



Double Braid Class II Eye Splice for TS-II™ / TS-II Premium™



For all measurements use fid 1 size larger than rope.

Note: For 1/2" use 9/16" fid, for 5/8" use 3/4" fid, etc.

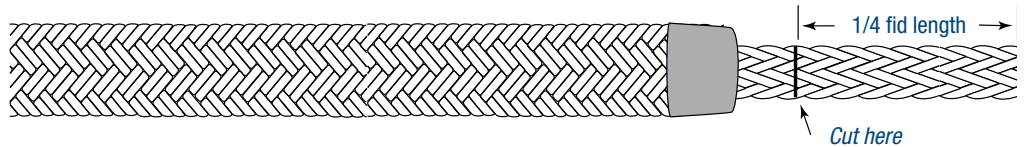
Note: Fid length for measurement purposes is 21 x rope diameter.

Example: For 5/8" rope use 3/4" fid.
Fid length = .75 x 21 or 15.75"

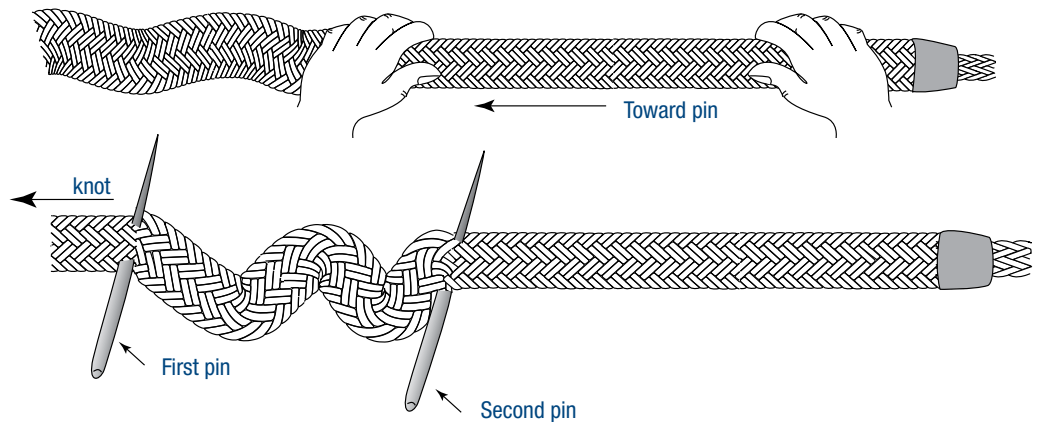
STEP 1 PREPARING THE ROPE

Tie the rope to a fixed object approximately 12 fid lengths from the end, then place pin through cover and core near knot.

1A Slide taped end of cover back from end of core. Measure 1/4 fid length from end of exposed core and make a mark. Cut core off at mark.

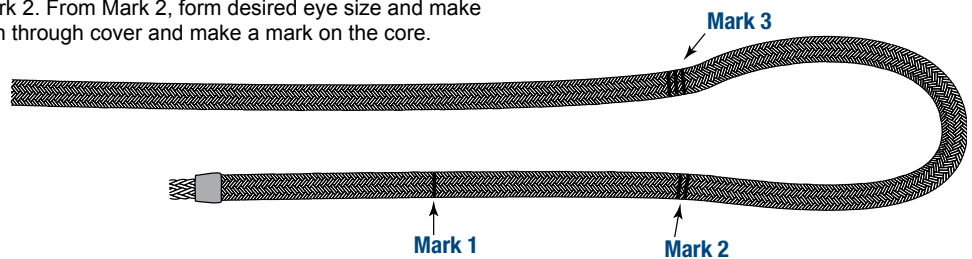


1B Leaving a small amount of core protruding from cover, grasp the taped end tightly with one hand, and with the other hand milk the cover back towards the pin. Pin back cover slack. Place second pin to hold back cover slack.

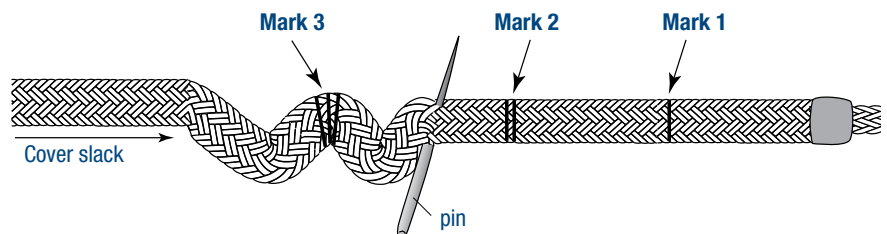


STEP 2 MEASURING AND MARKING

From taped end, measure 1 fid length and make Mark 1. From Mark 1, measure another fid length and make Mark 2. From Mark 2, form desired eye size and make Mark 3. At Mark 3, press felt pen through cover and make a mark on the core.



