

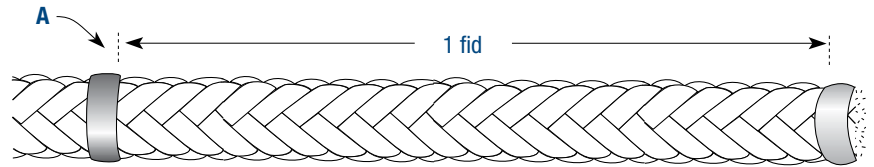


# Round Plait Class I End-For-End Splice

Class I round plait ropes are made from any or all of the following fibers: olefin, polyester, or nylon. These instructions illustrate a tuck splice that can be performed in the field on new or used rope.

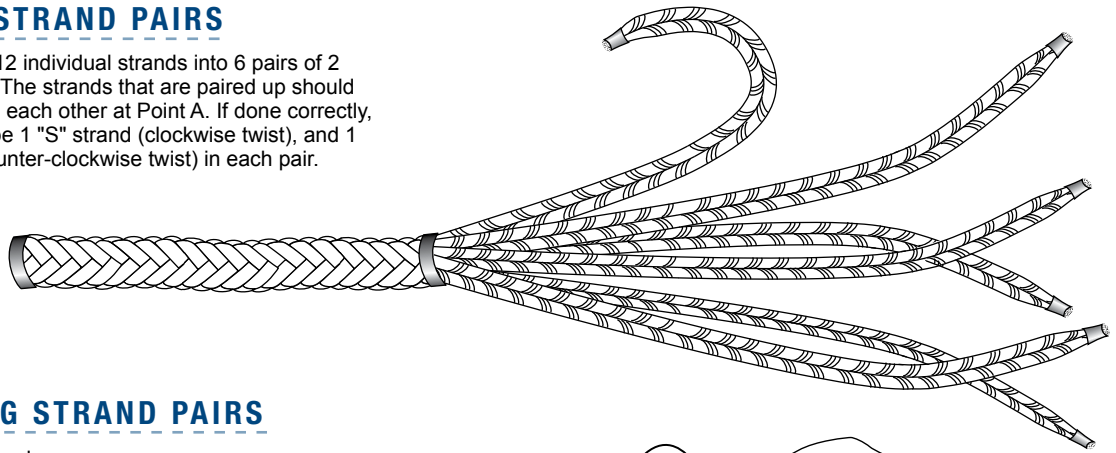
## STEP 1 MEASUREMENT

Lay out and measure from the end of each rope a length that is equal to 1 fid length. Wrap tape around the rope (Point A). Tape each of the 12 strands at the end of the rope. After the ends are taped unbraid each rope back to Point A.



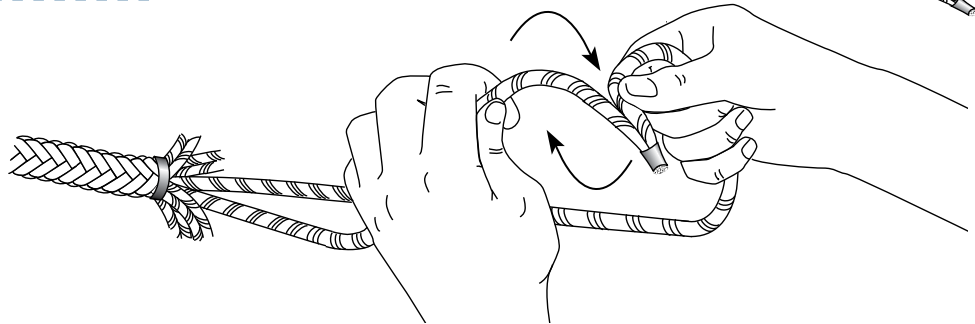
## STEP 2 TAPING STRAND PAIRS

Combine the 12 individual strands into 6 pairs of 2 strands each. The strands that are paired up should be adjacent to each other at Point A. If done correctly, there should be 1 "S" strand (clockwise twist), and 1 "Z" strand (counter-clockwise twist) in each pair.



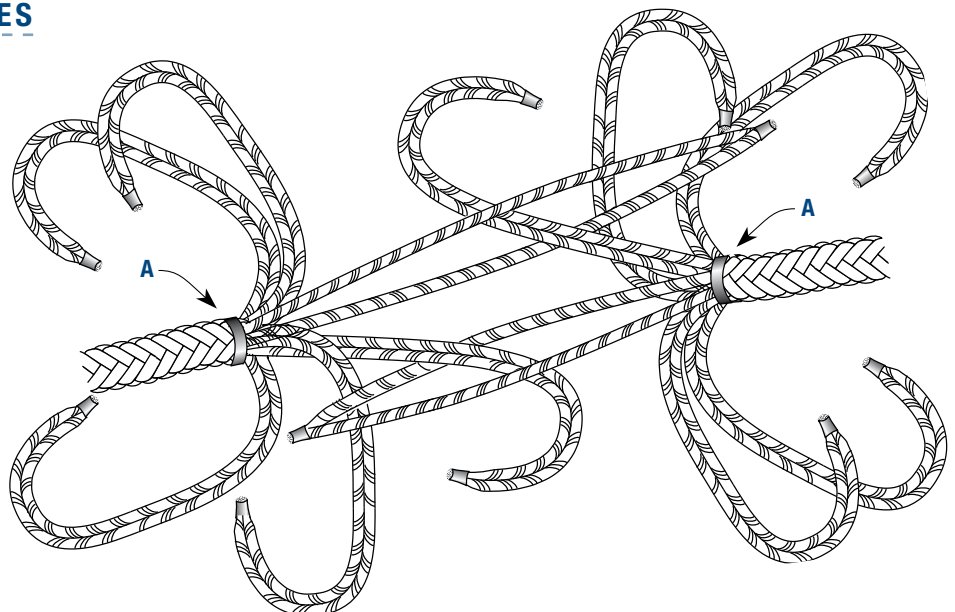
## STEP 3 TWISTING STRAND PAIRS

Tape the 2 strands together. It is desirable that these strands retain some twist. To twist the strands, hold the 2 strands as shown and rotate the taped end between the strands to retain the original twist.



