



EYE SPLICE DOUBLE BRAID CLASS II

Class II (core-dependent) double braids are made in whole or part from any of the following high modulus fibers: Dyneema®, Vectran®, Technora®, and Zylon®.

The eye splice is used to place a permanent loop in the end of a rope, generally for attachment purposes to a fixed point. An eye is also used to form the rope around a thimble, which is used to protect the rope, especially when it is to be attached to a shackle, chain or wire rope.

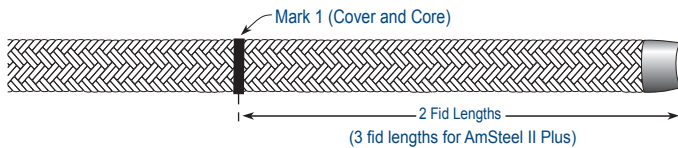
The following procedure is intended to preserve the strength of double braided rope constructions where the rope's core is the primary strength member.

Additional rope needed for splice:
 2-1/2 fid lengths plus length of eye:
 with thimble: 2-1/2 fid lengths
 plus 1/2 circ. in feet.
 (for AmSteel II Plus, 3 fid lengths.)

STEP 1

MARKING THE COVER

1A Measure 2 tubular fid lengths back from end:
 Place Mark 1 on cover and on core.
 (for AmSteel II Plus, the required bury length is 3 fids.)



Measure eye size back from Mark 1 and place Mark 2 on both the cover and core, as done with Mark 1.

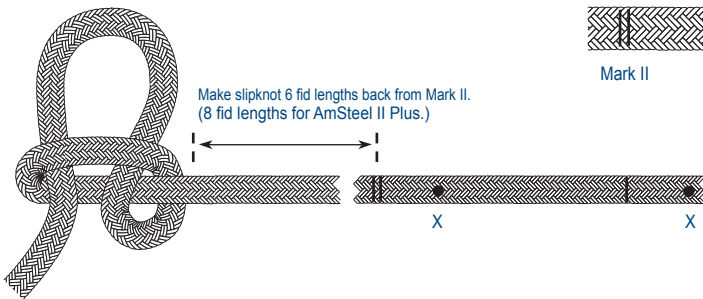
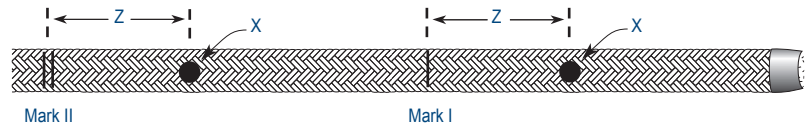
When splicing on a thimble with ears, slide thimble on and position between Mark 1 and Mark 2. Leave in place and continue with the splice. Thimble must be positioned between "X" points. (1B)

1B Mark on cover two extraction points (X), as measured by the "Z" length toward end of rope from Mark 1 and Mark 2.
 (8 fid lengths for AmSteel II Plus.)

1C Put slipknot in rope six fid lengths back from Mark 2.
 (8 fid lengths for AmSteel II Plus.)

Length of Z Section Based On Size of Rope as Follows:

Size (Dia.)	1/4"	5/16"	3/8"	7/16"	1/2"	9/16"	5/8"	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-5/16"	1-1/2"
Z Length	5"	5"	5"	5"	6"	6-3/4"	7-1/2"	8"	9"	9"	12"	12"	13"	13"
AmSteel II Plus	6-1/2"	6-1/2"	6-1/2"	6-1/2"	8"	9"	10"	10-1/2"	12"	12"	15"	15"	17-1/2"	17-1/2"



STEP 2

EXTRACTING THE CORE

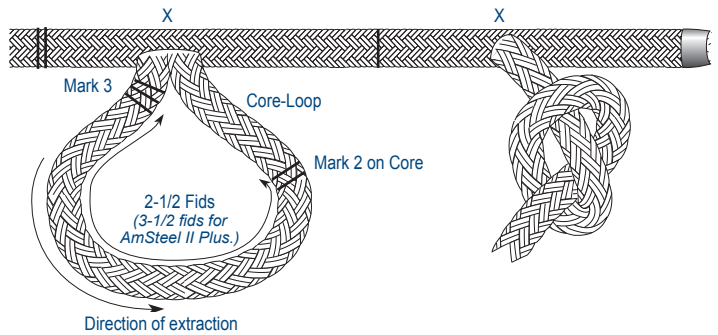
Extract core at extraction point X nearest end of rope. Put an overhand knot in core at the point where it comes out of the cover.



EYE SPLICE DOUBLE BRAID CLASS II

2A Now extract core at second core extraction point X in the form of a loop. Expose 2-1/2 fids from Mark 2 and make Mark 3. Extract from same side of rope as first extraction.
(3-1/2 fids for AmSteel II Plus.)

When using thimble with ears, move rope around thimble to expose second extraction point.

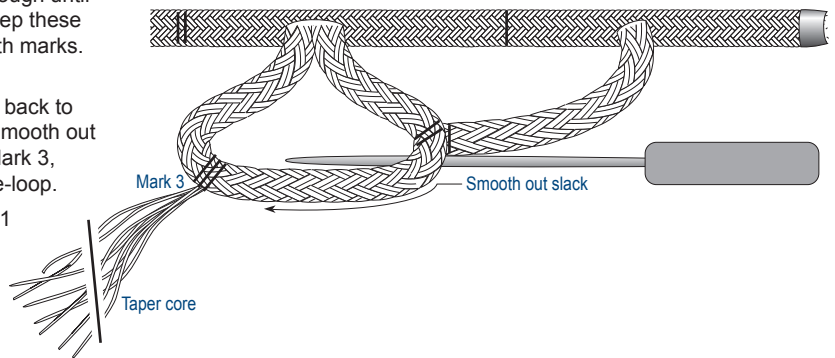


STEP 3 INSERTING CORE INTO CORE

Remove knot in core and insert core-tail into core loop at Mark 2 for 2-1/2 fid lengths. Pull core-tail through until Mark 1 on core meets Mark II on core-loop. Keep these marks together by inserting pusher through both marks.
(3-1/2 fids for AmSteel II Plus.)

Taper core tail by unbraiding core tail from end back to Mark 3. Angle cut strands to perform a taper. Smooth out slack away from Mark 2 on core-loop toward Mark 3, which will cause core tail to disappear into core-loop.

Remove pusher (inserted earlier to keep Mark 1 and Mark 2 together).

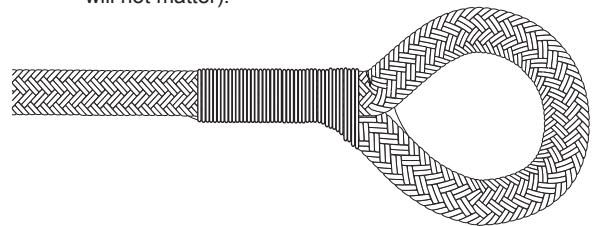


STEP 4 SMOOTHING COVER

Milk up cover completely away from slipknot and toward eye. This should bring cover up to Mark I and Mark II on core (a little over is acceptable).



4A Smooth out cover slack around eye. Extraction points X should close in and meet (a little long will not matter).



STEP 5 FINISHING THE SPLICE

Bring cover-tail down on side of rope (minimum 2 times rope circumference in inches) and lock stitch (or tape) excess cover to rope. After lock stitching, excess cover should be whipped to the neck of the rope with appropriate whipping twine.