2A Straighten the rope out and place a pin through cover and core between Marks 2 and 3. Remove the pin holding back the extra cover slack and milk the cover slack back towards Mark 3.





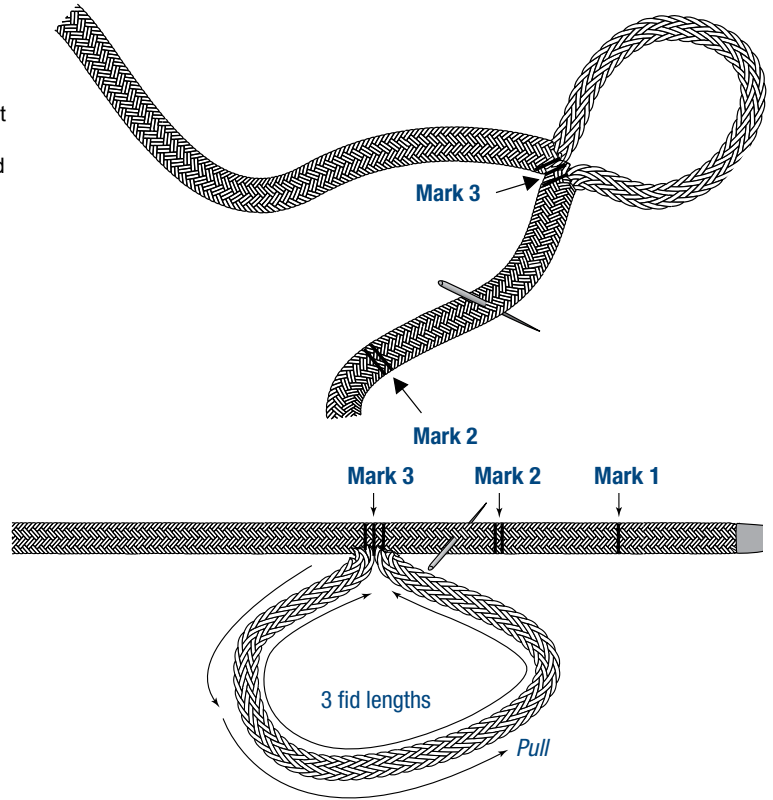
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STEP 3 EXTRACTING THE CORE

Bend rope sharply at Mark 3. Using an awl or similar device, carefully pry the cover strands apart to create an opening. Using the awl, carefully pry the core out of the cover. Make sure the pin placed between Marks 2 and 3 stays in place.

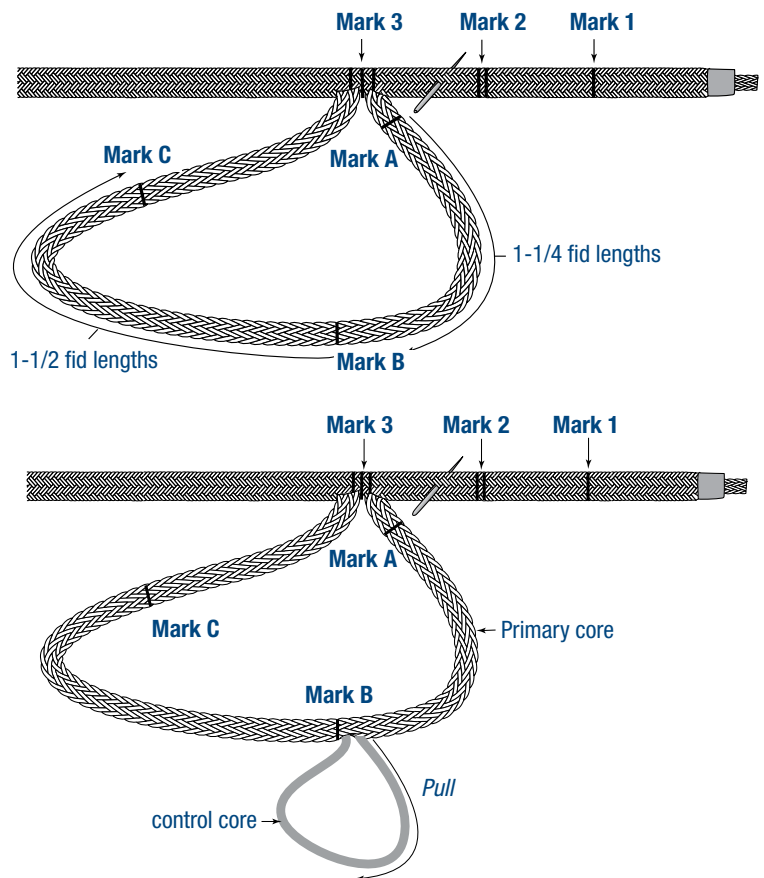
3A With rope positioned as shown, pull on core in the direction shown. You will need to expose a minimum of 3 fid lengths of core.



