

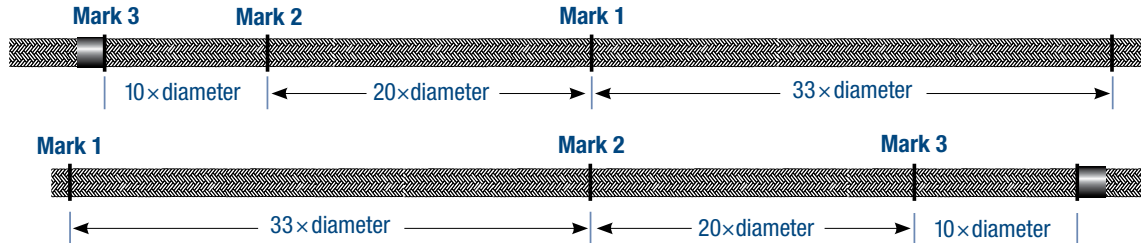


Double Braid Class II End-for-End Splice Modified for Turbo-37 **samson** THE STRONGEST NAME IN ROPE

STEP 1 MEASURING AND MARKING

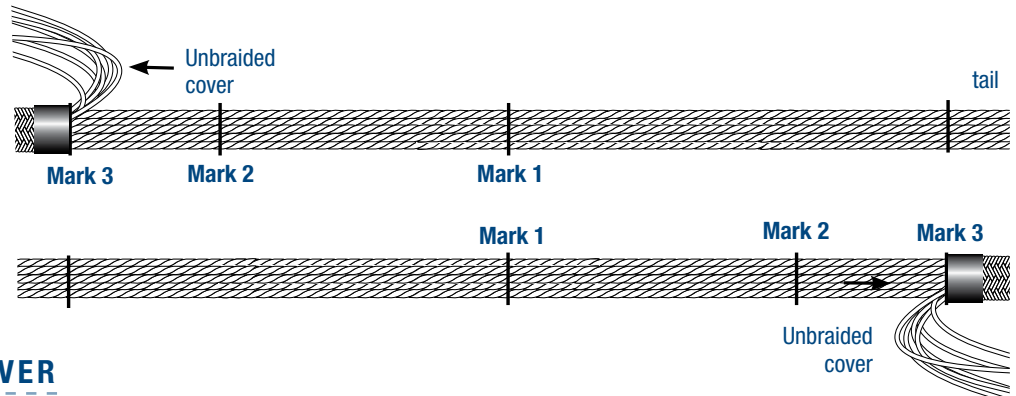
On each of the 2 ends to be spliced together measure 33 times rope diameter. This is Mark 1. From Mark 1, measure an additional 20 times the diameter, this is Mark 2. Now make Mark 3, 10 times the diameter beyond Mark 2. Tape securely at Marks 3.

Note: Mark 1 on the cover is for reference only; however, each sub-rope will be marked at this location after cover removal.



STEP 2 INSTALLING SPLICE COVER MATERIAL

Using an appropriate size and approx 1.7 times splice length of cover material (splice length approx. 60 times rope diameter), slide the cover onto either end of the rope, and slide past Mark 3. This will be used later to cover the exposed sub-ropes in the splice area.

