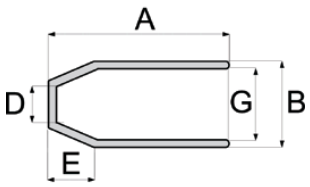
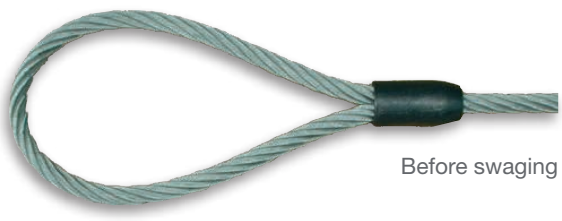
Steel Flemish Eye



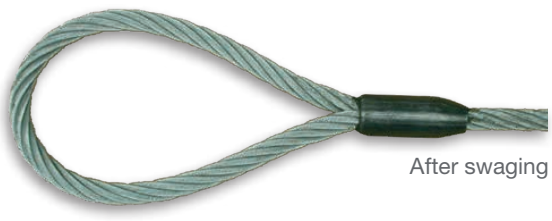
Ferrule dimensions

Ferrule No. inch	Rope Ø mm	Swaging Die No.	Nominal Ferrule-Dimensions mm					Max. Pressed Ferrule Ø mm
			A	B	G	D	E	
¼"	6	¼"	25	16,8	12,0	7,9	7,1	14,5
5/16"	8	⅜"	38	23,0	15,8	9,7	11,2	19,1
⅜"	9 - 10	⅜"	38	23,0	16,7	11,9	9,9	19,1
7/16"	11	½"	51	31,0	21,4	14,3	16,5	25,7
½"	12 - 13	½"	51	31,0	23,0	15,9	14,2	25,7
9/16"	14	⅝"	70	37,3	26,2	17,8	16,0	31,5
⅝"	16	⅝"	70	37,3	27,8	19,1	16,0	31,5
¾"	19	¾"	81	43,7	32,5	23,1	21,3	37,1
⅞"	22	⅞"	90	51,6	38,9	26,0	25,4	42,7
1"	25 - 26	1"	102	58,0	43,7	30,0	28,6	49,0
1⅛"	28	1⅛"	122	63,5	49,2	33,0	31,8	54,1
1¼"	32	1¼"	132	70,6	54,8	37,0	35,8	58,9
1⅜"	34 - 36	1⅜"	148	76,2	60,3	40,0	39,7	64,0
1½"	38	1½"	159	82,6	66,7	44,0	42,9	68,8
1¾"	44	1¾"	184	97,6	79,4	50,0	50,0	78,7
2"	50 - 52	2"	216	111,0	92,1	58,0	57,0	90,4
2¼"	56	2¼"	243	127,8	102,4	64,0	64,5	104,6
2½"	62 - 64	2½"	267	139,7	114,3	70,0	71,5	114,3
2¾"	68 - 70	2¾"	292	146,0	120,0	76,0	78,5	119,4
3"	76 - 77	3"	305	152,4	127,0	83,0	86,0	126,0
3¼"	82 - 84	3¼"	330	165,0	138,0	98,0	90,0	136,5
3½"	87 - 89	3½"	356	178,0	148,0	99,0	100,0	146,6
3¾"	93 - 96	3¾"	381	191,0	160,0	103,0	108,0	158,2
4"	100 - 105	4"	406	206,0	173,0	111,0	114,0	169,9
4½"	112 - 114	4½"	457	232,0	195,0	124,0	129,0	189,2
5"	126 - 128	5"	508	267,0	222,0	140,0	143,0	222,3
6"	152 - 156	6"	610	319,0	259,0	165,0	171,0	264,0

Dies 1/4" through to 1" are tapered dies.
Sleeves 1.1/8" and above require 1st and 2nd stage dies.
2nd stage dies for 1.1/8" through to 1.3/4" are tapered dies.
Both 1st and 2nd stage dies for sleeves from 2" and upwards are plain bore with no taper.



Before swaging



After swaging

Splicing instructions for our Flemish Eye ferrules

1. Allocation ferrule to wire rope

Select the appropriate ferrule according to our splicing table. Wire rope constructions with a metallic cross-sectional area factor of less than 0,283 should not be used. These splicing instructions work for wire rope constructions according to EN 12385-4. Wire rope constructions with a tensile grade above 1960 N/mm² should not be used.

2. Preparation of the rope

Slide the ferrule down the rope. Un-lay the wire rope. For IWRC rope 3 strands and core in one group and 3 strands in the other group. For FC rope un-lay with 3 strands in each group and cut away the fibre core. Cross and lay the one group of strands into the other group of strands forming a natural weave. Continue to reweave the group of strands together to form the eye. The remaining tails must be as long as the cylindrical part of the ferrule. At the end of the eye collect the tails around the outside of rope dispersing equally and slide the ferrule over the tails and as far up towards the eye as possible.

3. Installation and condition of the tooling

Swaging die faces with corresponding numbers need to be precisely aligned in the die pocket. Dies 1/4" through to 1" are tapered dies. Sleeves 1.1/8" and above require 1st and 2nd stage dies. 2nd stage dies for 1.1/8" through to 1.3/4" are tapered dies. Both 1st and 2nd stage dies for sleeves from 2" and upwards are plain bore with no taper.

4. Swaging procedure

A competent person, trained in ferrule securing shall carry out the procedure.

First stage dies

- Lubricate both die bores.
- Close dies until initial contact is made between ferrule and die (STEP 1).
- Swage down ½ the distance and then rotate the ferrule 45-90° (STEP 2).
- Repeat STEP 2 three times.
- Swage down until die faces meet with 5th pass.
- Rotate again ferrule 90° and swage down until die faces meet.
- Swap dies.

Second stage dies

- Lubricate both die bores.
- Carry out STEP 2 six times.
- Swage down until die faces meet with 7th pass.
- Rotate ferrule 90°.
- Swage down until die faces meet and ferrule is round.

5. Ferrules after swaging

The temperature limits when used with a steel core wire rope are -60° to +250° C

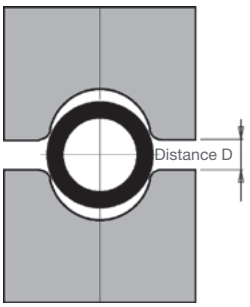
6. Marking the ferrule

If the Ferrule Secured Eye Termination (FSET) forms part of a wire rope assembly other than a sling:

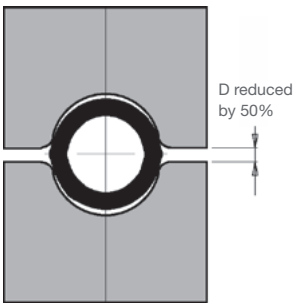
- the ferrule shall be legibly and indelibly marked with the FSET manufacturer's name, symbol or mark; and
- the assembly shall be legibly and durably marked with the traceability code identifying the assembly with the certificate in 7.2. of EN 13411-3.

For FSET forming part of a sling you will find further details in the standard EN 13414-1 ANY STAMPING should be carried out using rounded character stamps and to a maximum depth of 0,4mm.

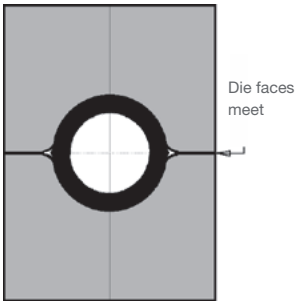
The area for stamping should be restricted to the sleeve surface along the plane of the eye. Stamped characters should start or finish a minimum of 6mm from either end of the sleeve.



STEP 1



STEP 2



FINAL STEP