STEP 4 MARKING THE CORE

Find the mark on the core made previously through the cover at Mark 3. This is Mark A. From Mark A, measure back a distance of 1-1/4 fid lengths, make Mark B. From Mark B, measure back a distance of 1-1/2 fid lengths and make Mark C.

4A Bend the primary (load bearing) core sharply at Mark B. Carefully pry the strands apart to expose the control (inner) core. Carefully pry the control core out of the primary core, and pulling in the direction shown, completely remove it.

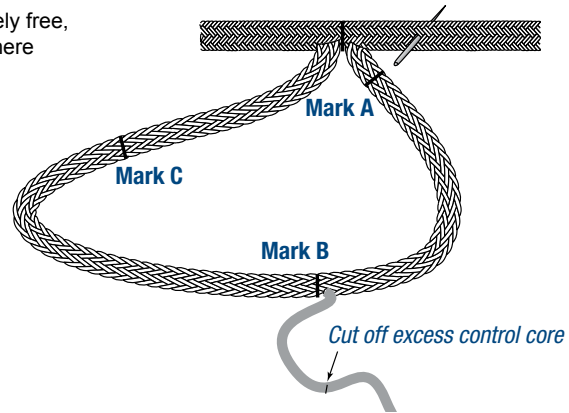




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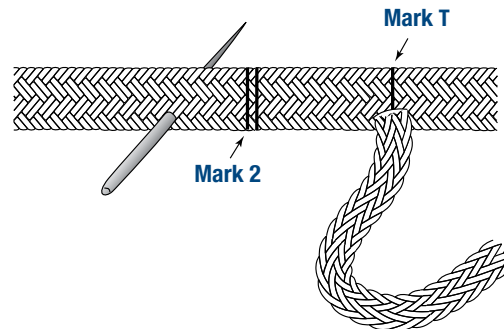
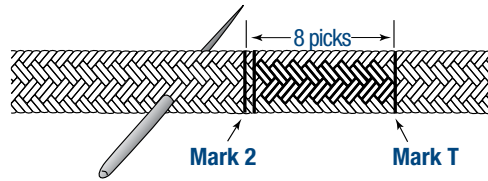
4B After the control core has been pulled completely free, cut off the excess approximately 1 foot from where it protrudes from the primary core.



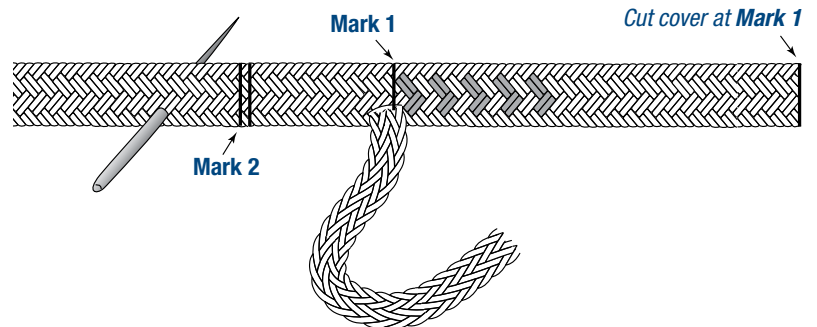
STEP 5 TAPERING THE COVER

From Mark 2 on cover, count 8 picks (pairs of right and left laid strands) in the direction of Mark 1 and make Mark T.

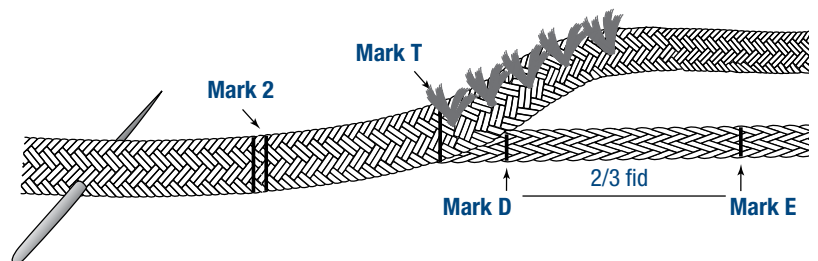
Extract core from cover at Mark T and pull completely free.



