

Lock Stitching Procedures



Twines for lock stitching:

In general, braided nylon twine is preferred for lock stitching. Polyester twines, or twisted twines in either polyester or nylon, can also be used. The twine should be in alignment with the rope strand size; not less than half the strand diameter nor larger than 1x the strand diameter. If the rope or the cover of the rope is made up of pairs of strands rather than a single strand, the twine should be approximately the same as 1 of the ends but no larger than the 2 ends together. To check for correct twine size, lay the twine over the strands in the rope — if it covers the width of the strand(s), it is the right size.

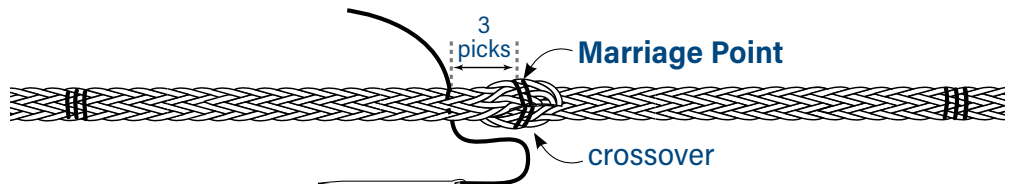
FOR 2" (48mm) DIAMETER & ABOVE ROPES:

Lock stitching will need to be performed using 1/2" or 5/8" (12mm or 16mm) diameter polyester cover only/flat braid rope for 3.5" (86mm) diameter and larger ropes.

LOCK STITCHING END-FOR-END SPLICES

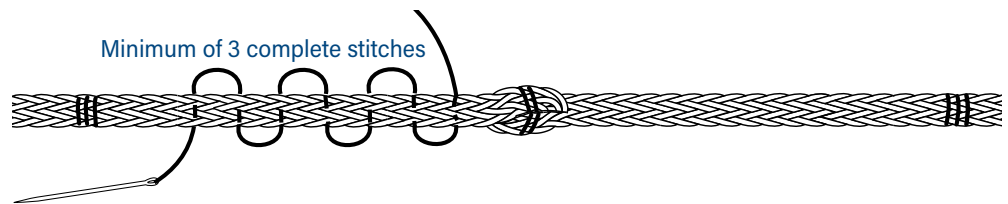
STEP 1

From the marriage point of the crossover, count 3 picks in either direction and insert stitching twine.



STEP 2

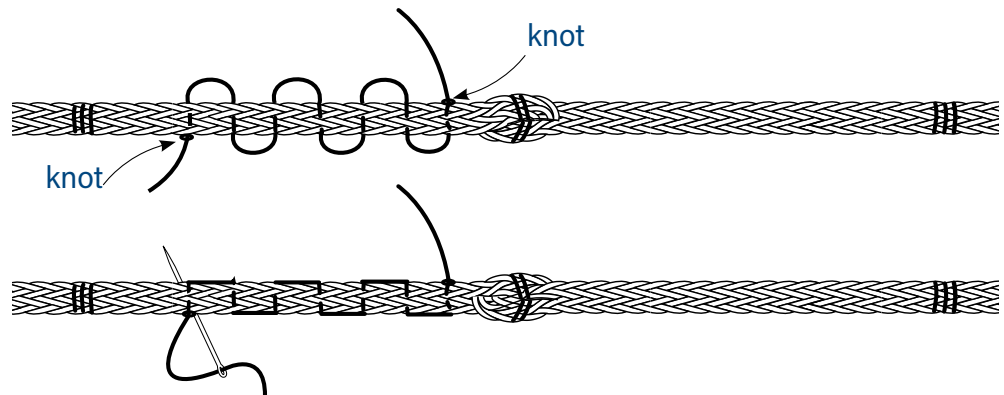
Working away from the crossover, stitch twine back and forth through the splice, crossing over at least 2 picks at a time until a minimum of 3 complete stitches have been made on 2 sides of the rope.



STEP 3

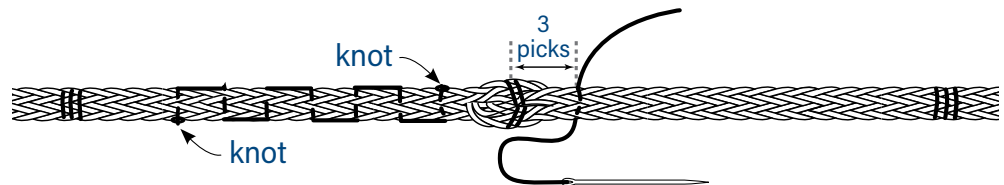
Tie an overhand knot in each end of the twine, as close to its exit point as possible.