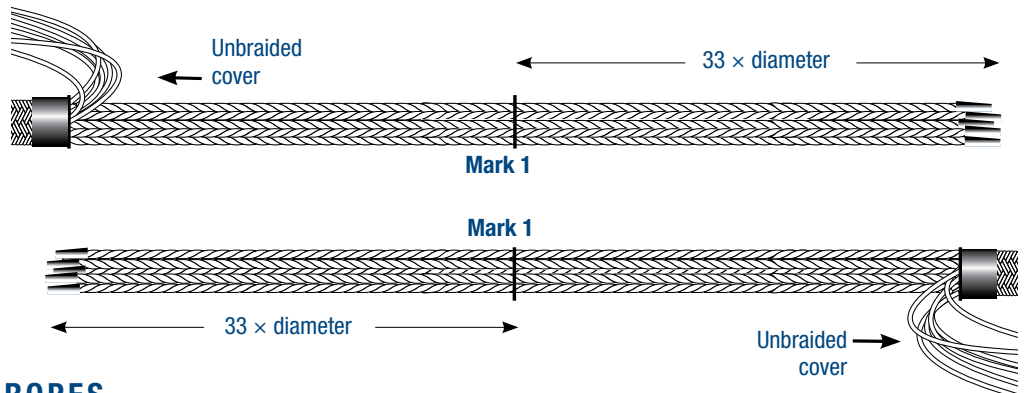


STEP 3 REMOVING COVER

Carefully cut the cover of the rope at Marks 2, and remove from rope. Unbraid the cover from Marks 2 back to Marks 3. This material will be used later to incorporate the cover into the splice.

STEP 4 TAPING SUB-ROPES

Tape the end of each sub-rope. This should be done immediately after removing the cover to prevent unlaying.



STEP 5 MARKING SUB-ROPES

Arrange sub-ropes as shown, taking care that all are laid straight. From the bitter ends of the sub-ropes, measure 33 times the rope diameter and mark each one at exactly the same point.

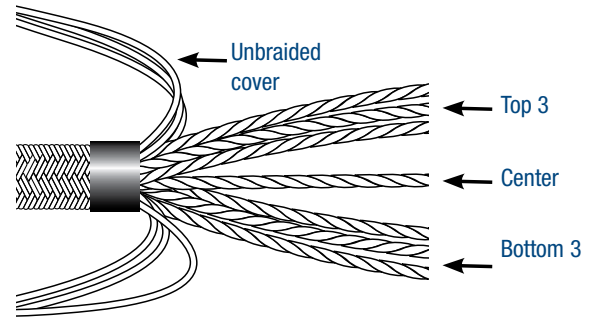


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STEP 6 ARRANGING SUB-ROPES

Arrange sub-ropes in groups as shown, separating the top 3, the center 1, and the bottom 3 (Fig. A).

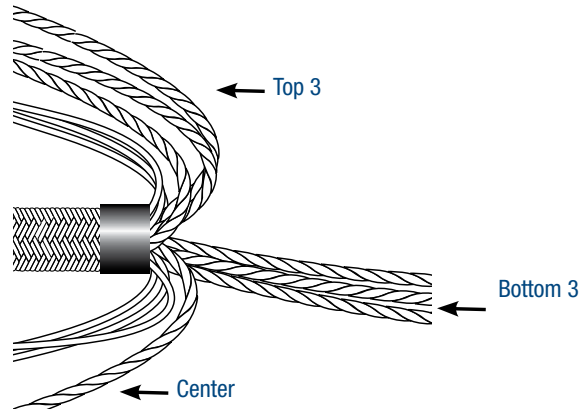
Figure A



STEP 7 PULLING TOP 3 AND CENTER

Pull the top 3 and center sub-ropes out of the way on both sides (Fig. B).

Figure B



STEP 8 ARRANGING BOTTOM 3 SUB-ROPES

Arrange bottom 3 sub-ropes from each side as shown.

