



## Stainless Steel

Rope Ø mm fibre and steel core		Ferrules		
		Ferrule No.	Swaging Die No.	Pressed Ferrule Ø mm
min.	max.			
1,0	1,1	1	1,5	3
1,5	1,6	1,5	1,5	3
2,0	2,1	2	2	4
2,5	2,6	2,5	2,5	5
3,0	3,2	3	3	6
3,5	3,7	3,5	3,5	7
4,0	4,2	4	4	8
4,5	4,7	4,5	4,5	9
5,0	5,2	5	5	10
6,0	6,3	6	6	12
7,0	7,3	7	7	14
8,0	8,3	8	8	16
10,0	10,4	10	10	20
12,0	12,4	12	12	24
14,0	14,4	14	14	28
16,0	16,5	16	16	32
18,0	18,5	18	18	36
20,0	20,5	20	20	40
22,0	23,0	22	22	44
24,0	25,0	24	24	48
26,0	27,0	26	26	52
28,0	29,0	28	28	56

Wire ropes with only one layer of wires per strand (such as 6 x 9 + 7fc., 6 x 12 + 7fc., 6 x 15 + 7fc., 6 x 18 + 7fc.)\* are not suitable for swaging.

Use only CYLINDRICAL DIES WITHOUT CUTTING EDGES which are marked accordingly.

Ensure that ferrule and swaging die numbers correspond.

\*fc. = "fibre core"

### Proceed as follows:

- Select appropriate ferrule for the rope as per splicing table.
- Thread rope through ferrule and form a loop as required or over a thimble.
- Lubricate the bore of the swaging dies before each swaging operation.
- Place ferrule with rope in centre of the lower half of swaging die. Ensure during swaging operation that the ferrule is positioned in swaging die vertically and not tilted.
- Swaging is completed when swaging die faces make contact.
- Release swaging dies.