

Dynaplus™ & Calibre™ Eye Splice

PRODUCT-SPECIFIC CLASS II DOUBLE BRAID

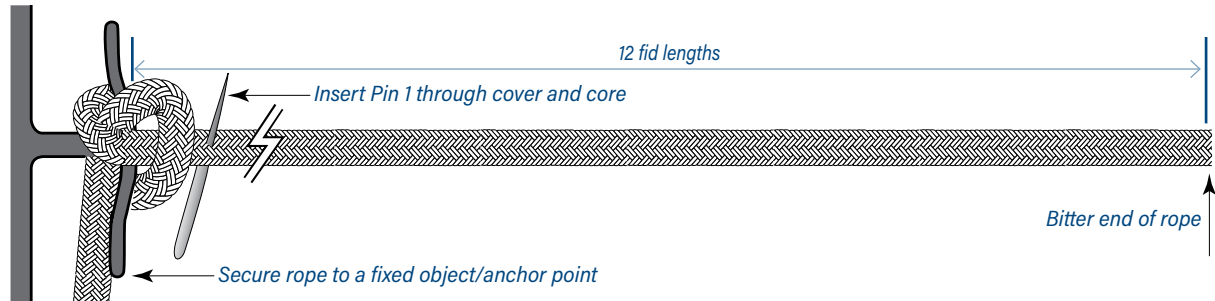


This is a modification to the standard Double Braid Class II eye splice for Dynaplus™ and Calibre™ ropes only. For other Samson double braid rope splice instructions visit SamsonRope.com/resources/how-to-splice-rope.

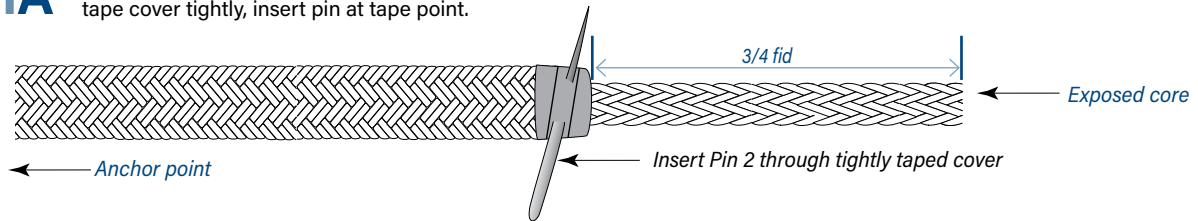
Note: Fid length for measurement purposes is 21 x rope diameter.

STEP 1 PREPARING THE ROPE

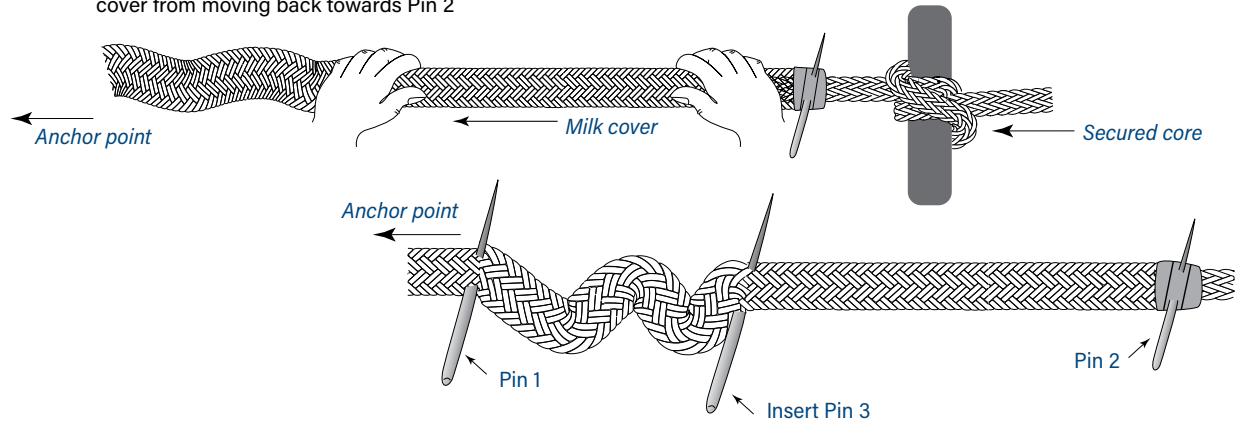
Tie the rope to a fixed object approximately 12 fid lengths from the end, then insert Pin 1 through cover and core near anchor point.