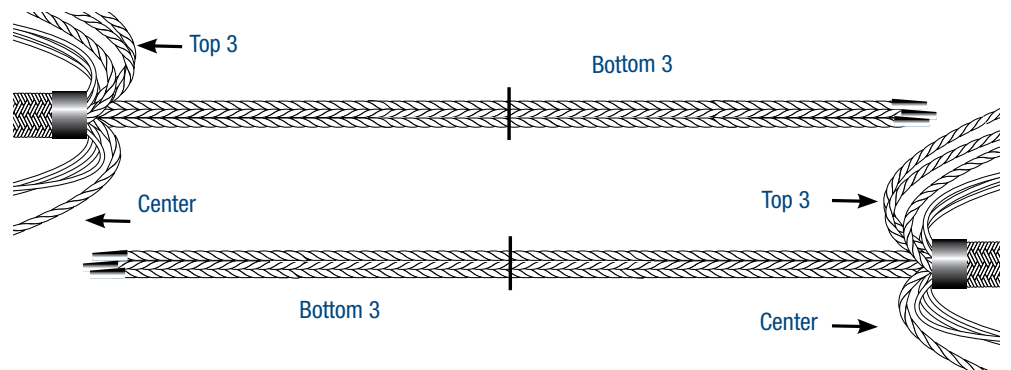
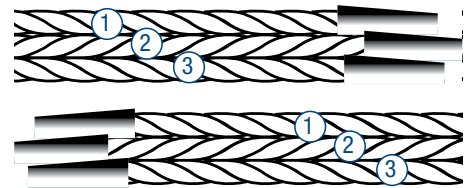


Fig. C shows how the bottom 3 strands from each side will be paired. Note that the corresponding sub-ropes from each side should have the same direction of twist.

Pairing of bottom 3 sub-ropes (sub-ropes numbered 1 will be spliced together, numbered 2 will be spliced together, etc.)

Note: After splicing bottom 3 and center 1, top 3 will be paired likewise.

Figure C



STEP 9 JOINING THE SUB-ROPES

Insert sub-rope 1 from the right into sub-rope 1 from the left by tucking under 1 strand at the mark (Fig. D). Draw the right-hand sub-rope through until the mark on it coincides with mark on the left-hand sub-rope. (Fig. E) This is the 1st tuck.

Figure D

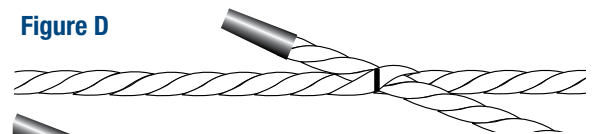
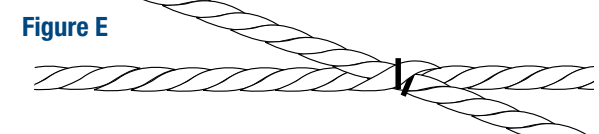


Figure E





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STEP 10 REPEAT PROCEDURE

Repeat this procedure, now tucking the left-hand sub-rope 1 into the right-hand sub-rope 1 (Fig. F). Draw the left-hand sub-rope all the way through to close up the crossover (Fig. G). Place a wrap or two of tape around the crossover point.

Figure F

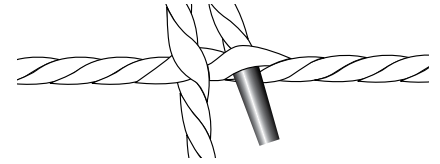
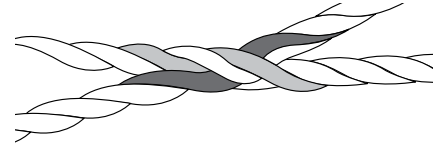


Figure G



STEP 11 MAKING ADDITIONAL TUCKS

11A Make an additional 14 tucks in each direction. A tuck consists of passing the tail over 1 strand, and under 1 strand, always against the lay. When pulling the tail through, pull perpendicular to the direction the rope is lying in, and take care not to over tighten the tuck, this will cause unnecessary distortion. Fig. G shows normal appearance after 1 tuck each direction. As the splice progresses, the tail should gradually spiral around the standing part. To accomplish this, it is necessary to pull the tail underneath the standing part on every 3rd or 4th tuck (Fig. H).

