

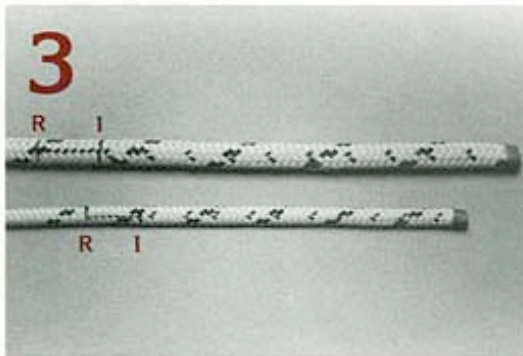
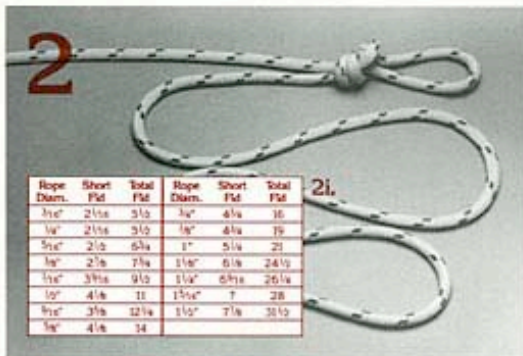
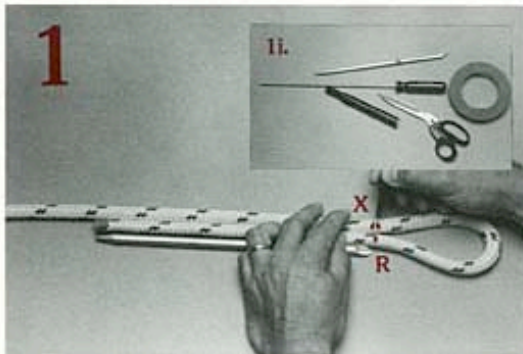
**YALE CORDAGE
S·P·L·I·C·I·N·G
INSTRUCTIONS**

**INDUSTRIAL
DOUBLE BRAID
EYE SPLICE**

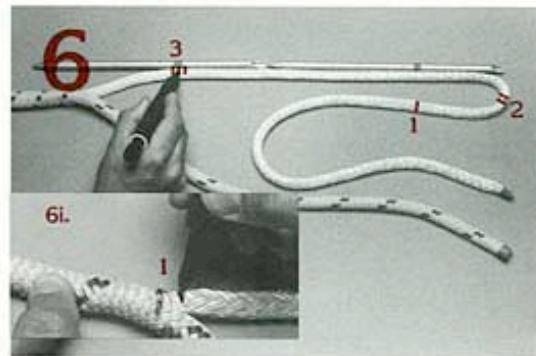
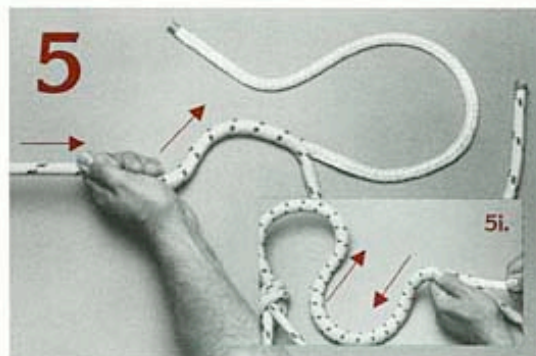
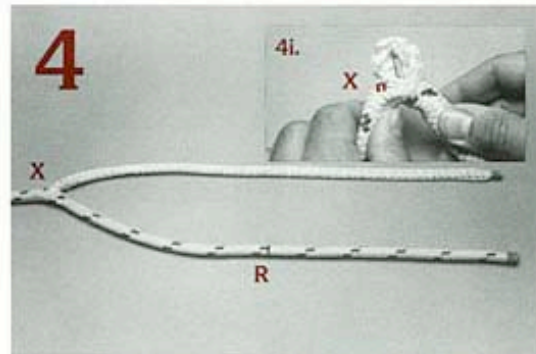


Yale Cordage:

Industrial

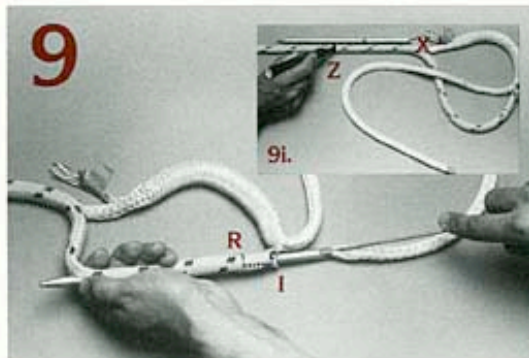
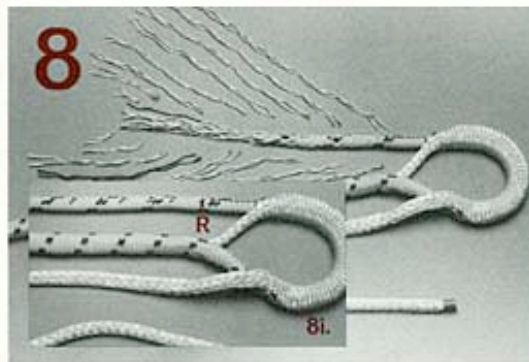
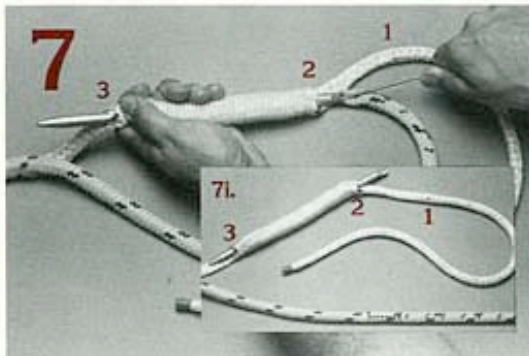


- 1i. The tools you will need are: a properly sized fid, fid pusher, knife or scissors, masking tape and a marking pen.
1. Lay out the end to be spliced. Mark one full fid length from the end. This is mark "R". Form desired eye size and make another mark. This is mark "X".
2. Tie a looped knot approximately 5 fid lengths from mark "X". (In larger diameter ropes 1" and over it may be helpful to insert a small fid through the rope core and sleeve in place of the knot).



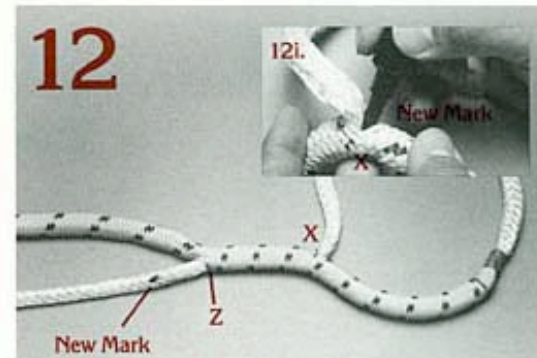
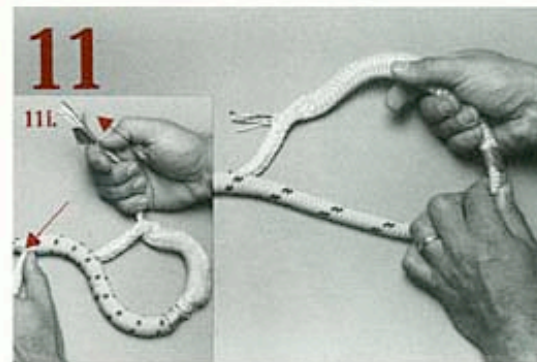
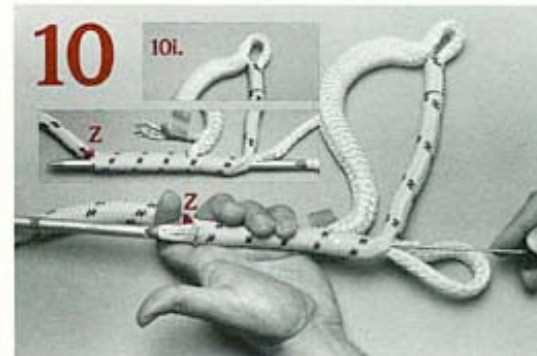
- Note the nature of the sleeve braids. They are made of sets of strands composed of 2, 3 or perhaps 4 individual ends. Half of the strands revolve to the right and half to the left. See Notes & Tips on overlay.
3. From mark "R", count 8 sets of strands towards the end of the rope and make mark "I". This mark should be made all around the circumference of the rope. From mark "I", mark the sleeve taper. For 16-strand ropes mark every 5th set of left and right strands, 20-strand ropes mark 4th then 5th and repeat and 24-strand ropes mark a 4th, a 4th, then a 5th and repeat.
- 4i. Extract the core at mark "X". Work the rope to "pop" the core up through the cover strands at mark