1A Slide end of cover back from end of core. Measure 3/4-fid length from end of exposed core, tape cover tightly, insert pin at tape point.

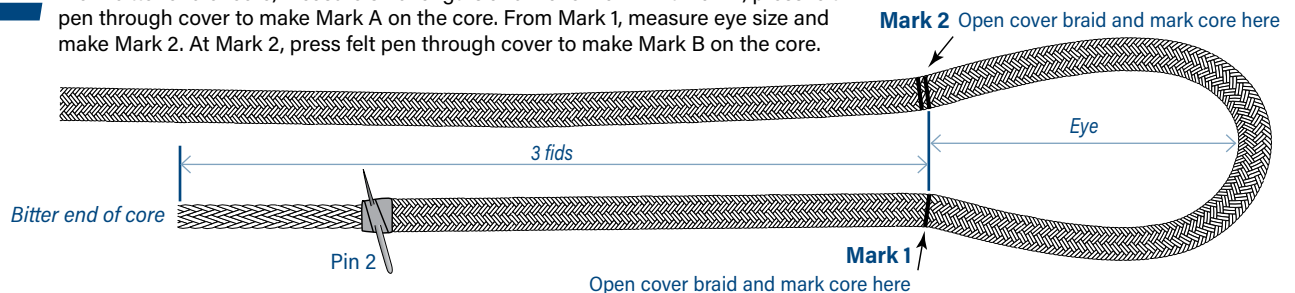


1B Tie exposed core to an anchor point. Use a milking strap, milk cover slack from Pin 2 towards Pin 1 until cover slack is bunched up against Pin 1. Insert Pin 3 through cover and core before bunched up cover section, keep cover from moving back towards Pin 2



STEP 2 MEASURING AND MARKING

From bitter end of core, measure 3 fid lengths and make Mark 1. At Mark 1, press felt pen through cover to make Mark A on the core. From Mark 1, measure eye size and make Mark 2. At Mark 2, press felt pen through cover to make Mark B on the core.



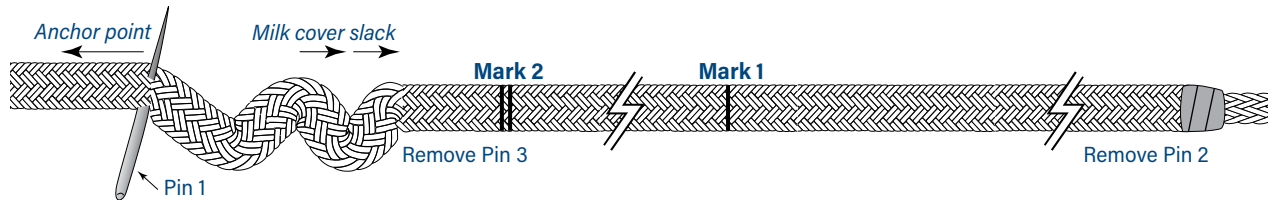
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STEP 2 MEASURING AND MARKING (CONTINUED)

