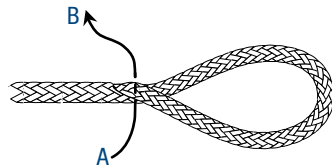


Lock Stitching Procedure



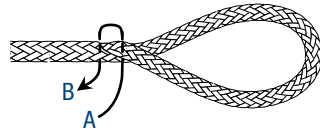
STEP 1

Pass stitching twine through spliced area near throat of eye as shown.



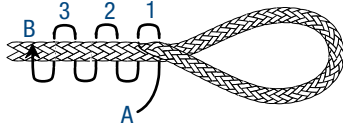
STEP 2

Reinsert twine through the rope. The twine should cover 2 strands from the exit point. Pull the twine snug, but not tight.



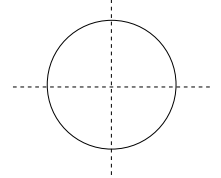
STEP 3

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



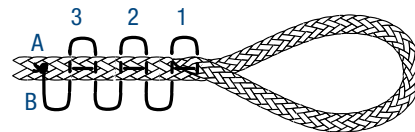
STEP 4

After completing Step 3, rotate spliced part of rope 90° and reinsert end A into spliced area in the same fashion as in Steps 1, 2 and 3. The splice will now be stitched on 2 planes perpendicular to each other. Make sure you do not pull the stitching too tight.



STEP 5

After stitching at least 3 complete stitches as in Step 3, extract both ends of the twine together through the same opening in the braid. Tie them together with a square knot and reinsert back into braid. For double braids, re-insert the knot between the cover and core.



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 approximately the same diameter as 1 strand in the rope. 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 about the same diameter as these 2 strands 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.

Whipping Method I

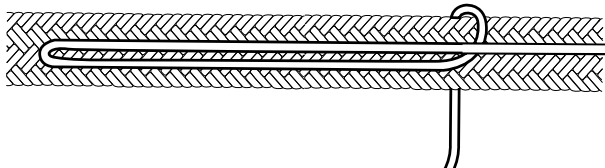
Choosing twines for whipping:

In general, braided nylon twine is preferred for whipping. Polyester twines, or twisted twines in either polyester or nylon, can also be used.

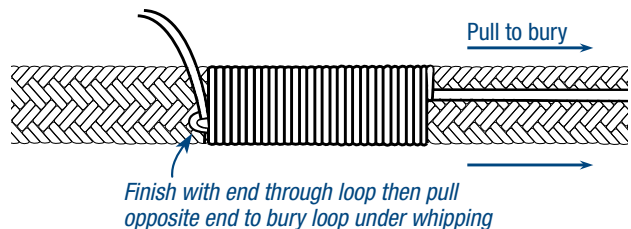
For double braids the twine used should be approximately twice the diameter of the strands in the cover.

Whip or seize 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.

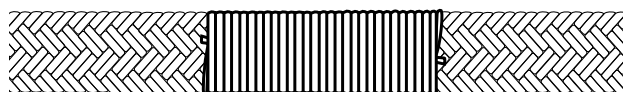
STEP 1 Form loop along the rope with whipping twine and wrap end around the back.



STEP 2 Continue wrapping at least 1 rope diameter in length.



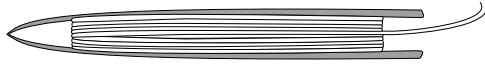
STEP 3 Cut both ends close to whipping.



Seizing Method II

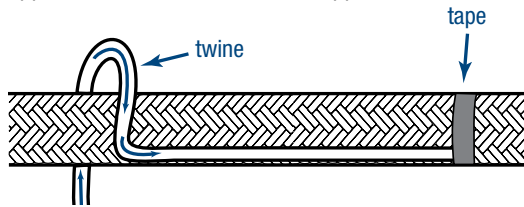
STEP 1

Attach twine to netting needle.



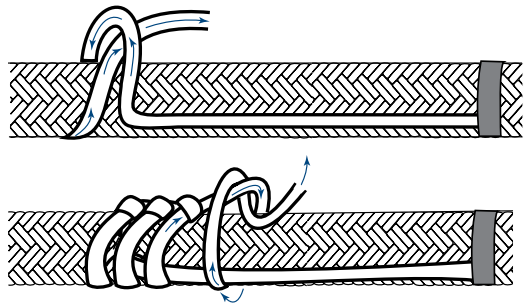
STEP 2

Tape the free end of the twine to the opposite side of the area to be whipped.



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.



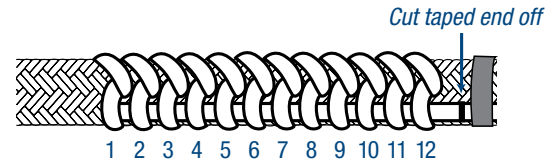
STEP 7

Pull the loop through the whipped area. This should place the remaining whipping twine under the whipped area.



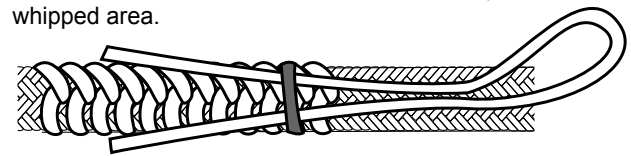
STEP 4

Continue with this procedure until the whipped 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 whipping distance, letting the 2 free ends of the looped twine lay over the completed whipping. Tape the free ends of the loop past the already whipped area.



STEP 6

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

