

Tools Needed:

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



Step 1 - Slide the chafe sleeve over the rope past the splice area.

Step 2 - Mark the tail length needed to strip for size of rope you are splicing based on chart below. Mark the eye size desired.

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)

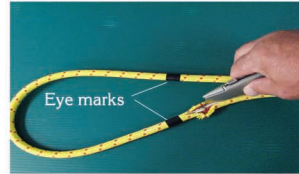
Uniline Splice Chart

Cross Over #	Rope Diameter	3/8	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 3/8	1 1/2	1 3/4	2
1		3 1/2	4 1/2	5 1/2	7	8	9	10	11	12	14	16	18
2		7	9	11	14	16	18	20	22	24	28	32	36
3		9 1/2	12	15	18 1/2	21 1/2	24	27	30	32	37	43	48
4		12	15	19	23	27	30	34	38	40	46	54	60
5		14 1/2	18	23	27 1/2	32 1/2	36	41	46	48	55	65	72
6		17	21	27	32	38	42	48	54	56	64	76	84
7		19 1/2	24	31	36 1/2	43 1/2	48	55	62	64	73	87	96
8		22	27	35	41	49	54	62	70	72	82	98	108
9		23 1/2	29	37 1/2	44	52 1/2	58	67	75	78	88	105	116
10		25	31	40	47	56	62	72	80	84	94	112	124
11		26 1/2	33	42 1/2	50	59 1/2	66	77	85	90	100	119	132
completed splice length		27	35	45	53	63	70	82	90	96	106	126	140
length of sleeve to strip		45	60	75	90	105	120	135	150	165	180	210	240

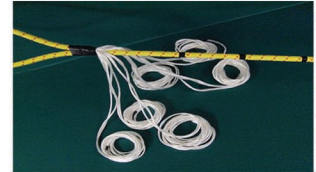
(All dimensions are expressed in inches)

Crossover dimensions are taken with tape measure anchored at the crotch of the eye.

Step 3 - Remove the outer sleeve and inner protective layer by cutting down the length of tail being careful not to cut any of the core ends. Remove the core ends by peeling the sleeve and inner layer away. Cut as close to the eye mark as possible.



Step 4 - Clamp the eye marks together. Separate the core ends into the appropriate number of bundles. Half on one side and half on the other side. Now mark the body with the appropriate measurements from the chart for the rope you are splicing.



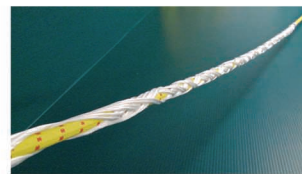
Step 5 - Spray a thin coat of adhesive along the splice zone of the body. Start with a bundle on the right side. Keep the bundle flat to the surface with hand tension. Wrap in a clockwise direction. Tape the bundle at the last mark. Spray another coat of adhesive along the splice zone.



Step 6 - Take the second bundle from the left side and wrap in a counter clockwise direction landing on top of the first wrap at each mark. Finish the second bundle just beyond the first then tape down.



Step 7 - Wrap the third bundle clockwise, parallel and just in front of the first bundle. Wrap the fourth bundle counterclockwise, parallel and just in front of the second bundle. Wrap the fifth bundle clockwise, parallel to the third bundle. Wrap the sixth bundle counterclockwise, parallel to the fourth bundle. Finish each bundle just beyond the previous bundle.



Step 8 - Whip the base of the eye. Whip completely over all tail ends at the end of the splice zone.



Step 9 - Spray lightly over the splice zone with spray adhesive. Slide the chafe sleeve over the splice area. Whip the eye first then milk the chafe down down tightly over the splice zone and whip the tail area. Saturate the chafe cover and whipping with Maxijacket coating.

