

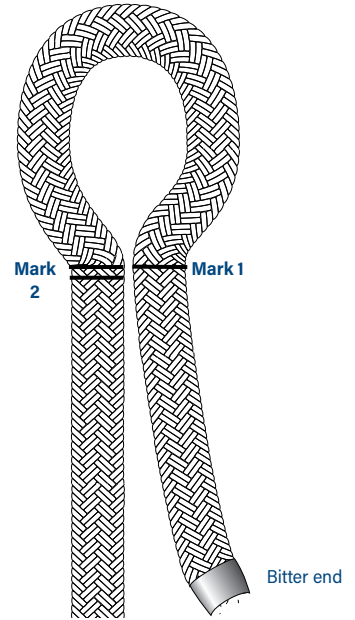


Double Braid Class II Eye Splice

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

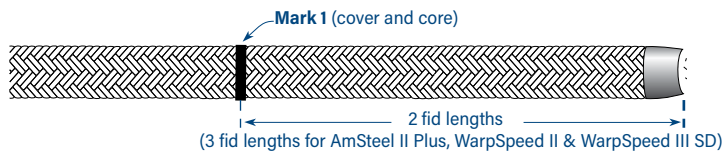
The eye splice is used to place a permanent loop in the end of a rope, generally for attachment purposes to a fixed point. An eye is also used to form the rope around a thimble, which is used to protect the rope, especially when it is to be attached to a shackle, chain or wire rope.

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



STEP 1 MARKING THE COVER

1A Measure 2 tubular fid lengths back from bitter end: Place Mark 1 on cover and on core.
(For AmSteel® II Plus, WarpSpeed® II & WarpSpeed® III SD: 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 (see Step 1B).

1B From Mark 1 on the cover, going towards the end of the rope, measure Z length 1 and make a mark at extraction Point X1.

From Mark 2 on the cover, going towards the end of the rope, measure Z length 2 and make a mark at extraction Point X2.

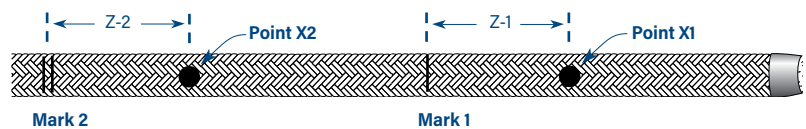
LENGTH OF Z SECTION BASED ON SIZE OF ROPE IS AS FOLLOWS:

Double Braid Class II Ropes (including AmSteel® II)

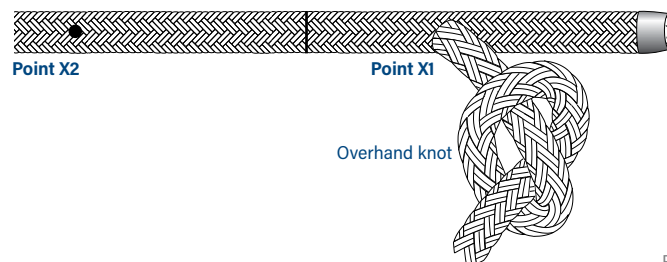
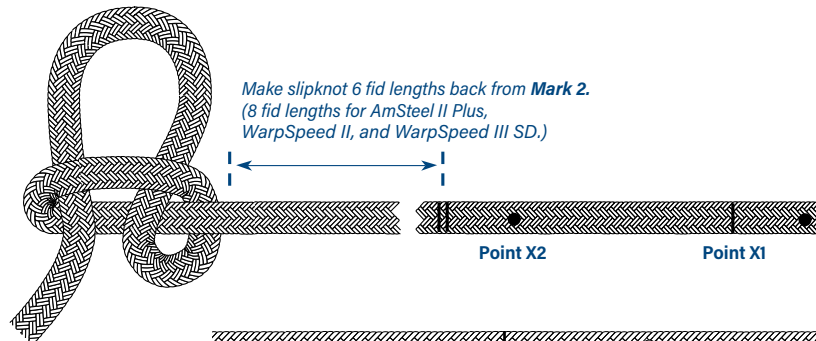
Size (Dia.)	1/4"	5/16"	3/8"	7/16"	1/2"	9/16"	5/8"	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-5/16"	1-1/2"
Z Length 1	5-1/2"	5-1/2"	5-1/2"	5-1/2"	5-1/2"	6-1/2"	7-1/2"	8"	10-1/2"	12"	13-1/2"	14"	15"	15"
Z Length 2	4-1/2"	4-1/2"	4-1/2"	4-1/2"	4-1/2"	5-1/2"	6-1/2"	7"	9-1/2"	11"	12-1/2"	13"	14"	14"

AmSteel® II Plus / WarpSpeed® II / WarpSpeed® III SD

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 1	7"	7"	7"	7"	7"	8-1/2"	9"	10"	14"	16"	18"	18-1/2"	20"	20"
Z Length 2	6"	6"	6"	6"	6"	7-1/2"	8"	9"	13"	15"	17"	17-1/2"	19"	19"



1C Put a slipknot or pin in the rope 6 fid lengths back from Mark 2.
(8 fid lengths for AmSteel® II Plus, WarpSpeed® II, and WarpSpeed® III SD.)