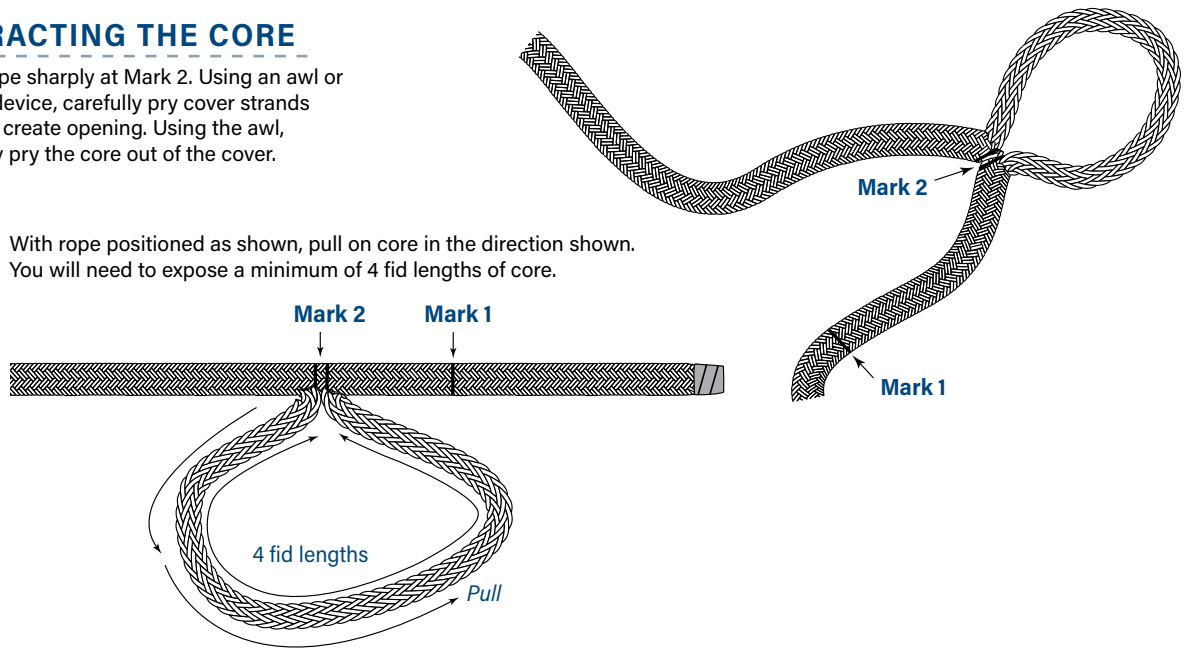
2A Remove Pin 2 and Pin 3. Then milk cover slack back towards Mark 2.



STEP 3 EXTRACTING THE CORE

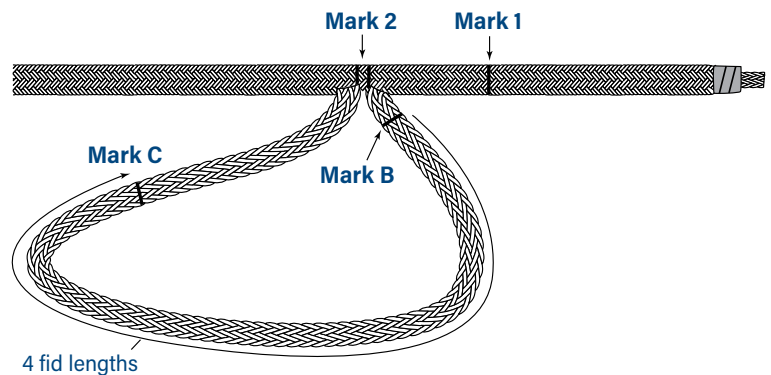
Bend rope sharply at Mark 2. Using an awl or similar device, carefully pry cover strands apart to create opening. Using the awl, carefully pry the core out of the cover.

3A With rope positioned as shown, pull on core in the direction shown. You will need to expose a minimum of 4 fid lengths of core.



STEP 4 MARKING THE CORE

Find Mark B on the core made previously through the cover at Mark 2. From Mark B measure back a distance of 4 fid lengths, make Mark C.