Figure H

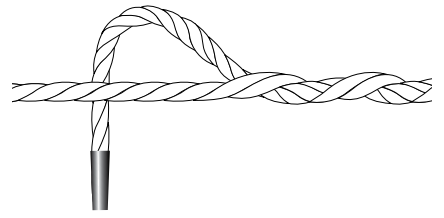
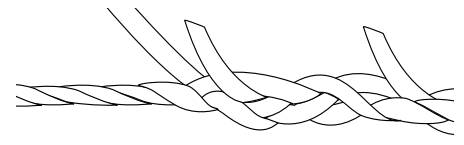


Figure I



11B Complete 15 tucks with full volume tail, then remove 1 strand from tail and complete 3 tucks with the remaining 2 strands (Fig. I). Now remove 1 strand and complete 3 tucks with the remaining 1 strand (Fig. J). Tape the tails to the rope.

Figure J



STEP 12 JOINING SUB-ROPE 2

Repeat Steps 9–11 with sub-ropes 2 (shown in Fig. K) and then sub-ropes 3.

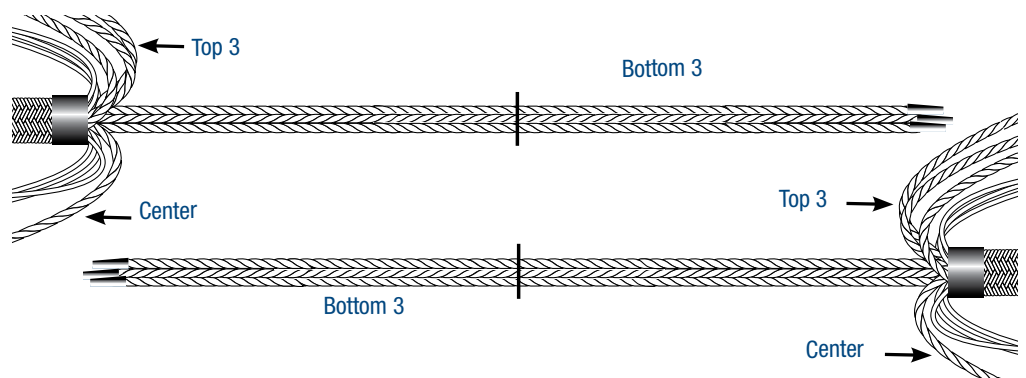
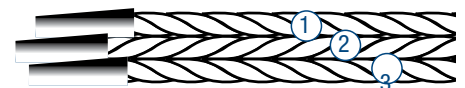
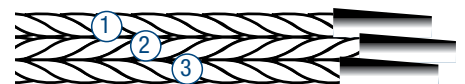


Figure K

Pairing of bottom 3 sub-ropes (sub-ropes numbered 1 will be spliced together, numbered 2 will be spliced together, etc.)

Note: After splicing bottom 3 and center 1, top 3 will be paired likewise.



STEP 13 SPLICING CENTER SUB-ROPES

Now select the center sub-ropes and splice them together, again following the procedure outlined in Steps 9–11.

STEP 14 SPLICING TOP SUB-ROPES

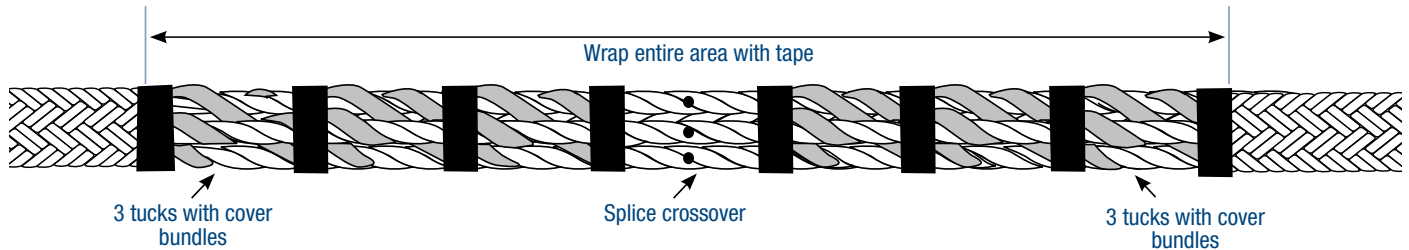
Arrange the top 3 sub-ropes as in Fig. 3. Starting with sub-ropes 1, splice all of the top sub-ropes as in Steps 9–11.



