in.	
Pin diameter (d)	in.	
Pin distance (DP)	in.	

Peek-A-Boo forks are mainly used in lumber industry and are specifically designed for increasing the truck driver visibility.



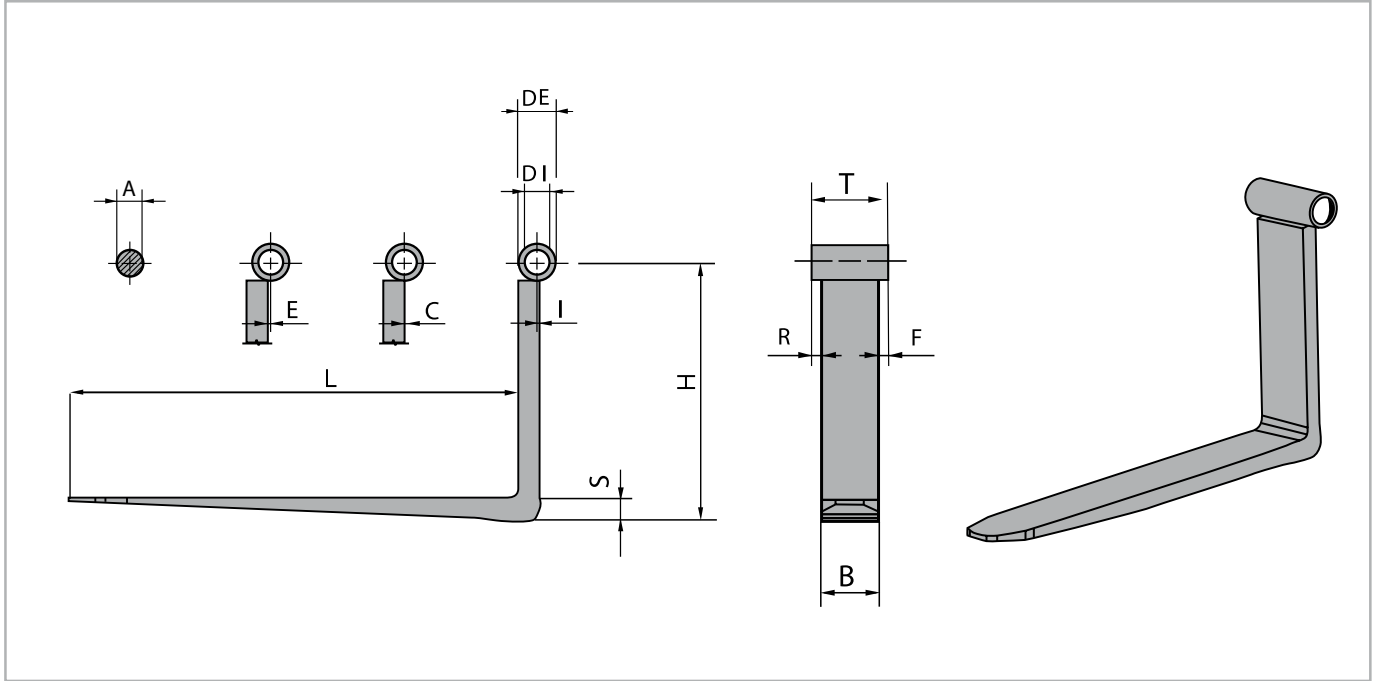
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Customer reference
Company:
Address:
Phone-office:
Fax:
Mobile:
E-mail address:
Contact:
Other info:

Technical Data		
Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Back height (H)	in.	
Tube width (T)	in.	
Tube int. diameter (DI)	in.	
Tube ext. diameter (DE)	in.	
Bar pin diameter (A)	in.	
Tube inset (I)	in.	
Tube offset (E)	in.	
Tube inline (C)	in.	
Thickness reinforcement (SR)	in.	
Bar height (AB)	in.	
Bar distance (DB)	in.	
Tapering starting point (IR)	in.	

Lumber forks are suitable for handling in lumber industry thanks to wide and thin horizontal blade.