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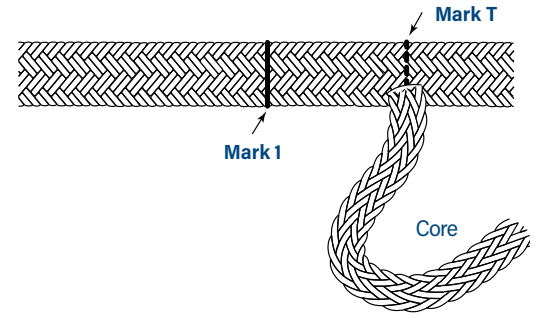
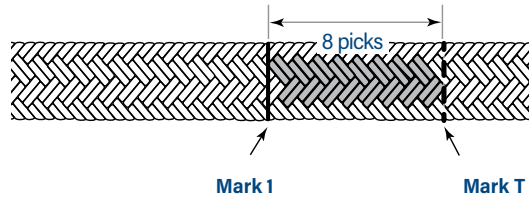
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STEP 5 TAPERING THE COVER

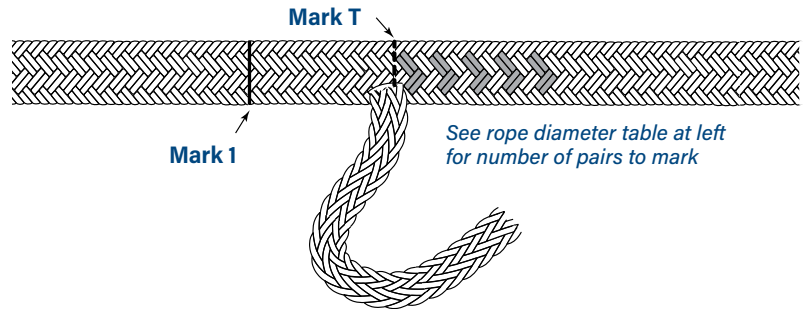
From Mark 1 on cover, count 8 picks (pairs of right and left laid strands) in the direction of Mark 1 and make Mark T.

Extract core from cover at Mark T and pull completely free.



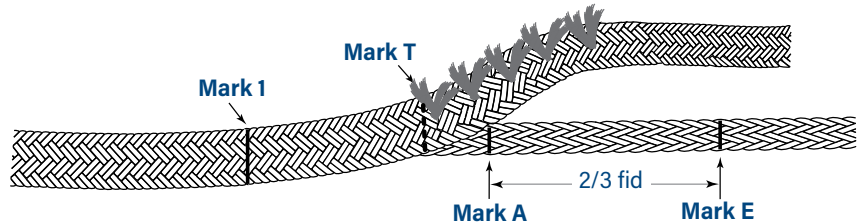
5A Starting at Mark T on the side of the cover opposite from the core extraction point, mark every other right and left laid strand pair for a distance of 5, 6, or 8 pairs, depending on rope diameter:

ROPE DIAMETER	MARK
1/2" - 5/8"	5 Pairs
12 mm - 16 mm	
3/4" - 1-1/2"	6 Pairs
18 mm - 36 mm	
1-5/8" & up	8 Pairs
40 mm & up	



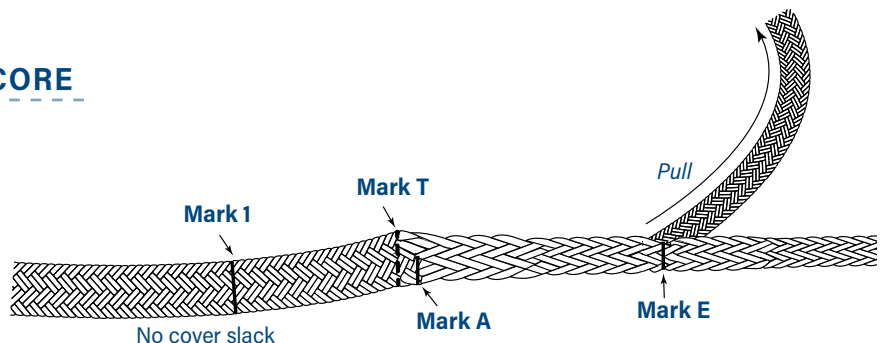
5B Reduce cover tail to half volume by cutting and removing the marked strand pairs. Milk cover towards exit point of core.

From Mark A, measure down the core a distance of 2/3 fid length, and make Mark E.