Insert tail of stitching twine at exact location where twine emerges. Using needle or small fid, pull (or push) through rope at a slight angle. Pull hard on the end of the twine so that the knot disappears inside the rope. Trim off the remaining twine close to the rope. Repeat on other end of the twine.



STEP 4

Repeat lock stitching steps 1-3 on the other side of the crossover to complete the splice.



Finished splice



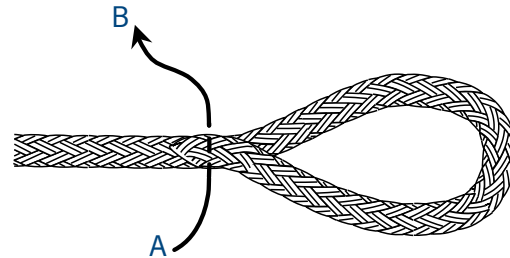
Lock Stitching Procedures



LOCK STITCHING EYE SPLICES

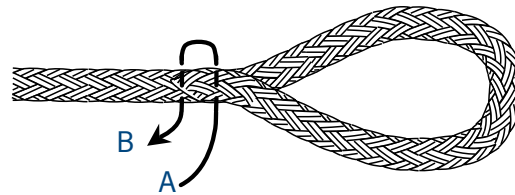
STEP 1

Start the stitching twine just below the entry point of the splice and pass it directly through to the other side. The stitching should start no farther than 1/4 fid length below the entry point, as shown.



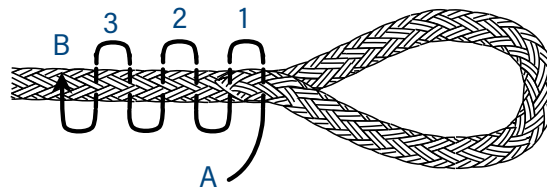
STEP 2

Reinsert twine through the rope. The twine should cover 2 rope picks, or for small diameter double braid ropes 3 rope picks, from the exit point. Pull the twine snug, but not tight.



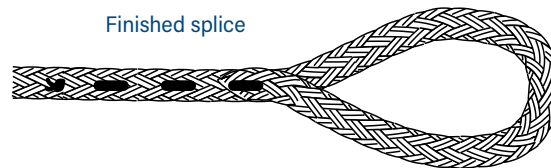
STEP 3

Continue to reinsert as shown until you have at least 3 complete stitches on each side of the rope. Each stitch should cross over at least 2 rope picks.



STEP 4

After stitching 3 complete stitches on 2 sides of the rope take the bitter ends of the stitching twine and tie a square knot as close to the rope as possible. Bury the square knots into the rope between the rope picks directly where the twine enters the rope. After the knots are buried, cut off any remaining twine sticking out.





Whipping & Seizing Procedures

Twines for whipping:

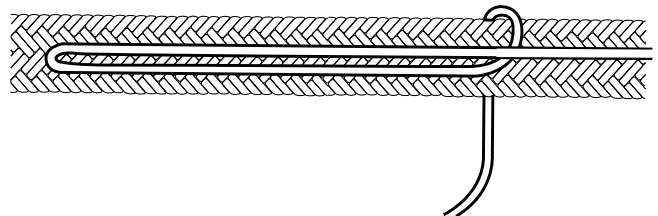
In general, braided nylon twine is preferred for whipping. Polyester twines, or twisted twines in either polyester or nylon, can also be used. For double braids the twine used should be approximately twice the diameter of the strands in the cover.

Whip the end of the spliced area with whipping twine for extra security and a professional touch. Keeping tension on rope while wrapping results in tighter whipping.

METHOD I WHIPPING FINISHED SPLICES

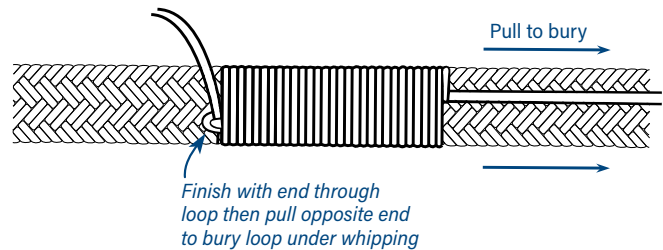
STEP 1

Form loop along the rope with whipping twine and wrap end around the back.