Double Braid



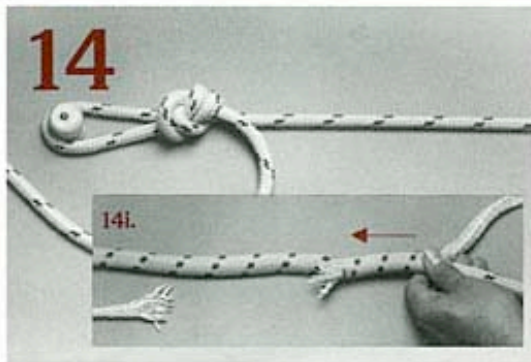
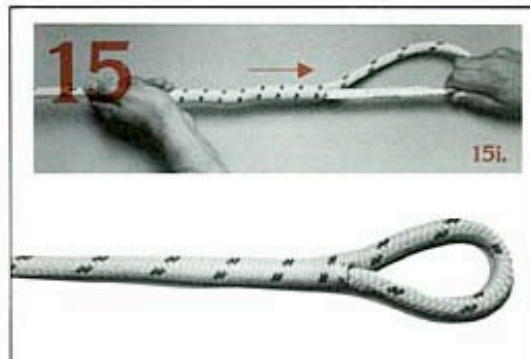
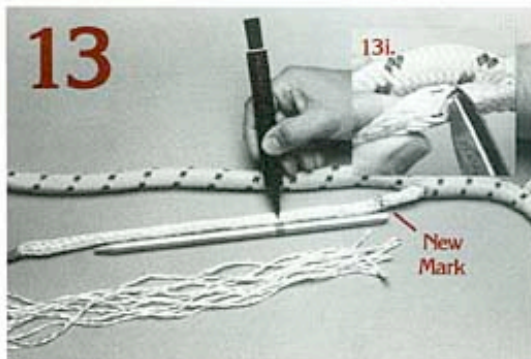
"X". Be careful not to pull any strands excessively or to "pop" the core between any individual ends of a strand.
4. Pull the core end completely out of the rope and tightly tape the end.
5i. Balance the rope by holding the core and pushing the sleeve back against the knot.
5. Milk (smooth) the bunched sleeve back over the core. Milk the sleeve until all the slack is removed from the sleeve.
6i. Mark the core at the point where it exits the sleeve (mark 1).
6. Pull out the core and working away from the end of the core make two marks (mark 2) on the core 1 short fid length from mark "1". Make three marks (mark 3)

Eye Splice



on the core 1 full fid plus 1 short fid length from mark "2".
Closed thimble goes on now, on the cover side.
7i. Insert the tapered point of the fid into the hollow center of the core at mark "2". Push it through and collect the core on the fid. Exit the fid at mark "3".
7. Insert the end of the sleeve into the hollow end of the fid and, using the pusher, push the fid and sleeve through the core. Do not induce any twist into the sleeve.
8i. Pull the sleeve through the core until you expose mark "R".
8. Cut off and pull out the strands that were marked in the sleeve. Place a small piece of tape on the end of the now tapered sleeve to prevent it from pulling into

Use this splice for Polydyne, Double Esterlon, Yalon, Enduralon, and T-Line.



the core.

9i. Milk the slack out of the sleeve from mark "X" towards the knot. Place mark "Z" on the sleeve 1/2 fid length from "X" towards the knot.

9. Inserting the fid into the sleeve at mark "I". Push it through, collecting the sleeve onto the fid. Place the tapered end of the core into the fid and, using the pusher, push it through the sleeve and out.

10i. Repeat this process reinserting the fid in the same hole just exited until the fid is able to exit at point "Z".
10. Push the core down through the sleeve without twisting it, and out at point "Z". Do not snag the portion of core between points "Z" and "X".

HINT: Depending on the size of the eye you may be able to insert at "I" and exit at "Z" in one pass or it may require several passes. It may be helpful to tape the core end onto the fid but you must be careful not to snag the sleeve.

11i. Form the crossover point by pulling the core end and the sleeve end until all the extra core and sleeve are pulled together completely.

11. Tightly tape the crossover to prevent slippage. Remove the tape from the sleeve end, hold the crossover, and milk the core over the sleeve end. The sleeve end will disappear. Milk the sleeve in the same manner.

12i. Insure *all* the sleeve slack is removed between the crossover and point "X" and as much as possible between points "X" and "Z". Then open up the crotch of the splice and mark the core.

12. Pull the core tail out at "Z" until the new mark appears.

13i. Starting at the exposed new mark, mark, cut and remove half the ends from each strand, completely around the circumference of the core.

13. Mark and cut off the core at a 45° angle one short fid length toward the end from the mark.

14i. Hold the crossover and milk the sleeve over the core tail which will disappear into the cover.

