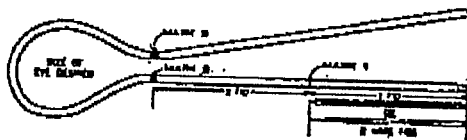


Sac Line Splicing



Step 1 . . .Measurement

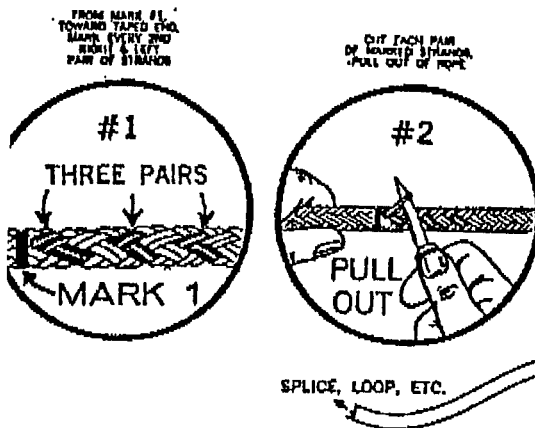


Tape end of line to be spliced and measure one tubular fid length (2 wire fid lengths because wire fid is 1/2 size) from taped end of line and make Mark #1.

From Mark #1 measure two tubular fid lengths (4 wire fid lengths) - Make Mark #2.

Now form size of eye desired and make Mark #3.

Step 2 . . .Making Taper

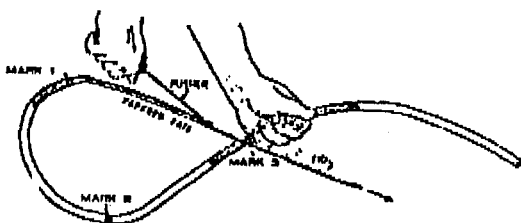


From Mark #1, in the direction of the taped end of the line, mark every 2nd right and left pairs of strands for 3 pairs. (See insert #1 & #2).

Cut every 2nd pair of marked strands and pull out of line (tape at end may have to be removed in order to pull out strands).

Tapered end will now have only 6 pairs of strands remaining. Tape tapered tail tightly to keep from unbraiding.

Step 3 . . .Locking Eye Splice

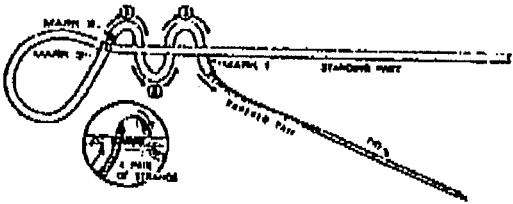


Attach fid to tapered end of line. At Mark #3 pass fid completely through line and go between strands. Pull on fid and tapered tail until Mark #2 just disappears inside standing part of line. *Be sure not to twist line.*

Note: With lines 1/4" to 5/8" diameter only one lock tuck has to be done. Lines 5/8" diameter to 1-5/16" diameter (4" Circumference) - two lock tucks should be done. Over 4" Circumference, 3 lock tucks should be done. See Step 4 for proper procedures on additional locks.

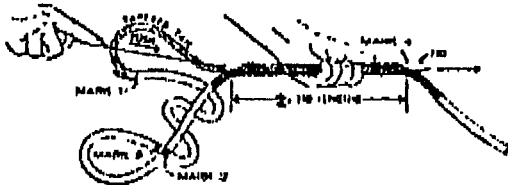
If your particular application will not allow locking, proceed with Step 5, burying the tapered tail 2-1/4 fid lengths starting at Mark #3.

Step 4 . . .Additional Locking of Eye Splice



Count down four (4) pairs of strands from point where tail of line comes out of standing part. Insert fid and then tapered tail between fourth and fifth pairs of strands. (See inset). Repeat Steps #3 and #4 two more times. Four passes of tail section will have been made through the standing part of the line. Be sure line has no twists.

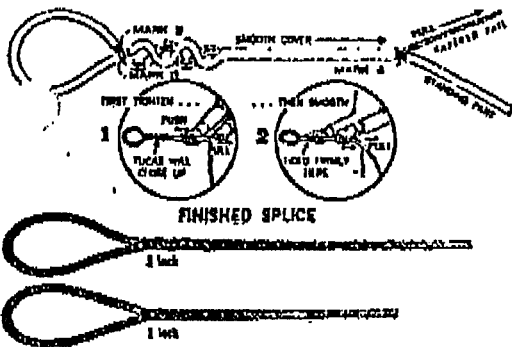
Step 5 . . .Bury Tail into Standing Part of Line



Measure 2-1/4 Tubular fid lengths (4-1/2 wire fid lengths) - Make Mark #4. Then count down four (4) pairs of strands on standing part of line from point of last insertion. Insert fid and tapered tail at this point and bring fid out at Mark #4. Pull fid and tapered tail out. Don't let line twist.

Note: If no "locks" are to be used, insert fid at Mark #3 a distance of 2-1/4 fid lengths and bury tapered tails.