04



Customer reference

Company:

Address:

Phone-office:

Fax:

Mobile:

E-mail address:

Contact:

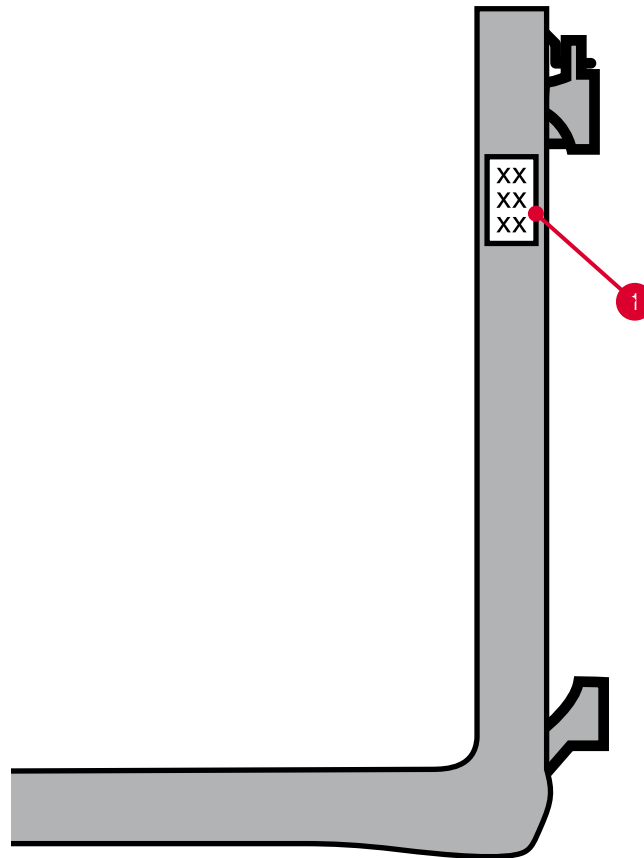
Other info:

Technical Data

Length (L)	in.	
Width (B)	in.	
Thickness (S)	in.	
Back height (H)	in.	
Tube width (T)	in.	
Tube int. diameter (DI)	in.	
Tube ext. diameter (DE)	in.	
Bar pin diameter (A)	in.	
Tube inset (I)	in.	
Tube offset (E)	in.	
Tube inline (C)	in.	
Tube position right (R)	in.	
Tube position left (F)	in.	

Marking/Stamping

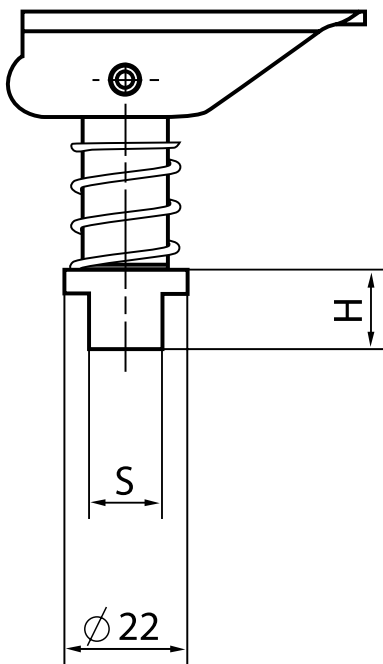
05



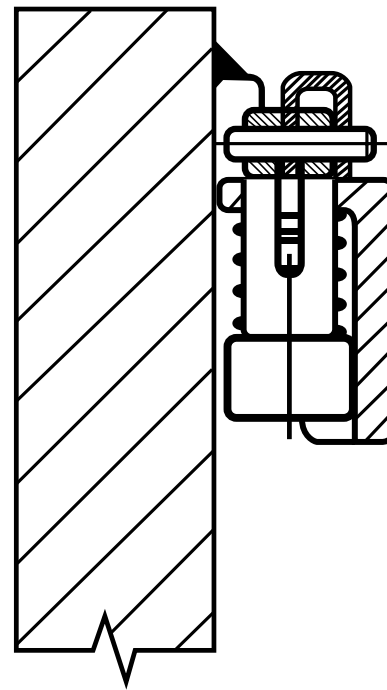
- 1 The following features are written on one side of the fork shank:
- Capacity
 - Load center
 - Manufacturer
 - Year
 - Month
 - Day

According to ISO 2330, forks have to be permanently marked, in order to allow their identification. If marking is not clearly legible, forks shall be withdrawn from service.

Hook Pin Kits



Kit assembly



Kit fit on fork

06

Hook pin is a mandatory locking device which prevents the fork from sliding off the carriage.

