

## SAMSON SPLICING INSTRUCTIONS

# 12-Strand Class II Long Taper Eye Splice

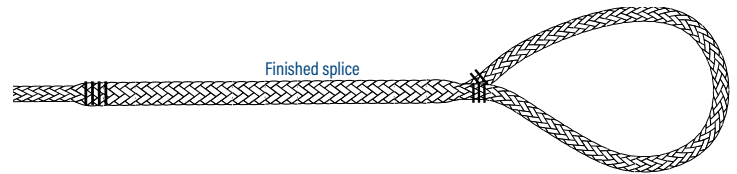
FOR AMSTEEL<sup>®</sup>ECO, EVERSTEEL<sup>®</sup>X, AND SURESTEEL<sup>™</sup>



Class II ropes are made in whole or part from any of the following high modulus fibers: HMPE, LCP, Aramid and PBO.

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.

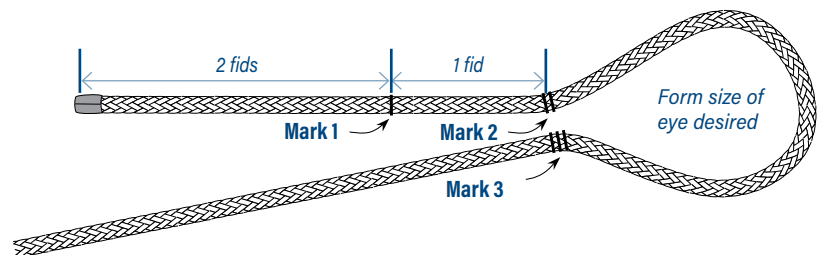
This eye splice may be performed on new or used rope. This is an all-purpose splice technique designed for people who generally splice used rope as frequently as new rope. By following the procedure below, the splice can retain from 90% to 100% of average new rope strength and in used rope up to the same proportion of residual used rope strength.



## STEP 1 MEASURING

Tape end of line to be spliced and measure 2 tubular fid lengths from taped end of line and make Mark 1.

From Mark 1 measure 1 tubular fid length and make Mark 2. Now form size of eye desired and make Mark 3.

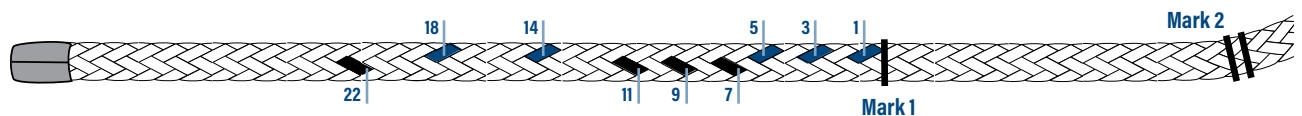


## STEP 2 MAKING TAPER

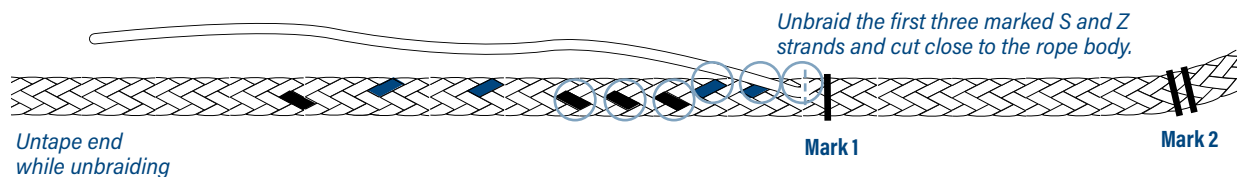
**2A** Counting from Mark 1 toward the bitter end mark these five S strands: 1st, 3rd, 5th, 14th and 18th.

Counting from Mark 1 toward the bitter end mark these four Z strands: 7th, 9th, 11th and 22nd.

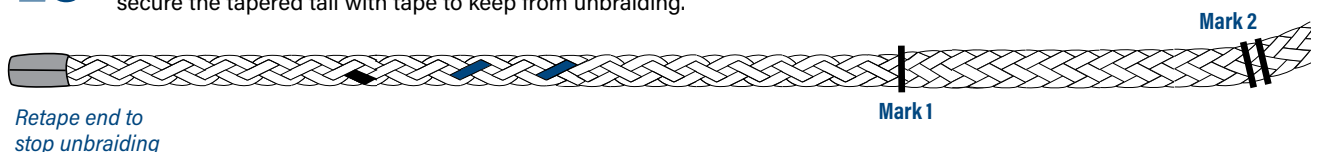
*NOTE: Some rope diameters may have pairs of strands in right and left direction. In this case, treat the pairs of strands as a single strand, marking and cutting both in each direction as described.*



**2B** Pull the first three marked S strands (1, 3, and 5) and the first three marked Z strands (7, 9, and 11) out of and cut to create the taper. The end may need to be untaped to remove the marked strands.



**2C** The tapered end will now have 6 strands remaining. Tightly secure the tapered tail with tape to keep from unbraiding.



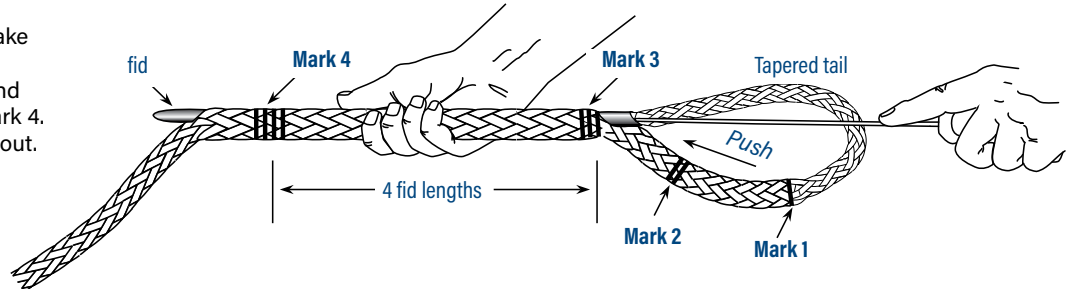
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## STEP 3 BURYING TAIL INTO STANDING PART OF LINE

Measure 4 tubular fid lengths from Mark 3, make Mark 4. Insert fid and tapered tail at Mark 3 and bring fid out beyond Mark 4. Pull fid and tapered tail out. Do not let the line twist.

