



EYE SPLICE ROUND PLAIT CLASS I

Class I Round Plait ropes are made from any or all of the following fibers: olefin, polyester, or nylon.

The Round Plait construction requires a splicing technique different from other 12-strand braided ropes. The "tuck" procedure may be performed in the field on both new and used rope with a minimum of tools.

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.

Additional rope needed for splice:
 1-1/4 fid lengths plus length of eye;
 with thimble: 1-1/4 fid lengths plus
 1/2 circumference in feet.



FID DIMENSIONS:

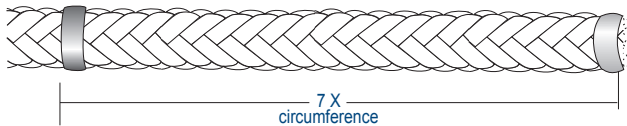
Fid Length	Wire Diameter	Width
21" (1/2 scale*)	1/4"	1-1/4"

*1/2 scale used to keep wire fids to a practical length.

Fid Specifications: A fid length is equal to 7 times the rope circumference. To complete the splice a Samson 2" diameter wire fid may be used for most rope sizes. The dimensions of this fid are:

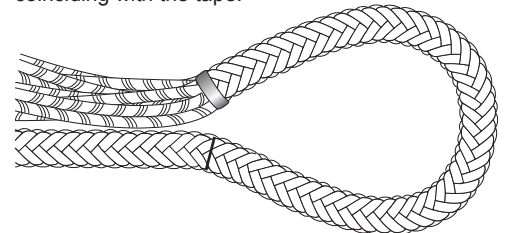
STEP 1 MEASUREMENT

Lay out the rope and measure down from the end of the rope a length that is equal to 7 times the rope circumference. At this point put one loose wrap of tape around the rope.



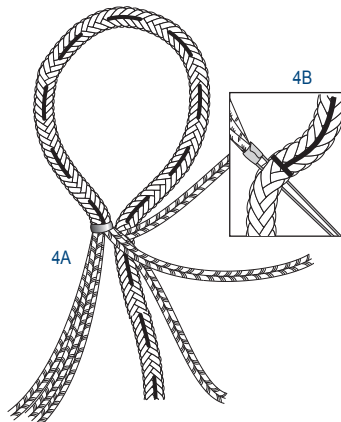
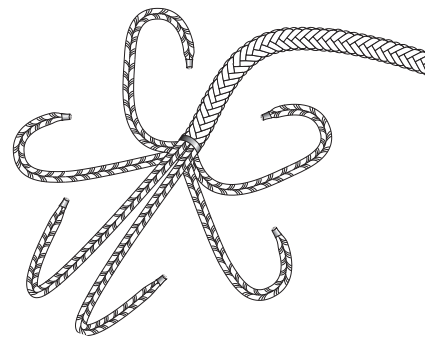
STEP 2 MARKING EYE SIZE

Individually tape each of the 12-strand ends at the end of the rope. After the ends are taped, unbraided the rope back to the point wrapped with tape in Step 1. Form the desired eye size using the tape wrapped around the rope as a reference mark. Mark the body of the rope at the point coinciding with the tape.



STEP 3 TAPE STRAND PAIRS

Combine the 12 individual strands into six pairs of two strands each. The strands that are paired together should be adjacent to each other at the point where the unbraided rope meets the tape wrapped around the rope. If done correctly, there should be one "S" strand (strand with clockwise twist) and one "Z" strand (strand with counterclockwise twist) in each pair. Before taping the two strands together, twist each strand separately to maintain the twist of the fiber.



STEP 4 INSERT STRAND PAIRS INTO BODY OF ROPE

Lay out the rope to form an eye taking care there are no twists in the rope (4A). The black line running along the axis of the rope illustrates how the strand pairs are separated for the splice. The 3 strand pairs on one side of the line adjacent to the standing part of the rope will be passed directly through the body of the rope. The 3 strand pairs must be passed directly through the middle of the rope to the other side (4B).

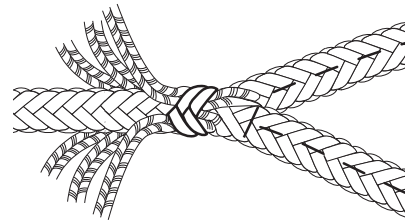


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STEP 5

BEGIN TUCKS

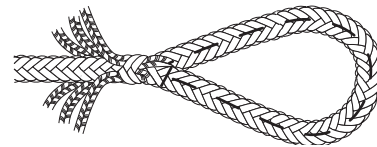
After the 3 strand pairs have been passed through the body of the rope you can start tucking the strand pairs into the braid of the standing part of the rope. One complete tuck consists of passing a strand pair under two individual strands in the braid and over one strand. Each strand pair is always tucked under the same line of braid so that the tucks progress straight down the body of the rope.



STEP 6

REMOVING SLACK FROM FIRST TUCK

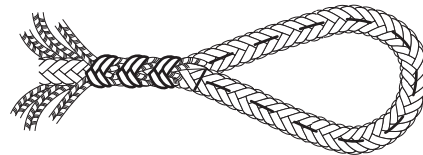
After one complete tuck has been made with each of the six strand pairs, pull on each pair to remove any slack from the strands and snug-up the base of the eye. Note: When pulling the strand pairs, do not attempt to pull them so tight that they become straight. It is desirable to leave the tucked strands with some twist in them so they have the necessary elongation when the rope is placed under load.



STEP 7

COMPLETE TUCKING PROCEDURE

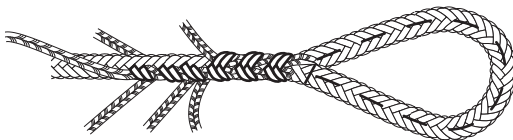
Do 3 complete tucks with all 6 strand pairs. Each strand pair is always tucked under the same line of the braid so that the tucks progress straight down the body of the rope.



STEP 8

TAPERING THE SPLICE

After completing the first 3 tucks drop every other strand pair and continue to do three more tucks with the remaining 3 pairs.



STEP 9

FINISHING THE SPLICE

After completing the second set of 3 tucks, untape the 3 strand pairs used to make these tucks. Drop one strand from each pair and do at least 2 more tucks with the remaining single strand of each pair. Once you have completed the last tucks, cut off the excess material and tape or whip the ends. Leave enough of an end protruding so that the end does not slip back into the rope when the rope is loaded.

