

End / End Splice Procedure

Tools Needed:

- Scissors • Utility Knife • Tape Measure • Electrical Tape • Whipping Twine • Spray Adhesive • Hose Clamps

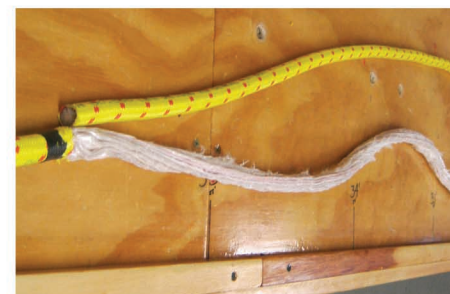
Unitrex Splice Chart

Cross Over #	Rope Diameter	4 Bundles				6 Bundles									
		0.44	0.53	0.58	0.63	0.71	0.84	1.00	1.15	1.25	1.40	1.70	1.80	1.90	2.20
1		4 1/2	5 1/2	6	6 1/4	7 1/4	8 1/2	10	11 3/4	12 1/2	14 1/4	17 1/4	19 1/2	20	22 1/4
2		8 1/2	10 1/2	11 3/4	12 1/4	14 1/4	16 3/4	19 3/4	23	24 3/4	28	34 1/4	38 1/2	39 3/4	44 1/4
3		12 1/2	15 1/4	17 1/4	18	21	24 3/4	29 1/4	34	36 3/4	41 1/2	50 1/4	57 1/2	59 1/4	66
4		16	19 3/4	22 1/4	23 1/2	27 1/4	32 1/4	38 1/2	44 3/4	48 1/2	54 3/4	67 1/4	76	78 1/2	87 1/4
5		19 1/2	24 1/4	27 1/4	28 3/4	33 1/2	39 3/4	47 1/2	55 1/2	60	68	83 1/2	94 1/2	97 1/2	108 1/2
6		22 1/2	28 1/4	32	33 3/4	39 1/2	47	56 1/4	65 3/4	71 1/4	80 3/4	99 1/2	112 1/2	116 1/4	129 1/2
7		25 1/2	32	36 1/2	38 1/2	45 1/4	54	64 3/4	75 3/4	82 1/4	93 1/4	115 1/4	130 1/2	134 3/4	150 1/4
8		28	35 1/2	40 1/2	43	50 1/2	60 1/2	73	85 1/2	93	105 1/2	130 1/2	148	153	170 1/2
9		30 1/2	39	44 1/2	47 1/4	55 3/4	67	81	95 1/4	103 1/2	117 3/4	145 3/4	165 1/2	171	190 3/4
10		32 1/2	42	48 1/4	51 1/4	60 3/4	73 1/4	88 3/4	104 1/2	113 3/4	129 1/2	160 3/4	182 1/2	188 3/4	210 3/4
11		34 1/2	44 3/4	51 3/4	55	65 1/2	79 1/4	96 1/4	113 1/2	123 3/4	141	175 1/2	199 1/2	206 1/4	230 1/2
12		36	47 1/4	54 3/4	58 1/2	69 3/4	84 3/4	103 1/2	122 1/4	133 1/2	152 1/4	189 3/4	216	223 1/2	249 3/4
13		37 1/2	49 3/4	57 3/4	61 3/4	74	90 1/4	110 1/2	131	143	163 1/2	204	232 1/2	240 1/2	269
14		38 1/2	51 3/4	60 1/2	64 3/4	78	95 1/2	117 1/4	139 1/4	152 1/4	174 1/4	218	248 1/2	257 1/4	288
length of sleeve to strip		72	90	102	108	126	150	180	210	228	258	318	360	372	414
completed splice length		45	58	66	71	84	101	123	145	158	180	224	255	263	294

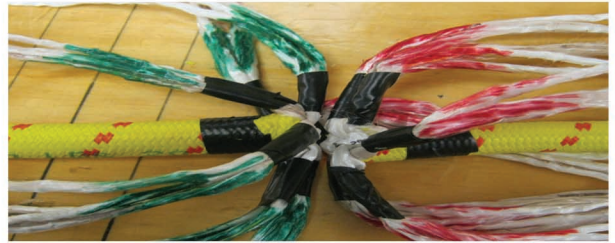
(All dimensions are expressed in inches)

Step 1 - On one side, slide on chafe sleeve past the splice area needed to cover the splice.

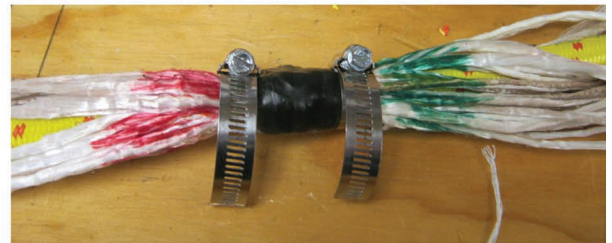
Step 2 - From chart above, mark, cut and strip the sleeve. (This is done easily with an adjustable utility knife.) Put the blade out just enough to cut through the sleeve and inner tape and not damage the core. Repeat on the other side.