5A Cut cover at Mark 1. 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 (1/2" through 5/8" diameter, mark 5 pairs, 3/4" through 1-1/2" diameter, mark 6 pairs. 1-5/8" diameter and above mark 8 pairs.)



5B Reduce cover tail to 1/2 volume by cutting and removing the marked strand pairs. Milk cover from pin placed between Marks 2 and 3 towards exit point of core tail. Make Mark D on the core at its exit point. From Mark D, measure down the core a distance of 2/3 fid length, and make Mark E.



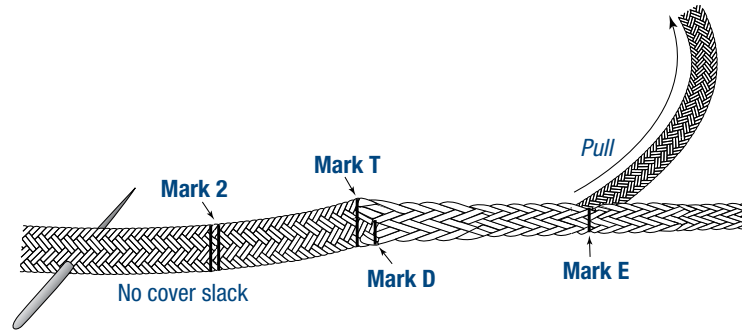


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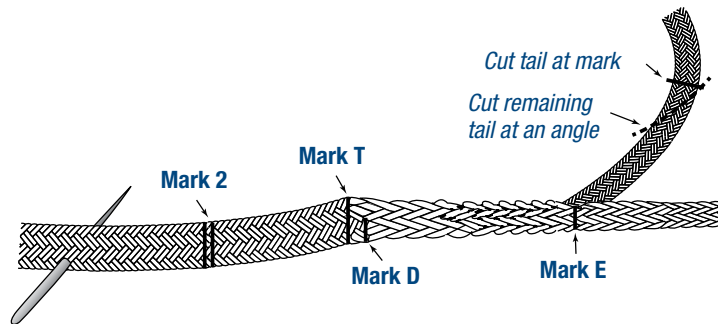
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STEP 6 INSERTING COVER INTO CORE

Using a tubular fid, insert 1/2 volume cover tail into core tail at Mark D, and exit at Mark E. Make sure there is no cover slack between the pin and Mark T, then pull cover tail to tighten up cover/core crossover.



6A Thoroughly milk core tail from Mark D to Mark E. Make a mark on the 1/2 volume cover tail where it exits the core tail. Pull on cover tail to expose several inches. Cut cover tail off at the exit mark and perform angle taper.



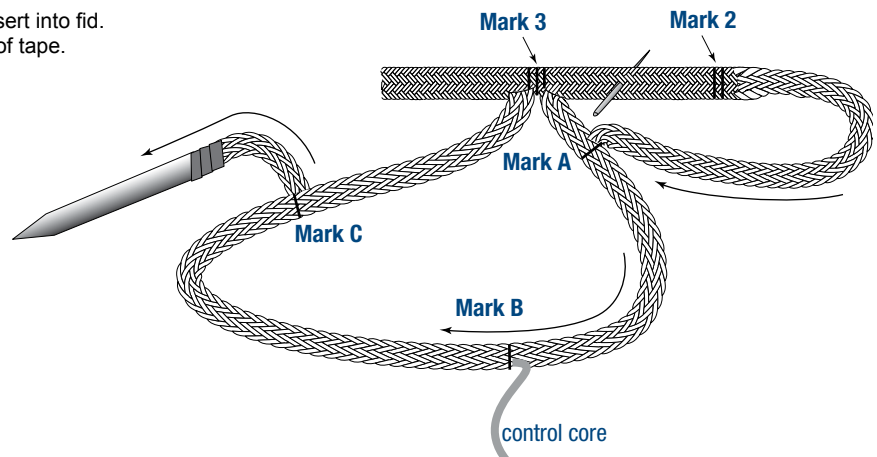
6B Re-milk core tail from Mark D to Mark E. Cover tail should disappear inside core tail. You are now ready to bury the core tail into the core loop.