STEP 2 EXTRACTING THE CORE

Extract core at Point X1 nearest end of rope. Put an overhand knot in core at the point where it comes out of the cover.

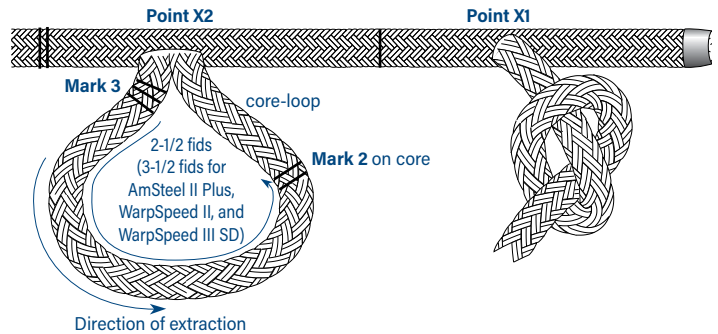


Double Braid Class II Eye Splice

2A Now extract core at Point X2 in the form of a loop. Expose 2-1/2 fids from Mark 2 and make Mark 3. (3-1/2 fids for AmSteel II Plus, WarpSpeed II, and WarpSpeed III SD.)

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

NOTE: If the cover is too tight, extract the core at point X2 and using a fid, rebury at X2 and extract the core from point X1.

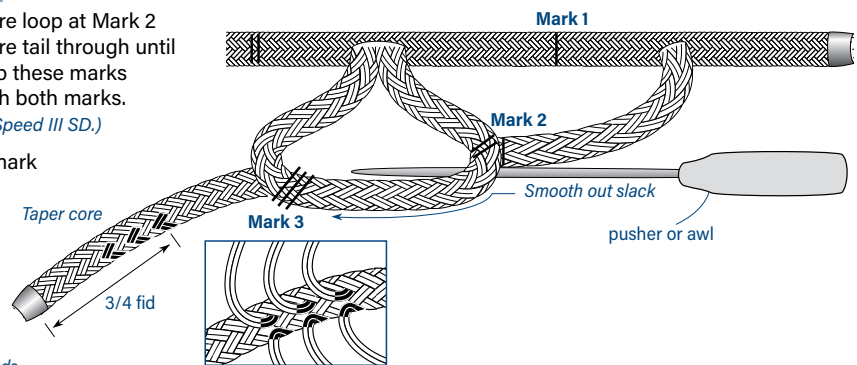


STEP 3 INSERTING CORE INTO CORE

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

From the end of the core, go back 3/4 of a fid, mark every other right and left strand for 3 strands.

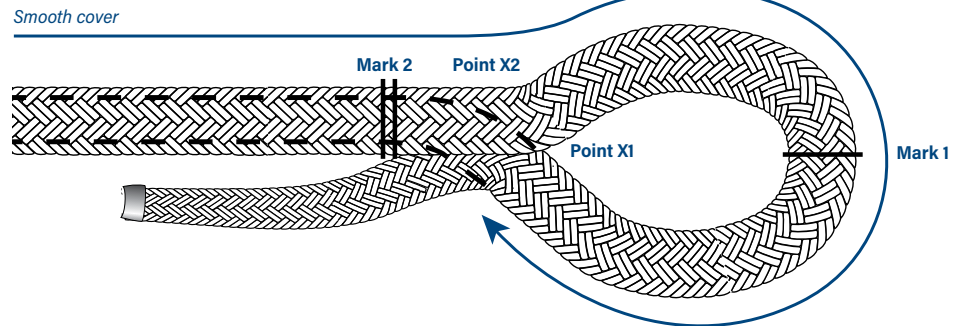
Pull every marked strand out of line and cut (tape at end can cause resistance and may have to be removed in order to pull out cut strands.) Tapered end will now have only 6 strands remaining.



*** For an 8-strand core mark every other right and left strand for 2 strands.*

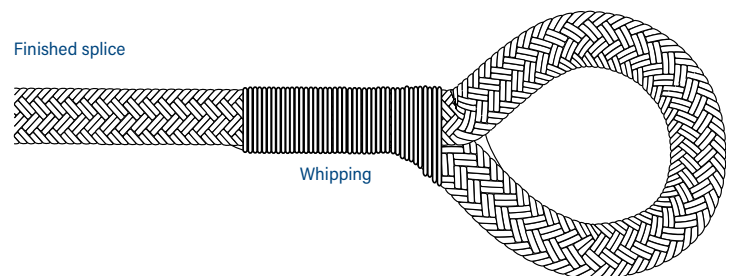
STEP 4 SMOOTHING COVER

Milk up cover completely away from slipknot and toward eye. This should bring cover up to Mark 1 and Mark 2 on core (a little over is acceptable).



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. Start whipping at the throat of the eye moving toward tail using Whipping Method 1.