## STEP 4 JOINING THE ROPES

Join the 2 ropes together at Point A and combine the pairs by starting at any 1 set of opposing set of strands and inserting 1 pair of strands between the strands of its opposite pair. This step is alternated, right, left, etc., around the rope until all pairs have been joined. Draw strand pairs tight to bring both ropes' Point As together.



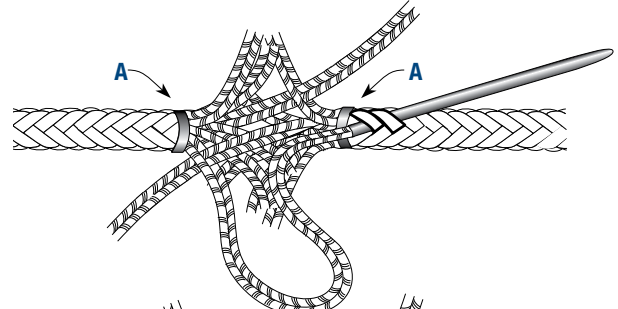


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## STEP 5 TUCKING

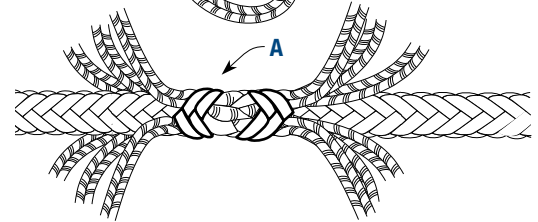
Now you can begin to tuck the pairs. 1 complete tuck consists of passing a strand pair over 1 strand and under 2 strands of the body of the rope. Pull the strands through and repeat on opposite pair, tucking straight down the body of the rope.

**TIP:** When making the tucks, don't pull the strands excessively tight but keep them twisted. This allows the tucked strands to elongate in alignment with the body of the rope, thereby preventing the tucked strands from being prematurely overloaded.

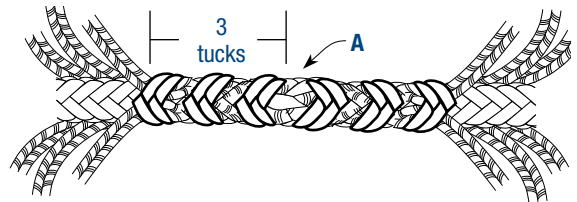


**5A** Do 1 complete set of tucks on all 12 strand pairs.

**Note:** when pulling on the strand pairs, do not attempt to pull them so tight that they become straight. It is desirable to leave the tucked strands with some twist in them so that they have the necessary elongation when the rope is placed under a load

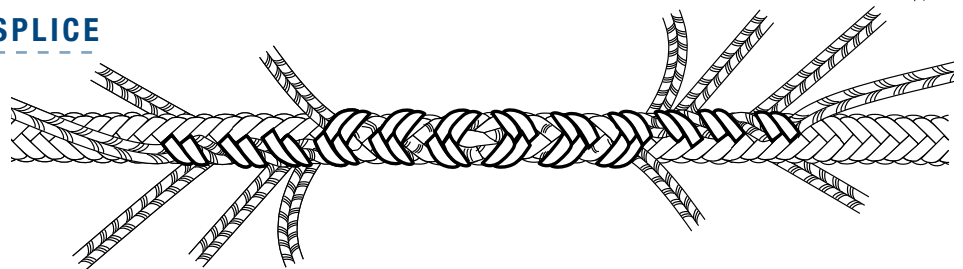


**5B** Do 3 complete tucks on each side of the splice with all 6 strand pairs. Each strand pair is always tucked under the same line of braid so that the tuck progresses straight down the body of the rope.

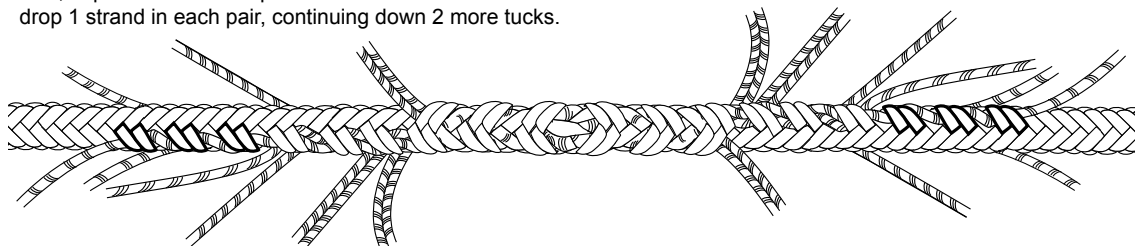


## STEP 6 TAPERING THE SPLICE

After completing the first 3 tucks drop every other strand pair and continue to do 3 more tucks with the remaining 3 pairs. This is done on each side of the splice.



**6A** Once 3 of the strand pairs have 6 full tucks on each side, separate the strand pairs into individual strands and drop 1 strand in each pair, continuing down 2 more tucks.



## STEP 7 FINISHING THE SPLICE

Once you have completed the last tucks, cut off the excess material and tape or whip the ends. Leave enough of an end protruding so that it does not slip back into the rope when it is loaded.