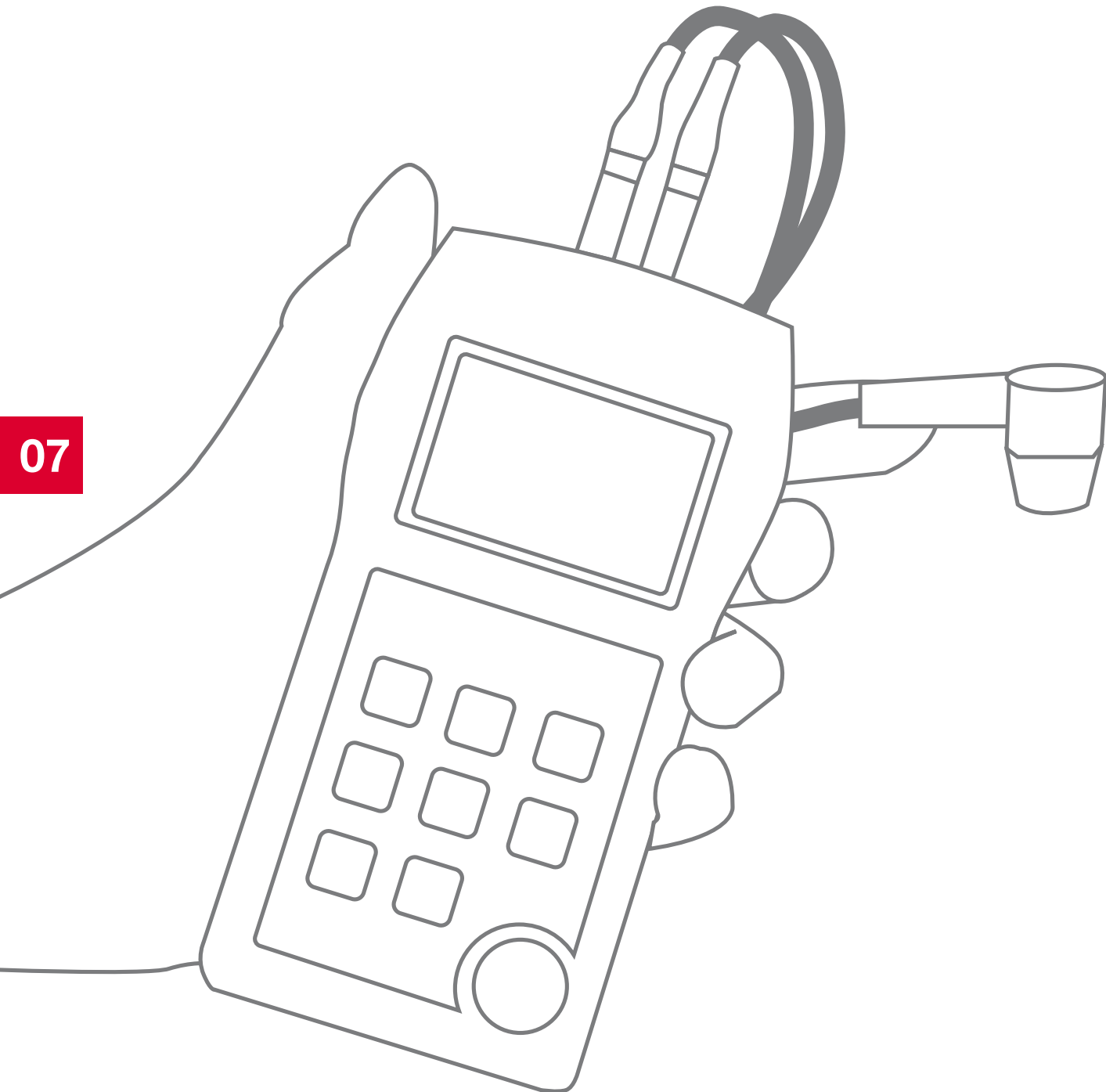
It is supplied as a kit, including the following components:

- n. 1 pin
- n. 1 lever
- n. 1 spring pin
- n. 1 spring

When ordering Pin Kits, please provide all stamping information available on fork shoulder side.

Inspection and maintenance

07



Chapter Description

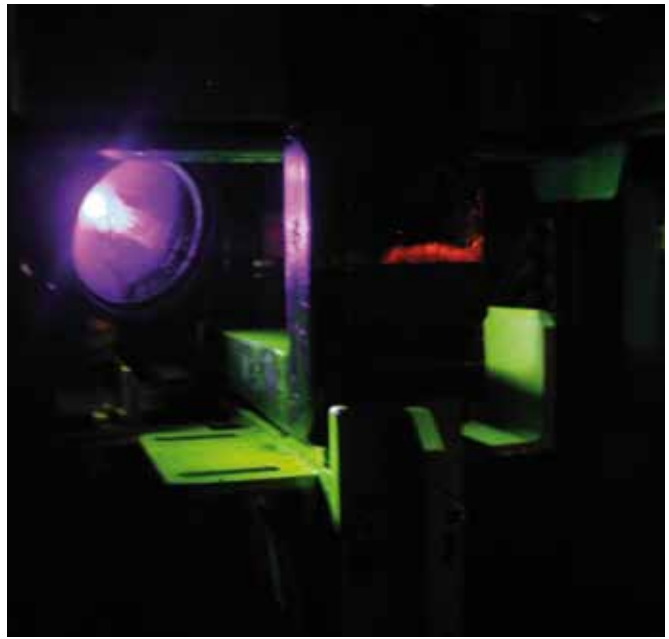
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Forks in service on forklift trucks

