12-Strand Class II Tuck-Bury Eye Splice for Saturn-12™

Samson Splicing Instructions

This is a modification to the standard HMPE Tuck-Bury 12-strand splice to increase splice length on Saturn-12. This modification must be used on Saturn-12 products larger than 1-1/8” in diameter.

**STEP 1**

**MEASURING AND MARKING**

Tape end to be spliced. Then measure 2 fid lengths from the bitter end and mark. This is Mark 1. Wrap tape tightly around the rope at Mark 1.

1A From Mark 1, form a loop the size of the eye desired and mark. This is Mark 2.

1B From Mark 2, measure down the rope 2-1/2 fid lengths and mark. This is Mark 3.

**STEP 2**

**TAPERING THE TAIL**

At Mark 1, pull out half the strands (3 “S” and 3 “Z”) by rotating around the rope and pulling out strands in the pattern shown:

- Z strand = counter-clockwise twist
- S strand = clockwise twist

This should leave 6 strands still braided down the middle. Tightly tape the ends of the 6 individual strands, as well as the end of the remaining braided portion.

On 1 side you should have 2 S strands and 1 Z strand. On the other side, you should have 2 Z strands and 1 S strand.

**STEP 3**

**ROUTING THE STRANDS**

3A **MARKING ENTRY AND EXIT POINTS**

At Mark 2, make a mark at the intersection of an S and a Z strand. This will be the entry point for all 6 strands and the tail when it is buried. The entry point should be on the side of the rope facing the opposite leg of the eye.

From the entry point, count 2 picks down the rope and mark 6 strands around the circumference of the rope. There will be 3 S strands and 3 Z strands marked. At each intersection of an S and a Z strand, mark an exit point. There will be 6 exit points marked.

3B **ROUTING 3 STRANDS**

The first 3 strands are now routed from the entry point at Mark 2 to the exit point. Each strand is routed separately, entering at the entry point and exiting at its own exit point. Do not pull the strands up tight yet. Leave slack at the entry point.
3C BURYING THE TAIL
Attach a fid to the end of the tapered tail and bury it from the entry point through the rope to exit beyond Mark 3. Pull the tail until Marks 1 and 2 meet. Leave the tail exposed.

3D ROUTING LAST 3 STRANDS
The 3 remaining strands are now routed from the entry point at Mark 2 to the exit point. Each strand is routed separately, entering at the entry point and exiting at its own exit point. Do not pull the strands up tight yet. Leave slack at the entry point.

With all 6 strands routed and the tail buried, pull each of the 6 routed strands to remove any slack, and make sure the rope is smooth and tight at the entry point.

3E TAPERING TAIL
At Mark 3, pull the tail out until Marks 1 and 2 meet. Pull any slack out of the 6 strands that are routed. Pull out the tail and mark 3 consecutive strands as shown. Pull out all 3 and cut off.
**STEP 4 TUCKING THE STRANDS**

The strands are now tucked into the braid of the rope. 1 complete tuck consists of passing a strand over 1 strand and under 2 strands. The tucks proceed down the same row of picks straight down the body of the rope.

4A Do 5 complete tucks for all 6 strands. Each strand is always tucked under the same line of the braid so that the tucks progress straight down the body of the rope.

4B After completing the first 5 tucks, remove 1/2 of the volume of the twisted yarns. Cut yarns from each of the 6 strands near the taped ends and complete 3 more tucks with the reduced volume strands.

**STEP 5 FINISHING THE SPLICE**

After completing the second set of 3 tucks, cut off the excess strands and tape the ends. Leave enough of an end protruding so that the end does not slip back into the rope when the rope is loaded.