STEP 6 INSERTING COVER INTO CORE

Using a tubular fid, insert half volume cover tail into core tail at Mark A and exit at Mark E. Pull cover tail to tighten up cover/core crossover.



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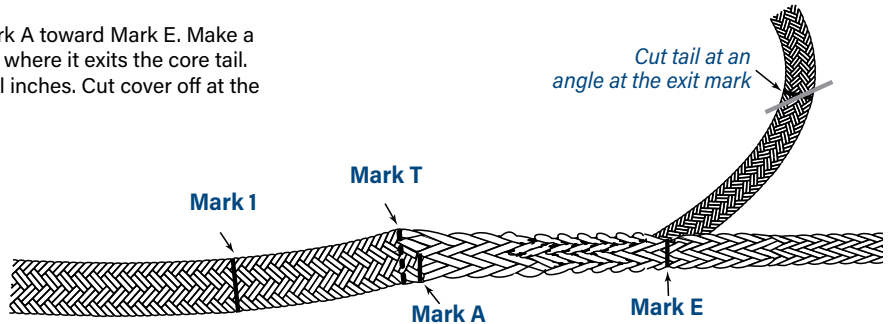


STEP 6 INSERTING COVER INTO CORE (CONTINUED)

6A Thoroughly milk core tail from Mark A toward Mark E. Make a mark on the half volume cover tail where it exits the core tail. Pull on cover tail to expose several inches. Cut cover off at the exit mark with an angled cut.

Cut tail at an angle at the exit mark

6B Milk core tail from Mark C to Mark D, until cover is buried into the core.



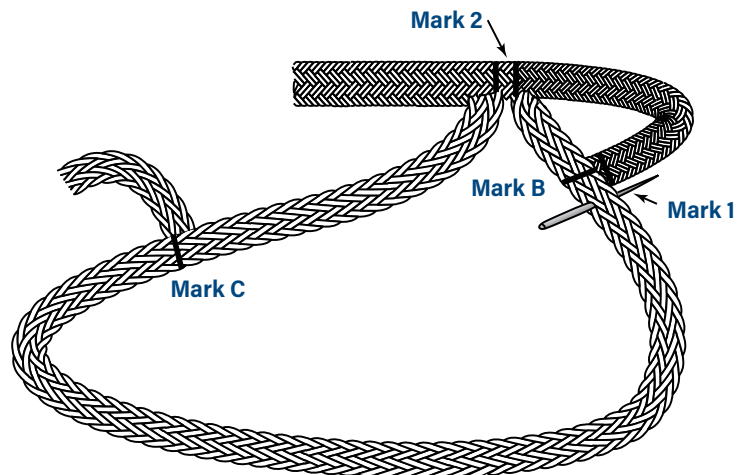
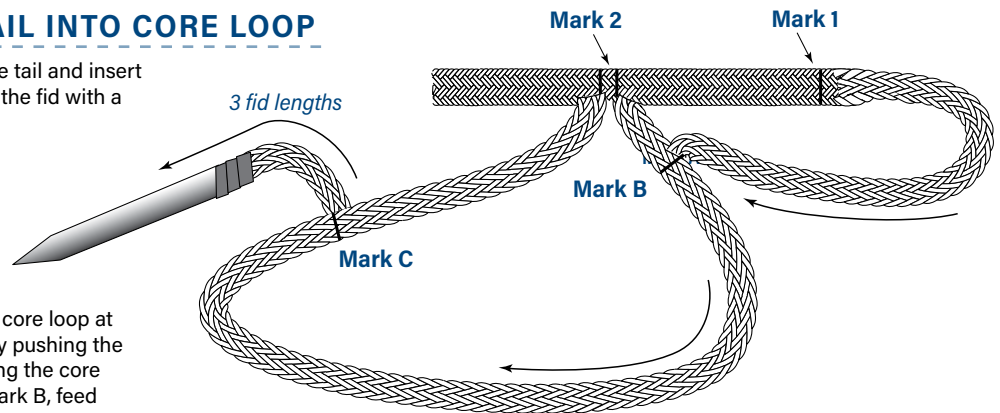
STEP 7 BURYING CORE TAIL INTO CORE LOOP

Tightly tape the end of the core tail and insert into fid. Secure the core tail to the fid with a wrap of tape.