page 40

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07



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

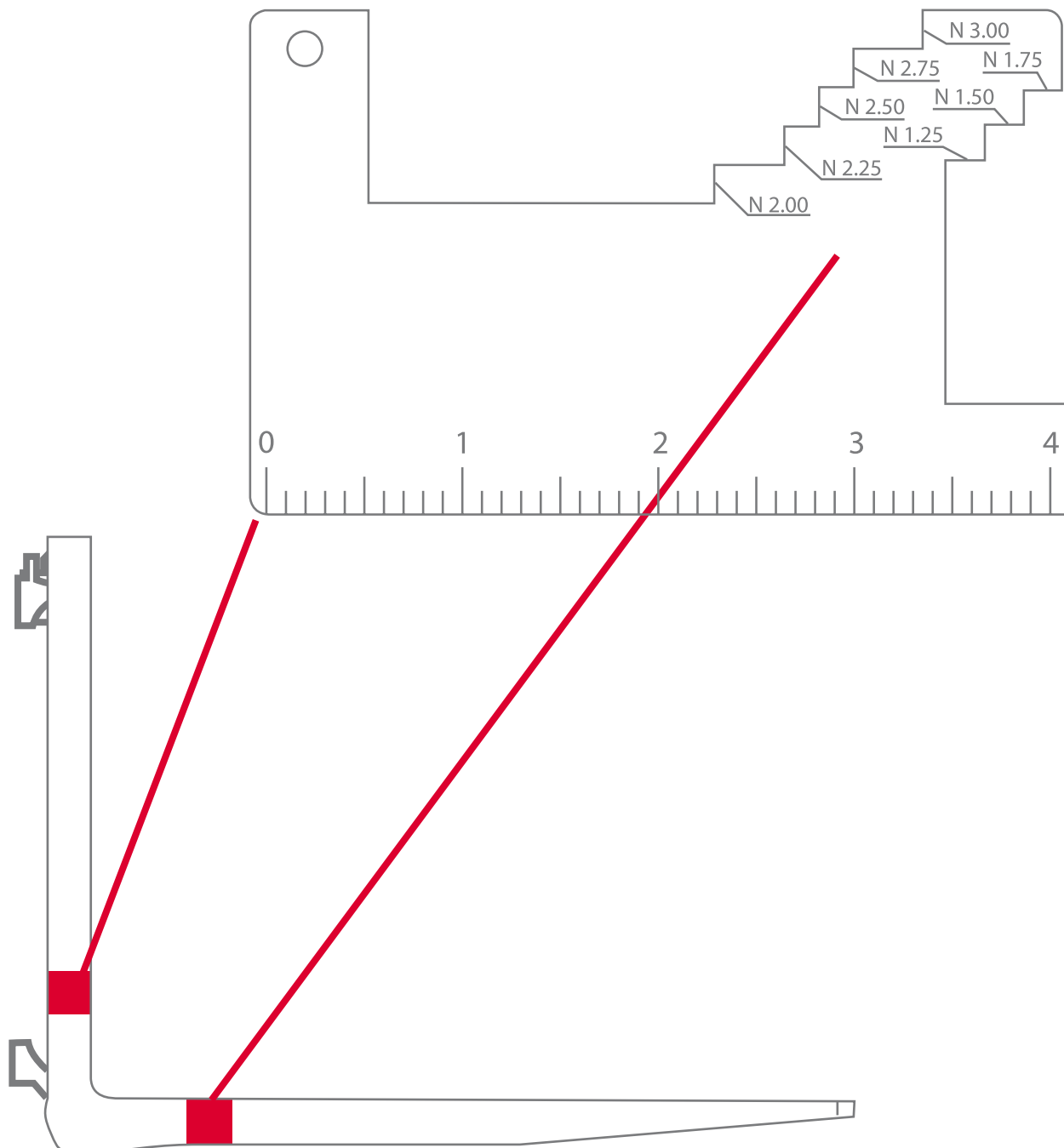
Repairs should be decided or carried out by authorized, expert personnel only, in accordance with recommendations of fork manufacturer. Do not repair surface cracks or wear by welding.

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.

The best way to inspect forks is to use a fork caliper.

1. Determine the nominal thickness of "N" of the fork. Measurement has to be done on the fork shank using the caliper ruler.
2. Position the caliper at the end of the heel internal radius with the opening corresponding to the nominal dimension "N" (eg. for N 1.75 use 1.75 inch. thickness), where the wear is higher.
3. If the fork enters the opening, it is mandatory to replace it. **DANGER OF BREAKING.** Furthermore, a 10% reduction in fork blade thickness results in 20% reduction in operating capacity.



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Quality Certification ►







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