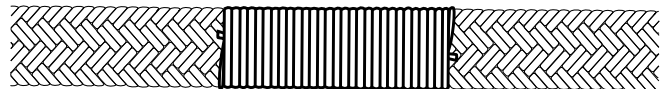
STEP 2

Continue wrapping at least 1 rope diameter in length.



STEP 3

Cut both ends close to whipping.



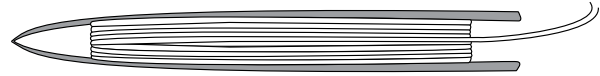
Whipping & Seizing Procedures



METHOD II SEIZING FINISHED SPLICES

STEP 1

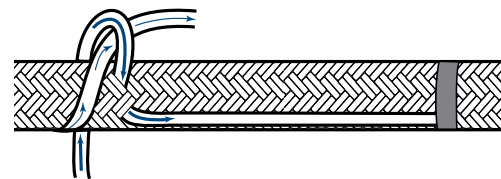
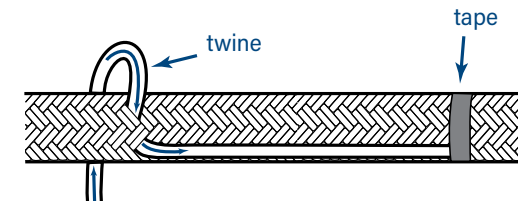
Attach twine to netting needle.



STEP 2

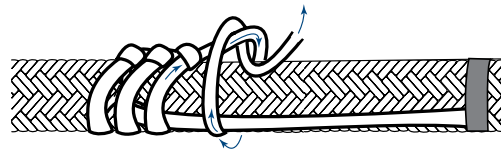
Pass the free end of the twine under a couple of strands in the cover and pull enough twine through to extend beyond the area to be seized.

2A Tape the free end of the twine to the opposite side of the area to be seized.



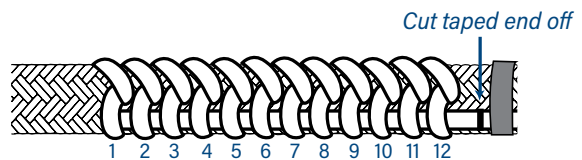
STEP 3

Start seizing. Wrap the needle around the circumference of the rope 1 complete turn. Pass the netting needle under the complete wrap left to right. Pull the loop tight. Pull the needle up maintaining tension on the completed half hitch and then quickly pull back down to lock the half hitch in place.



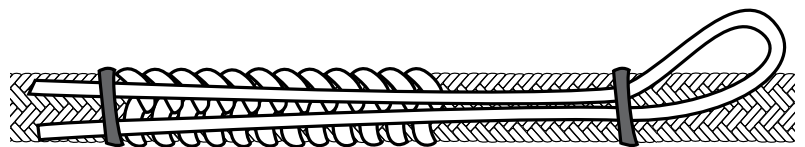
STEP 4

Continue with this procedure until the seized area is approximately 1/2 of the desired length, then cut off the taped end near the last wrap.



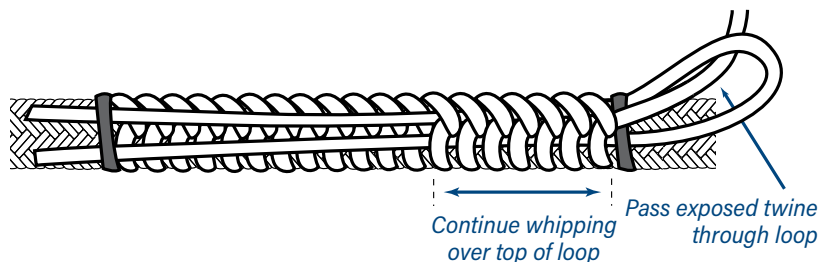
STEP 5

Using some spare twine, tape a loop that covers the length of the intended seizing distance, letting the 2 free ends of the looped twine lay over the completed seizing. Tape the free ends of the loop past the already seized area.



STEP 6

Continue seizing for the desired total length over the top of the looped twine. After seizing is complete, pass the exposed seizing twine through the loop. Remove the tape on the looped twine and pull the ends to draw the loop under the seizing.



STEP 7

Pull the loop through the seized area. This should place the remaining seizing twine under the seized area. Cut off any excess twine.