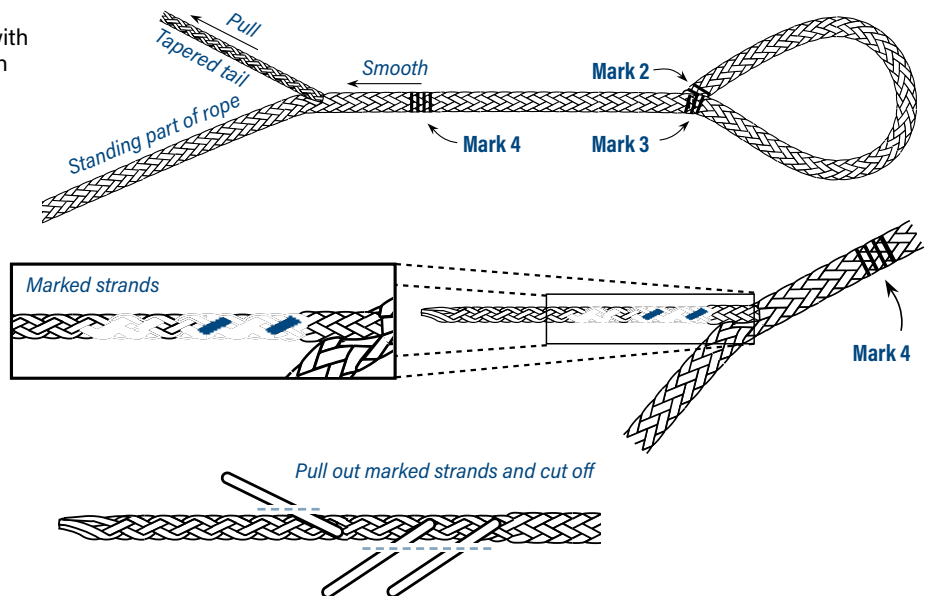


## STEP 4 FINISHING BURYING

Remove fid. Pull hard on tapered tail with one hand. With the other hand, smooth bunched line towards eye splice until Marks 2 and 3 converge.

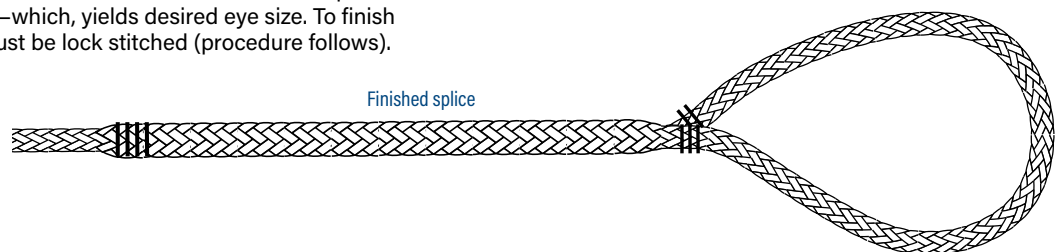
**4A** Remove the fid and any tape at the end of the tail. Pull remaining three marked strands out of the tail and cut off close to the body of the rope.

**4B** Now, using both hands and the weight of your body, smooth the cover slack from Mark 3 towards Mark 4. The tail will disappear into the rope, and a smooth, gradual taper should result. This should be done a minimum of three times.



## STEP 5 FINISHING THE EYE SPLICE

When finished, Mark 2 and Mark 3 should be at the same point at the vertex of the eye—which, yields desired eye size. To finish eye splice, the splice must be lock stitched (procedure follows).



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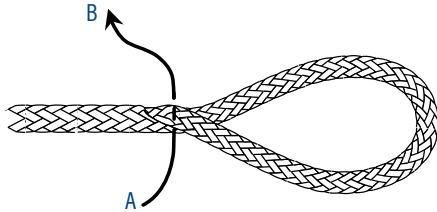
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## Lock Stitching Procedure

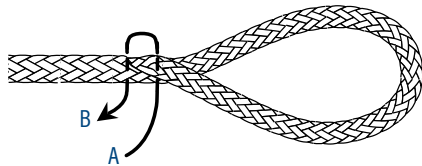
### STEP 1

Start the stitching twine just below the entry point of the splice and pass it directly through to the other side. The stitching should start no farther than 1/4 fid length below the entry point, as shown.



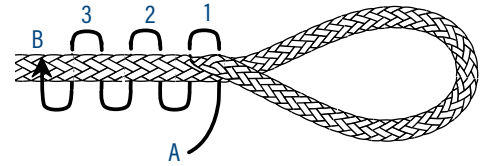
### STEP 2

Reinsert twine through the rope. The twine should cover 2 rope picks from the exit point. Pull the twine snug, but not tight.



### STEP 3

Continue to reinsert as shown until you have at least 3 complete stitches on each side of the rope. Each stitch should cross over 2 rope picks.



### STEP 4

After stitching 3 complete stitches on 2 sides of the rope take the bitter ends of the stitching twine and tie a square knot as close to the rope as possible. Bury the square knots into the rope between the rope picks directly where the twine enters the rope. After the knots are buried, cut off any remaining twine sticking out.