Step 6 . . .Finish Burying



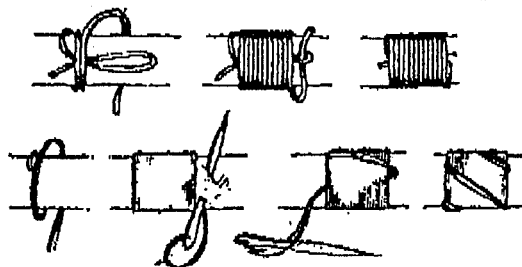
Remove fid. Pull hard on tapered tail with one hand. (See inset #1 and #2). With other hand smooth bunched line away from eye splice. Be sure all tucks are tight and that there is no more slack. Now, cut off tail at the angle close to standing part of line. Smooth cover once more away from eye to bury tail. With larger ropes it is easier to bury by tying a small line to eye and securing firmly to fixed object, then, with both hands and weight of body, smooth cover slack to tighten locks and bury tail in standing part.

FIDS AND DIMENSIONS

Rope Dia.	Rope Circ.	Short Section Measure	Long Section Measure	Full Fid Length
1/4"	3/4"	2-1/16"	3-7/16"	5-1/2"
5/16"	1"	2-1/2"	4-1/4"	6-3/4"
3/8"	1-1/8"	2-7/8"	4-7/8"	7-3/4"
7/16"	1-1/4"	3-9/16"	5-15/16"	9-1/2"
1/2"	1-1/2"	4-1/8"	6-7/8"	11"
9/16"	1-3/4"	4-1/4"	8"	12-1/4"
5/8"	2"	4-1/2"	9-1/2"	14"
3/4"	2-1/4"	4-3/4"	11-1/4"	16"
7/8"	2-3/4"	4-3/4"	14-1/4"	19"
1"	3"	5-1/4"	15-3/4"	21"

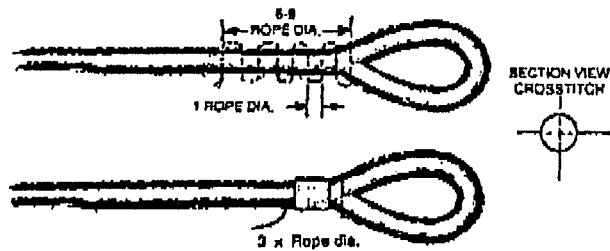
Whipping

Seize by whipping or stitching the splice to prevent the crossover from pulling out under an unbalanced load. To cross-stitch, mark off six to eight rope diameters from throat in one rope diameter increments (stitch length). Using same material as cover braid if available, or waxed whipping thread, start at bottom leaving at least eight inches of tail exposed for knotting and work

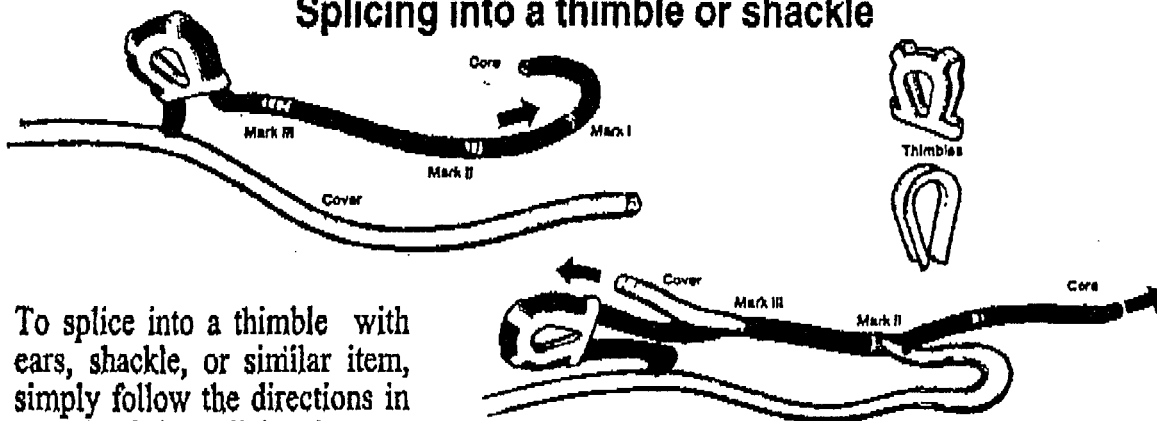


toward the eye where you then cross-stitch working back toward starting point. Cut off thread leaving an eight inch length and double knot as close to rope as possible. Trim thread to a one inch length and bury remaining thread and knot into rope.

As a general rule of thumb, if you whip the rope, do so for a length three times the rope diameter and hold it in place with cross-stitching. Use the same material as the cover braid if available, or waxed whipping thread.



Splicing into a thimble or shackle



To splice into a thimble with ears, shackle, or similar item, simply follow the directions in step 1 of the splicing instructions, using the thimble or shackle bale to determine the size eye. Extract the core and insert the core through the bale or around the shackle as illustrated. The eye spliced is then completed in a normal fashion with one exception: before final bury, slide thimble around to cover side of eye. For a thimble without ears: insert thimble into eye before final burying of splice.

Used Rope