Note: When splicing thimble eye, slide thimble in place between Marks 1 and 2 before attaching fid.

7A Insert the fid into the core loop at Mark B. By alternately pushing the fid forward and milking the core loop back towards Mark B, feed the fid and core tail through the core loop and bring out at Mark C.

7B Pull core tail through core loop until Mark 1 on cover meets Mark B on core loop. Place pin at crossover of Mark 1 and Mark A.



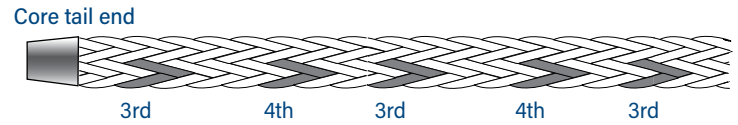
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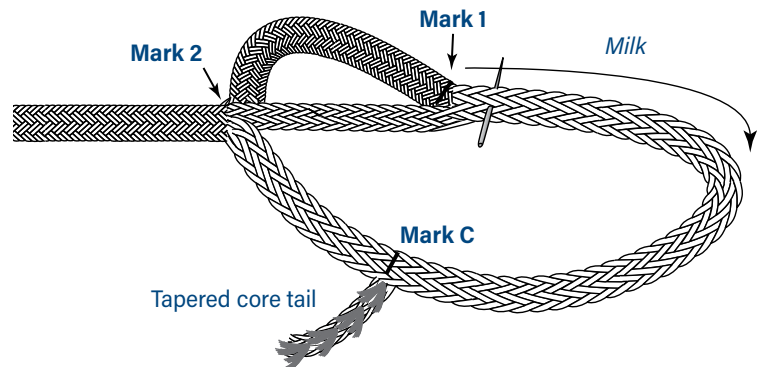
STEP 8 TAPERING THE CORE

Pull end of core tail to expose approximately 2/3 fid length of core tail. Remove fid and all tape from end of tail. From end of core tail, count 3 strands and mark a right and a left strand. From marked strands, count 4 strands and mark a right and left strand. Alternately mark third right and left strands then 4th right and left strands until a total of 5 right and left pairs have been marked. Taper core by cutting and removing marked strands.

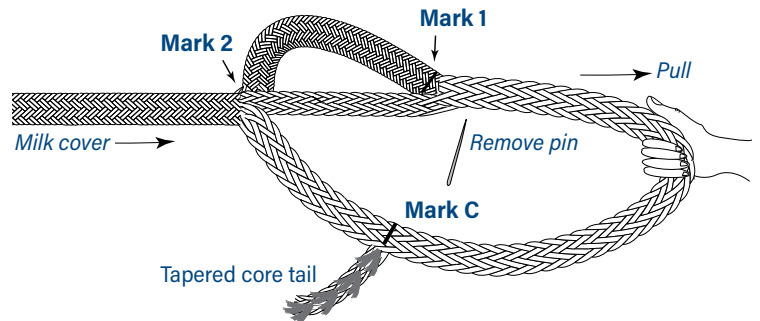


STEP 9 FINISHING THE SPLICE

With rope positioned as shown, milk core loop away from pin, working slack toward Mark C. Hold core loop as shown and pull sharply. This will set the core and cause the core tail to disappear inside the core loop. Repeat milking and pulling until all slack is removed from core loop.



9A Remove the pin. Create tension on core loop by pulling on it with one hand, then begin to milk cover up over splice area with other hand. On larger sizes, mechanical tension may be required. Continue cover milking until Marks 1 and 2 come together.



9B After the cover is completely milked and the core loop is fully buried, there may be a small loop of core material protruding from the cover at Mark 2. Milk the cover around the eye towards the core material and pull sharply on eye.* Excess core material should disappear inside of eye.

**May require an HMPE milking strap.*