Whipping Method I and Seizing Method II

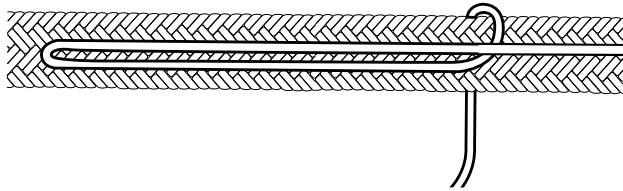
METHOD I WHIPPING FINISHED SPLICES

Choosing twines for whipping:

In general, braided nylon twine is preferred for whipping. Polyester twines, or twisted twines in either polyester or nylon, can also be used. For double braids the twine used should be approximately twice the diameter of the strands in the cover.

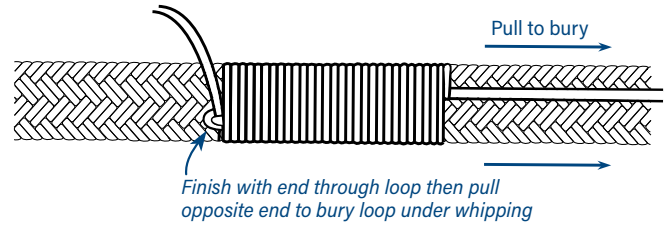
STEP 1

Form loop along the rope with whipping twine and wrap end around the back.



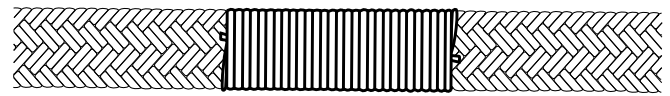
STEP 2

Continue wrapping at least 1 rope diameter in length.



STEP 3

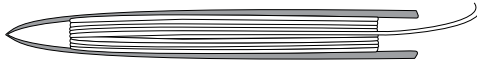
Cut both ends close to whipping.



METHOD II SEIZING SPLICES

STEP 1

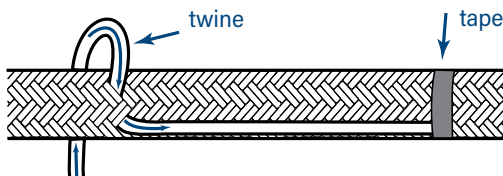
Attach twine to netting needle.



STEP 2

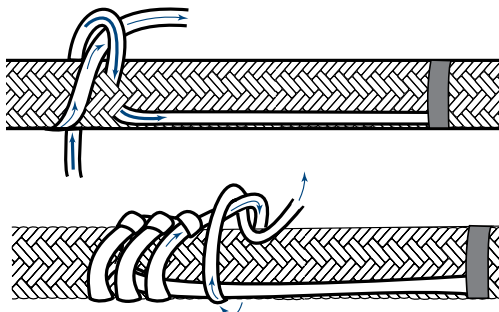
Pass the free end of the twine under a couple of strands in the cover and pull enough twine through to extend beyond the area to be seized.

2A Tape the free end of the twine to the opposite side of the area to be seized.



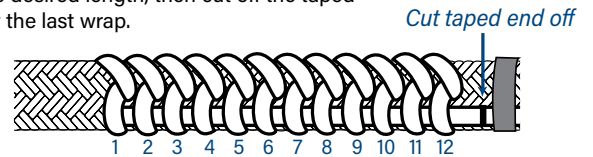
STEP 3

Start seizing. Wrap the needle around the circumference of the rope 1 complete turn. Pass the netting needle under the complete wrap left to right. Pull the loop tight. Pull the needle up maintaining tension on the completed half hitch and then quickly pull back down to lock the half hitch in place.



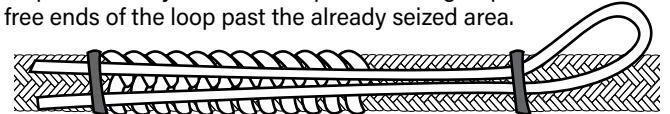
STEP 4

Continue with this procedure until the seized area is approximately 1/2 of the desired length, then cut off the taped end near the last wrap.



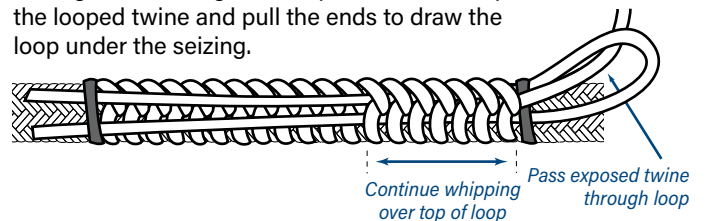
STEP 5

Using some spare twine, tape a loop that covers the length of the intended seizing distance, letting the 2 free ends of the looped twine lay over the completed seizing. Tape the free ends of the loop past the already seized area.



STEP 6

Continue seizing for the desired total length over the top of the looped twine. After seizing is complete, pass the exposed seizing twine through the loop. Remove the tape on the looped twine and pull the ends to draw the loop under the seizing.



STEP 7

Pull the loop through the seized area. This should place the remaining seizing twine under the seized area. Cut off any excess twine.

