

DROP FORGED WIRE ROPE CLIPS are useful for field installation of eyes in wire rope. With correct installation using a torque wrench, this type of termination can create 80% efficiency when used with 6 x 19 / 6 x 36 class wire rope.

It is important that installation instructions are followed carefully and the table below outlining minimum clips to be used and torque to be applied **is strictly adhered to**.

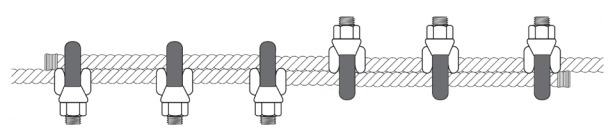
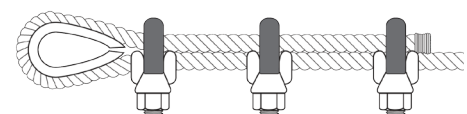
Installation

1. Turn back specified amount of rope (see table) from thimble or loop. Apply first clip one base width from dead end of rope. Apply U-bolt over dead end of wire rope - live end rests in saddle (Never saddle a dead horse!). Tighten nuts evenly, alternating from one nut to the other until reaching the recommended torque.

2. Apply the second clip as near the loop or thimble as possible. Tighten nuts evenly, alternating until reaching the recommended torque. When more than two clips are required, apply the second clip as near the loop or thimble as possible, turn nuts on second clip firmly, but do not tighten. Proceed to Step 3.

3. When three or more clips are required, space additional clips between first two - take up rope slack - tighten nuts on all clips, alternating from one nut to the other until reaching the recommended torque.

4. Apply an initial load equal to or greater than the loads expected in use. Inspect for proper spacing and re-tighten the nuts to the recommended torque.



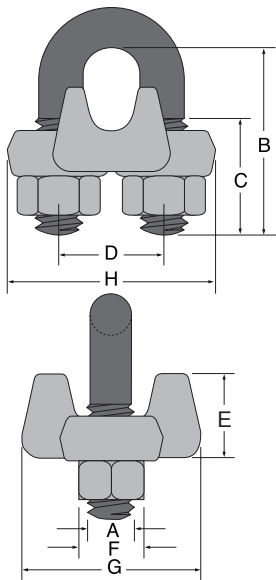
Size Inches	Minimum Clips Per Eye	Amount of Rope to Turn Back Inches	Torque in Foot-Pounds	Weight per Piece Pounds
1/8	2	3-1/4	4.5	0.06
3/16	2	3-3/4	7.5	0.10
1/4	2	4-3/4	15	0.19
5/16	2	5-1/4	30	0.28
3/8	2	6-1/2	45	0.48
7/16	2	7	65	0.78
1/2	3	11-1/2	65	0.80
9/16	3	12	95	1.09
5/8	3	12	95	1.10
3/4	4	18	130	1.42
7/8	4	19	225	2.12
1	5	26	225	2.52
1 1/8	6	34	225	2.83
1 1/4	7	44	360	4.38
1 3/8	7	44	360	4.42
1 1/2	8	54	360	5.44
1 3/4	8	61	590	9.34
2	8	71	750	13.00

Maintenance & Use

Wire Rope clips should be inspected frequently to make sure there is no wire rope slippage, indication of wire rope damage, improperly installed clips, loose or improperly tightened nuts and any signs of fatigue, wear or corrosion on the clip. Periodical re-tightening of nuts to torque values may be required. Wire rope clips should not come into contact with any loads or obstruction during lifts or when installed in static environments. Shock loading should be avoided at all times and using wire rope clips for lifting slings is prohibited. When joining two wire ropes with wire rope clips they must be installed as per diagram opposite. **NEVER** use wire rope clips with plastic coated wire rope.

ProCraft Drop Forged Wire Rope Clips

Drop forged wire rope clips are used for heavy duty applications or where loading conditions are severe. Precision manufactured and galvanized to meet the performance requirements of Federal Specifications FF-C-450, Type 1, Class 1. The base is drop forged and hot dipped galvanized for the toughest conditions. Please see installation instructions on page 25.



Stock Code	Wire Rope Diameter	Minimum Clips Per Eye	Dimension Inches								Weight per Piece Pounds
			A	B	C	D	E	F	G	H	
22FG-04	1/8	2	0.22	0.72	0.44	0.47	0.37	0.38	0.81	0.99	0.06
22FG-06	3/16	2	0.25	0.97	0.56	0.59	0.50	0.44	0.94	1.18	0.10
22FG-08	1/4	2	0.31	1.03	0.50	0.75	0.66	0.56	1.19	1.43	0.19
22FG-10	5/16	2	0.38	1.38	0.75	0.88	0.73	0.69	1.31	1.66	0.28
22FG-12	3/8	2	0.44	1.50	0.75	1.00	0.91	0.75	1.63	1.94	0.48
22FG-14	7/16	2	0.50	1.88	1.00	1.19	1.13	0.88	1.91	2.28	0.78
22FG-16	1/2	3	0.50	1.88	1.00	1.19	1.13	0.88	1.91	2.28	0.80
22FG-18	9/16	3	0.56	2.25	1.25	1.31	1.34	0.94	2.06	2.50	1.09
22FG-20	5/8	3	0.56	2.25	1.25	1.31	1.34	0.94	2.06	2.50	1.10
22FG-24	3/4	4	0.62	2.75	1.44	1.50	1.39	1.06	2.25	2.84	1.42
22FG-28	7/8	4	0.75	3.12	1.62	1.75	1.58	1.25	2.44	3.16	2.12
22FG-32	1	5	0.75	3.50	1.81	1.88	1.7	1.25	2.63	3.47	2.52
22FG-36	1 1/8	6	0.75	3.88	2.00	2.00	1.91	1.25	2.81	3.59	2.83
22FG-40	1 1/4	7	0.88	4.44	2.22	2.34	2.17	1.14	3.15	4.13	4.38
22FG-44	1 3/8	7	0.88	4.44	2.22	2.34	2.31	1.44	3.13	4.19	4.42
22FG-48	1 1/2	8	0.88	4.91	2.38	2.59	2.44	1.44	3.41	4.44	5.44
22FG-56	1 3/4	8	1.13	5.75	2.75	3.06	2.92	1.81	3.81	5.74	9.34
22FG-64	2	8	1.25	6.44	3.00	3.38	3.03	2.00	4.44	5.88	13.00