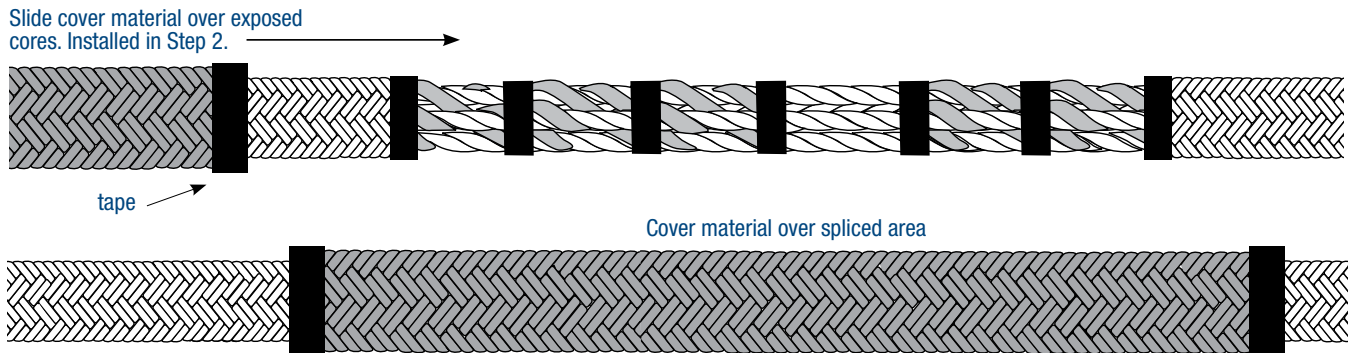
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STEP 15 DIVIDING UNBRAIDED COVER
Place the rope under tension, then divide the unbraided cover material (from Step 3) at each end of the splice into 6 equal bundles.

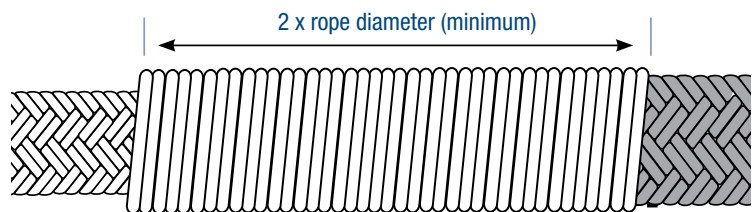
STEP 16 GROUPING AND TUCKING COVERS
Tuck the cover bundles at each end of the splice. Starting at either end of the splice, take 1 of the 6 cover bundles, pass it over 1 sub-rope and under the very next (forming a simple tuck similar to that used in splicing 3-strand rope.) Repeat until all 6 bundles have been tucked once. Then tightly tape around the rope at the point where the tucks occur. Repeat this process until a minimum of 3 tucks have been made with all 6 bundles. After the last set of tucks, trim off the excess cover yarn. Now repeat entire procedure, starting at the other end of the splice. With splice area still under tension, apply tape to entire area.



STEP 17 COVERING THE SPLICE AREA
Release tension and slide the section of cover on the rope in Step 2 into position over the splice with the splice crossover at the center. Remove all slack from the cover by milking away from the crossover in each direction.



STEP 18 SEIZING THE COVER
Milk all of the excess cover slack from the middle of the cover material down towards both ends of line. Tightly tape the cover to the rope approximately equal to rope diameter (in inches) back from the end of the cover. Unbraid the cover strands from the tape to the end. Seize over the area for a distance of 2 times rope diameter (in inches) with nylon seizing material.



STEP 19 GROUPING AND TUCKING COVERS
After seizing both ends of the cover material, apply a two-part urethane coating over the seized areas as shown, extending the urethane coating 1/2 the length of the seized area on both sides of the seizing.