14. Secure the knot loop made in the beginning to a solid point.

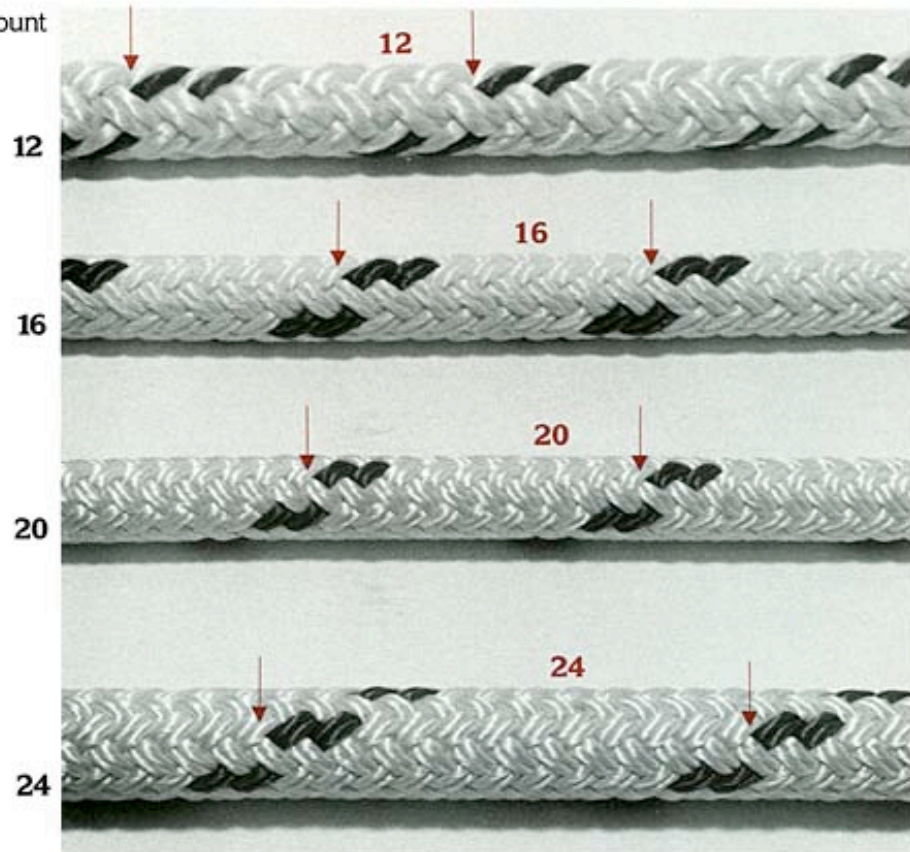
15i. Check that the crossover is tight. Grasp the rope in one hand at the crossover and with the other hand milk the sleeve over the core and crossover. (Remove the crossover tape before burying.) Repeat until all slack is removed from the body of the rope and from the eye.

HINT: Inserting a large fid through the eye and giving a sharp tug will assist in removing slack from the eye.

15. Check that all the slack is removed from the rope, there are no lumps in the crossover area or at point "Z" and that there is not an area of reduced volume in the eye adjacent to point "X". Remove the loop made in the beginning and finish your Double Braid Eye Splice with the Yale Whiplock.

For full, detailed Yale "WHIPLOCK" splice instructions see Yale YSI • 05

Cover Strand Count

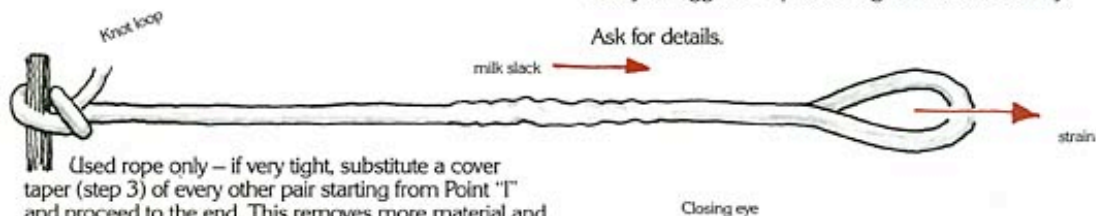


NOTES & TIPS

Closed (eared) Thimble Installation Install on the core side between step 6 & 7. Proceed per regular method.

Yale Qualified Splicer Program

Yale Cordage recognizes its products are regularly fabricated by authorized Stocking Distributors. We want to ensure the splices performed are of the highest quality and conform to our standard methods. We offer the Yale SPLICER Qualifier program as a tool to insure that your riggers are performing their work correctly.



Used rope only – if very tight, substitute a cover taper (step 3) of every other pair starting from Point "I" and proceed to the end. This removes more material and will make closing the splice easier.

Derate the rope strength accordingly.