Step 3 - Split the core ends into 6 even bundles. Mark the core ends with different colors for easier identification when weaving the two ends together.



Step 4 - Alternate weaving the bundles together and tape. Tighten hose clamps around either end. This will keep the ends tight when putting the rope under tension to do the splice.

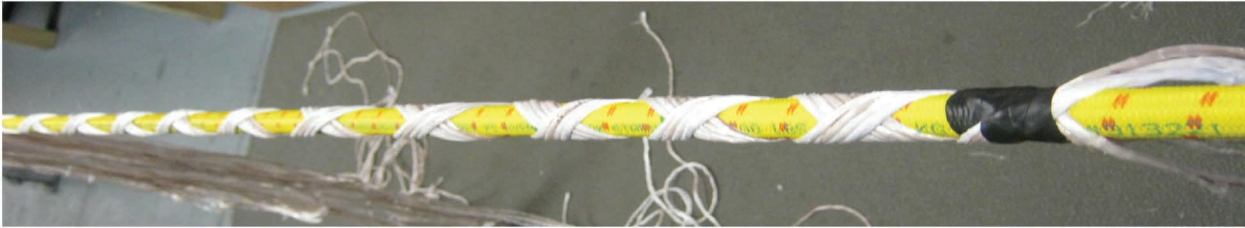


Step 5 - Tie off both ends beyond the splice zone and bring the splice area up under tension so the area is at a working height. Separate the core ends and position half on one side, half on the other side. Now mark the body using the appropriate cross over measurements from the chart for the rope you are splicing.

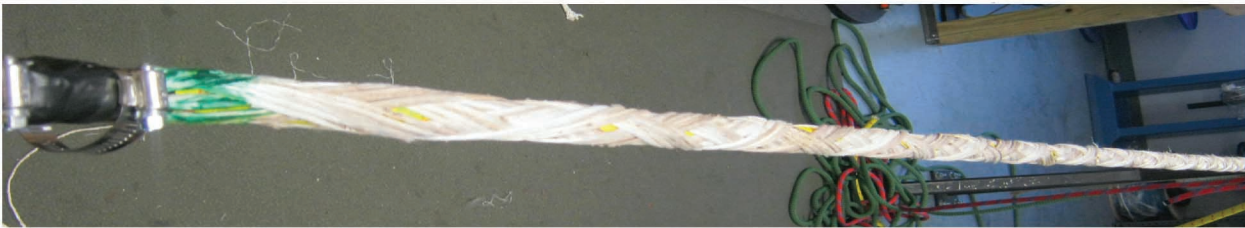


Step 6 - Spray a thin coat of adhesive along the splice zone of the body. Start with the inside pair of ends, wrap around the body in a counter clockwise direction keeping tension applied and landing on each mark. Tape the end at the last mark. Take the second pair and wrap in a clockwise direction in a cross over pattern. Finish the second wrap just beyond the first then tape down.





Step 7 - Now wrap the third pair in the same direction, parallel and just in front of the first pair. Wrap the fourth in the same direction as the second and parallel to. Spray adhesive between each wrap. Do the same with the fifth and sixth pairs.



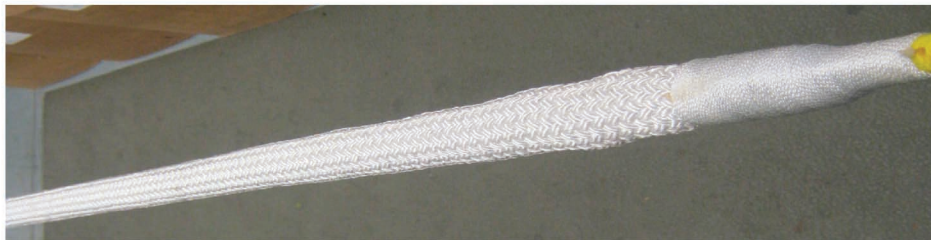
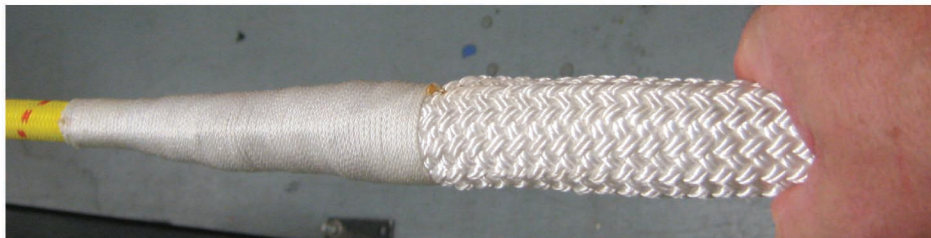
Step 8 - Repeat steps 5 thru 7 for the other side.



Step 9 - Whip the ends of the splice and where the two ends weave together.



Step 10 - Spray a light coat of glue over the entire splice and bring the chafe sleeve over the spliced zone. Whip one end of the chafe sleeve and milk the chafe tight to the splice zone towards the other end. Whip the other end.



Step 11 - Saturate the chafe sleeve and whipping with the coating provided.