STEP 7 BURYING CORE TAIL INTO CORE LOOP

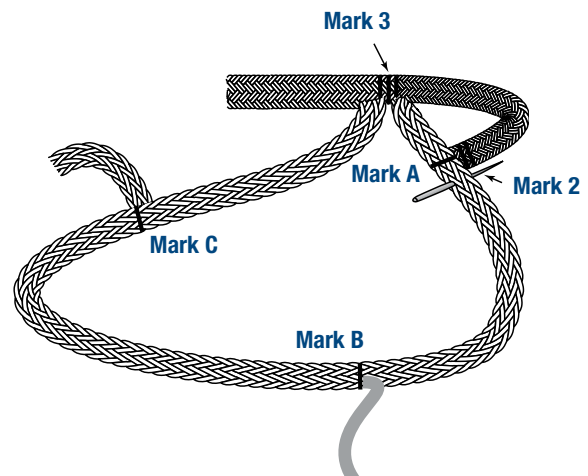
Tightly tape the end of the core tail and insert into fid. Secure the core tail to the fid with a wrap of tape.

Note: When splicing thimble eye, slide thimble in place between Marks 2 and 3 before attaching fid.

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



7B Pull core tail through core loop until Mark 2 on cover meets Mark A on core loop. Remove pin between Marks 2 and 3, and place through core loop at junction of Mark 2 and Mark A.



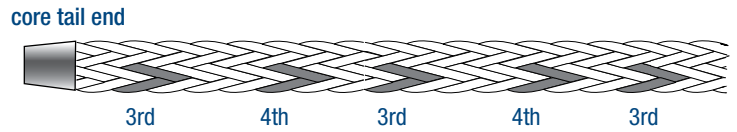


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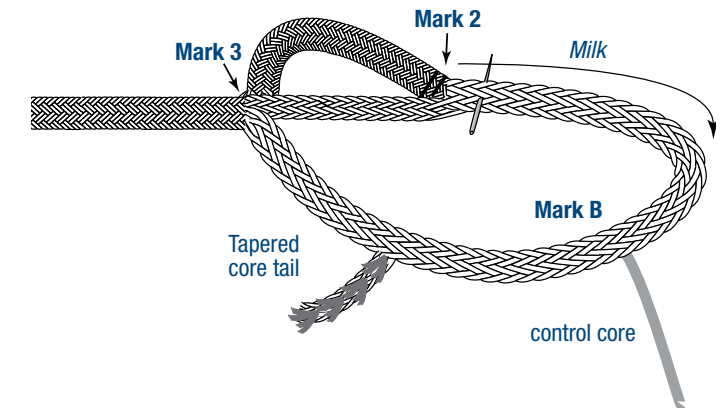
STEP 8 TAPERING THE CORE

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.

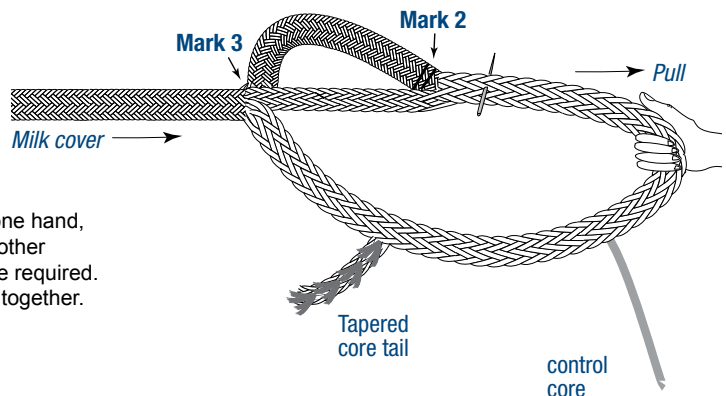


STEP 9 FINISHING THE SPLICE

With rope positioned as shown, milk core loop away from pin, working slack beyond Mark B where control core exits primary core. Hold core loop as shown and pull sharply. This will set the position of the control core and cause the core tail to disappear inside the core loop. Repeat milking and pulling until all slack is removed from core loop.

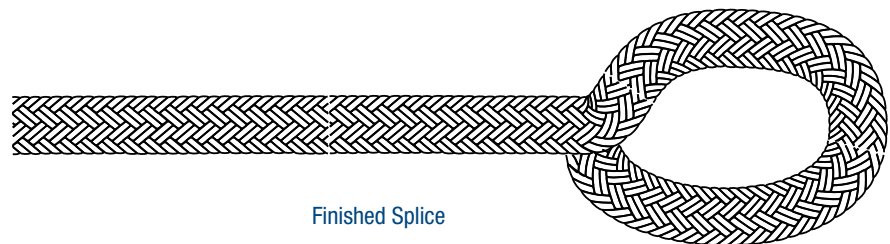


9A Mark control core right where it exits the core loop. Pull control core out slightly, then cut off just short of the mark. Repeat previous step one final time to seat control inside of core loop. Remove the pin.



9B 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 2 and 3 come together.

9C 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 3. Milk the cover around the eye towards the core material and pull sharply on eye. Excess core material should disappear inside of eye.



Finished Splice