



Lankhorst|*Ropes*

LANKO®FORCE – 12 strand endless splice

Splice Instruction

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LANKO®FORCE 12 strand endless splice

Splicing instructions for a LANKO®FORCE 12 strand rope in the length direction, connecting two rope ends to make one length of rope.

- Lay the rope on the floor, without any twist in the rope (one can use a black marker to make sure there is no twist is in the rope). See photo 1.
- To mark the splice length, count 12 times every other turn (see photo 2) from the bud end of the rope and place a mark on the full left hand turn.



photo 1



photo 2

- Loop the rope as shown in photo 3, place a mark on the full right hand turn, and count from this point once again 12 times every other turn (this represents the splice length for the other side).
- Place a small seizing over the full marking (the starting point of the splice), see photo 4.



photo 3



photo 4

- Cut the rope and tape each of the 12 strands at the end (see photo 5).
- Undo the braiding until the seizing set on the rope, repeat the same on the other rope end (see photo 6).



photo 5



photo 6

- Bring together the left hand strands closest to each other, as well as the right hand strands closest to each other, creating pairs. Bring together the two strands closest to each other on the left hand as well as the right hand: two by two, marking them L1-L2, R1-R2 etc. Continue doing so until all strands have paired up. Now do the same on the other rope end. See photo 7.



photo 7

- Take the pair of two left hand strands together (L1-L2) and the pair of two right hand strands (R1-R2), and repeat this for all the other pairs of strands (L3-L4,R3-R4,L5-L6,R5-R6) and do so the same on the other rope end. See photo 8A and 8B.



photo 8A



photo 8B

- At this point you will set the pair of strands into each other, pairing them up (rope 1; L1-L2 with rope 2; R1-R2, etc.) and repeat this with all the other pairs. See photo 9A en 9B.

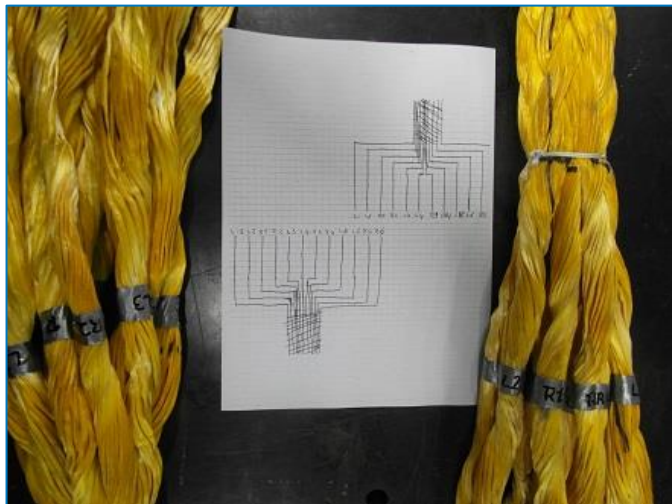


photo 9A



photo 9B

- Once all the strand-pairs have been paired up with the counter pairs, separate the pairs into 12 individual strands; do this on both the ropes. See photo 10.
- Now we can combine the L1 from one end to the L1 from the other end. The same for L2-L2 and so forth for all the other strands.

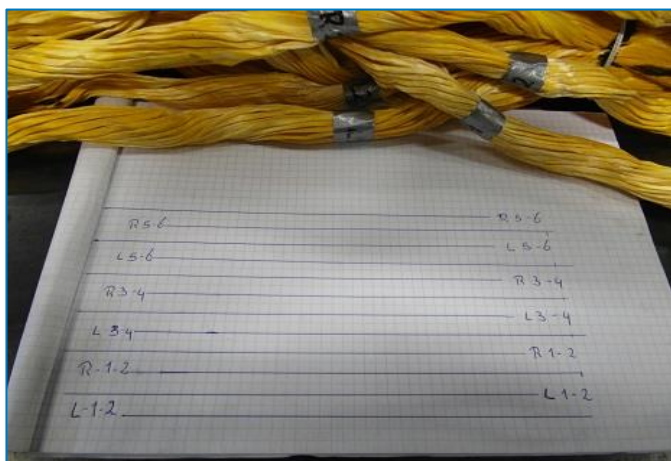


photo 10

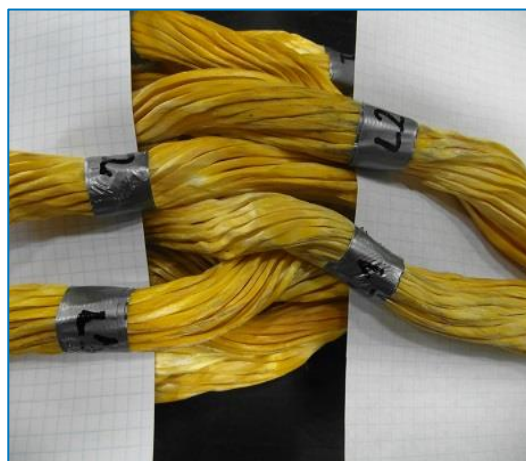


photo 11

- Once you have completed these steps, you will see a left hand strand with a left hand strand, once again a left hand strand with a left hand strand, then a right hand strand with a right hand strand and once again a right hand strand with a right hand strand. This will continue in Left-Left, Left-Left, Right-Right, Right-Right, Left-Left and so forth. See photo 12A and 12B.



