ELECTROLINE®
WIRE & SYNTHETIC ROPE TERMINATIONS

MZ1900

ASSEMBLY PROCEDURES

For All 6X Strand Rope Construction with Independent Wire Rope Core (without jacket or jacket removed on rope end)

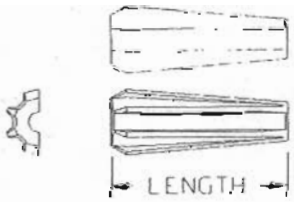
Electroline terminations have been used with ropes since 1933. Ease of installation and the ability to inspect after assembly contribute to the continued acceptance of these fittings. Following these simple steps is your assurance of a durable installation. However, many factors determine the safety of any rope assembly. PLEASE OBSERVE ALL USE AND CARE INSTRUCTIONS SUPPLIED WITH THE CABLE.

TOOLS NEEDED:*vise jaws hammerscrewdriver
***plug driver wrenchvise**

***Vise jaws with a hole 1/32" less than the diameter of the rope are recommended to prevent damage to the rope during assembly. The plug driver (a metal tube) aids in seating the plug and also bending the strands behind the plug after seating. These assembly kits are available from Esmet.**

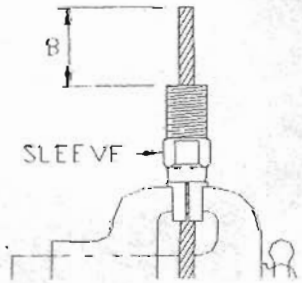
ROPE SIZE	ASSEMBLY KIT #
9/16	SP-307-M
5/8	SP-307-N
3/4	SP-307-P
7/8	SP-307-Q
1	SP-307-R
1 1/8	SP-307-S
1 1/4	SP-307-T
1 3/8	SP-307-V
1 1/2	SP-307-W

STEP 1:DETERMINE THAT THE PLUG IS CORRECT. The 2 piece copper alloy plug should look like the drawing shown. Make sure the length matches your rope size as described on the chart.



ROPE SIZE	PLUG PART #	LENGTH
9/16	MZ 1956	1 7/8
5/8	MZ-1962	2 7/32
3/4	MZ-1975	3 1/32
7/8	MZ-1987	3 7/8
1	MZ-1999	3 15/16
1 1/8	MZ-19112	5 7/8
1 1/4	MZ-19125	6 15/16
1 3/8	MZ-19137	8 1/4
1 1/2	MZ-19150	8 1/4

STEP 2:TWIST THE SLEEVE OVER THE ROPE AND SECURE THE ROPE IN THE SPECIAL VISE JAWS. If the rope has seizing, it may be easier to install the sleeve after the seizing has been removed. Before tightening the vise, be sure enough rope extends beyond the sleeve, as shown on the chart.



WIRE ROPE SIZE	$B^{+1/8}_{-0}$
9/16	1 5/8
5/8	1 5/8
3/4	1 7/8
7/8	2 1/4
1	2 3/4
1 1/8	3 1/8
1 1/4	3 5/8
1 3/8	4 5/16
1 1/2	5 1/8

--please see other side--

MZ1900 (REV.A)
RATED FOR 100% OF IPS ROPES
FOR OTHER ROPES, CONSULT FACTORY

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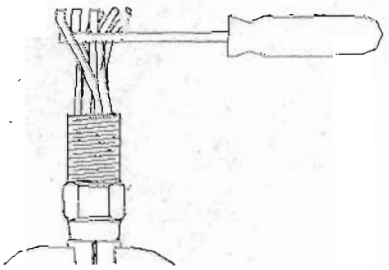
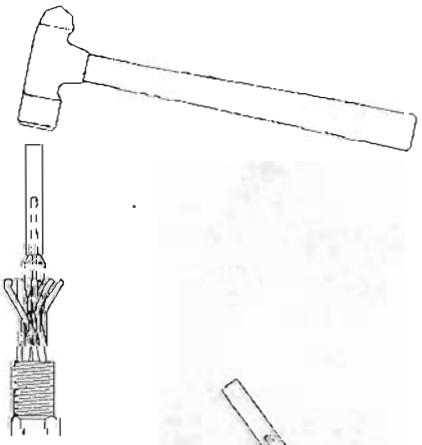
MANUFACTURED BY Esmet inc

--continued--

STEP 3:UNLAY THE ROPE. Gently force a screwdriver between the outer strands to unlay the rope. When done correctly, the six outer strands will form a symmetrical basket. Do not straighten out the spiral lay of the strands, unlay any wires that make up the strand, or allow the strands to cross each other inside the sleeve.

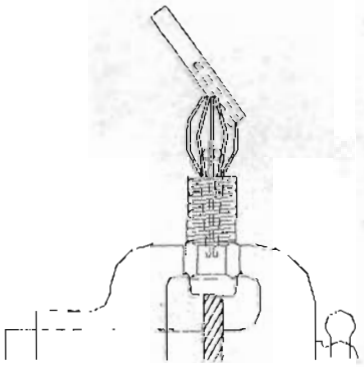


STEP 4:INSTALL THE PLUG. Place the two plugs around the center core of the rope. Use a metal tube (plug driver) and hammer to drive the plug into the sleeve while assuring that the outer strands are spaced somewhat equally around the plug. Drive the plug until firmly seated and no more than 1/3 of the plug is visible above the sleeve.

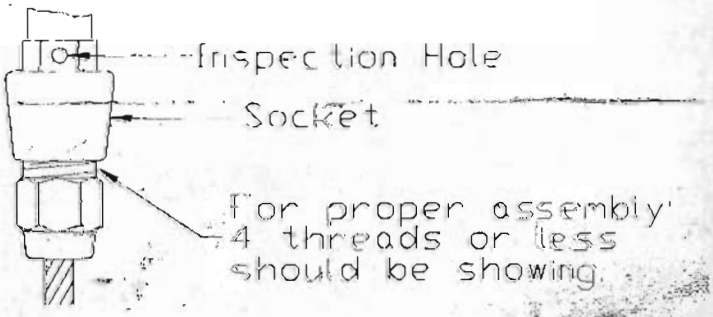


STEP 5:FORM THE ROPE AROUND THE PLUG. Reclamp the assembly in the vise on the flats of the sleeve. Using the plug driver, a metal tube or pliers, bend the six outer strands toward the center strand enough that the socket can be slipped over all the strands. On larger ropes, a hose clamp may be helpful.

STEP 6:INSTALL THE SOCKET. By twisting the socket over the strands, engage the threads and tighten until four or fewer threads are visible. If more than four threads are visible, proof load the cable and retighten the end fitting. (There is no specific requirement for torque). CAUTION: When assembling Stainless Steel parts, all threads must be coated with a dry film lubricant (MIL-L-23398) or an anti-seize lubricant (MIL-A-907) to prevent seizing.



STEP 7:INSPECT FOR PROPER ASSEMBLY. Prior to proof loading, strands visible through the inspection hole are your assurance of a proper assembly. The end of the rope may not be visible in the inspection hole after proof loading.



Certain dynamic applications may require a fastening device (i.e. set screw, lockwire, etc.) to retain the sleeve in the socket.Please contact the factory if this condition exists.The socket can be removed from the sleeve at any time for inspection of corrosion or excessive seating due to overloading.This will not affect the holding efficiency of the sleeve and plug.

(PERIODICALLY INSPECT SLEEVE FOR TIGHTNESS)

ANY QUESTIONS? PLEASE CONTACT OUR ENGINEERING DEPARTMENT.

1-800-321-0870