photo 12A

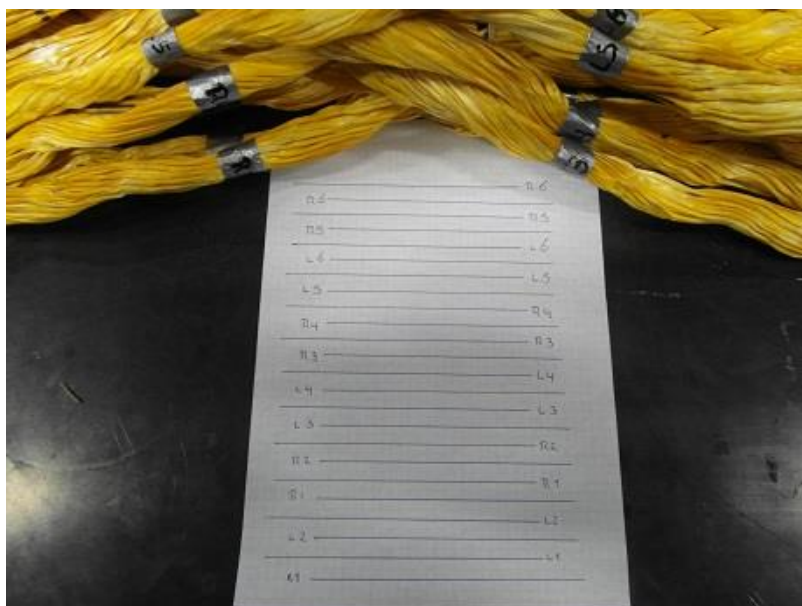


photo 12B

- Pull the two sides lightly towards each other. This will set the strands really in the crouch of the opposite rope. See photo 13A.
- Carefully cut the seizings that have been formed earlier (without cutting into the yarns of the strands). See photo 13B.



photo 13A



photo 13B

- Pull both sides again to tighten the crossings. This point of the crossings will be the middle point of your splice. Do the pulling without forcing it or disrupting the construction of the rope. Place another seizing to fix the strands, not on the middle point of the splice itself, put it a little to one side of the middle point of the splice. That leaves the other side free to make the splicing. See photo 14.



photo 14

- Now start the splicing. It will be your choice whether to start with the left hand strands or the right hand strands. It all depends which are best at hand.

The upper strands are the strands to be spliced, these are the loose strands. They are spliced in to the rope running underneath, the fixed strands.

Take one of the splicing strands (either the Left hand strand or the Right hand strand, choose the one that is closest to the seizing).

Lead the L-strand or the R-strand over a fixed strand then under the second fixed strand and repeat these steps with the second L-strand or R-strand.

Continue doing this alternating the two L-strands and the two R-strands that fit together. (Note that the L-splicing strands are always tucked under the L-fixed strands and that the R-splicing strands are always tucked under the R-fixed strands).



photo 15A



photo 15B

- Repeat these steps of “over one and under one” 3 times. Now turn the rope as a whole until you can reach the other two L-hand strands and the two R-hand strands. Tuck these 3 times “over and under” and repeat this process once again until you have done the remaining two L-hand strands and two R-hand strands. Stop here for a while at this end. See photo 16.



photo 16

- Cut the seizing and repeat the process on the other side with the three tugs tucks of splicing strands in to the fixed strand and rotating the rope. See photo 17.



photo 17

- Once you have spliced on both sides the three tucks, you can lightly pull the strands to fix the beginning of the splice properly. See photo 18.



photo 18

- Now you can continue the splicing process for both sides, tucking the loose strands over one and under one of the fixed strands until ten full tugs have been reached in total. See photo 19.



photo 19

- To finish off, tuck the first R-splicing strand or the first L-splicing strand under both the L-fixed strand or R-fixed strand (in stead of the normal “over and under”, this one goes “under and under”). The second L-splicing strand and the second R-splicing strand are to be idle and not tugged tucked in anymore. See photo 20.



photo 20

- Repeat these steps with all the splicing loose strands until all the full splicing on both sides is complete. Note; work always with the pairs of L-hand strands and the pairs of R-hand strands. Tape the ends of all strands and cut away excessive material. See photo 21A and 21B.



photo 21A



photo 21B

- The splice is now completed. Protect the splice by a PES hose.