



SLEEVES

SWAGING SLEEVES



Vanguard Steel Ltd.



www.vanguardsteelvancouver.com
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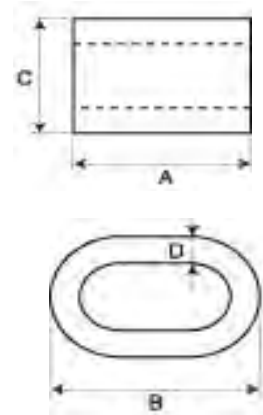


Duplex Eye Sleeves

Duplex Oval Steel Sleeves are recommended for use on 6 x 19 or 6 x 37 IPS or XIP, EIP, RRL, FC or IWRC wire rope.



Rope Size	Dimension Inches				Weight lbs/pc	Product Code
	A	B	C	D		
5/16"	1.250	1.080	0.810	0.190	0.17	29580020
3/8"	1.250	1.120	0.810	0.140	0.13	29580024
7/16"	1.630	1.410	1.020	0.190	0.31	29580028
1/2"	1.630	1.440	1.020	0.160	0.27	29580032
9/16"	2.250	1.720	1.230	0.230	0.63	29580036
5/8"	2.250	1.840	1.280	0.200	0.54	29580040
3/4"	2.630	2.160	1.520	0.230	0.90	29580048
7/8"	2.880	2.500	1.750	0.270	1.26	29580056
1"	3.060	3.840	2.000	0.330	1.87	29580100
1-1/4"	4.060	3.500	2.500	0.380	3.84	29580116



"Non-tapered" for turn-back loop

Specially processed low carbon steel

If using any other type of construction or grade of wire rope it is recommended to make a breaking load test of the swaged termination to prove the adequacy of the assembly to be manufactured.

Just one step will finish the swaging, turning the sleeves 90 ° and swaging again is not recommended.

**Inspect swaging dies frequently for nicks or scratches, which should be polished out!
Apply lubricants to the die blocks prior to swaging!**

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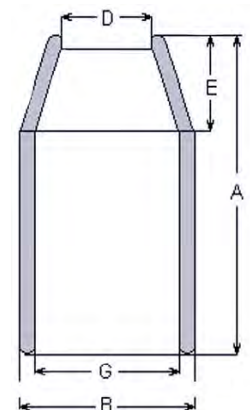


Flemish Eye Sleeves

Flemish Eye Carbon Steel Sleeves are recommended for use on 6 x 19 or 6 x 37 IPS or XIP, EIP, RRL, FC or IWRC wire rope.



Rope Size	Dimension before swaging Inches					Max. after swage		Weight lbs/pc	Product Code	
						Dim. Inches				
						Stages				
	A	B	D	E	G	1	2			
1/4"	1.00	0.66	0.31	0.28	0.47		0.57	2.27	29560016	
5/16"	1.50	0.91	0.38	0.44	0.62		0.75	6.36	29560020	
3/8"	1.50	0.91	0.47	0.39	0.66		0.75	6.36	29560024	
7/16"	2.00	1.22	0.53	0.65	0.85		1.01	14.89	29560028	
1/2"	2.00	1.22	0.63	0.56	0.91		1.01	13.17	29560032	
9/16"	2.75	1.47	0.70	0.63	1.03		1.24	29.06	29560036	
5/8"	2.75	1.47	0.75	0.63	1.09		1.24	25.42	29560040	
3/4"	3.19	1.72	0.91	0.84	1.28		1.46	38.85	29560048	
7/8"	3.56	2.03	1.03	1.00	1.53		1.68	59.47	26590056	
1"	4.00	2.28	1.19	1.13	1.72	2.00	1.93	88.53	29560100	
1-1/4"	4.81	2.50	1.28	1.25	1.94	2.25	2.13	117.04	29560108	
1-1/2"	5.19	2.78	1.44	1.41	2.16	2.50	2.32	161.17	29560116	
1-3/8"	5.81	3.00	1.56	1.56	2.36	2.75	2.52	192.04	29560124	
1-1/2"	6.25	3.25	1.69	1.69	2.63	2.87	2.71	226.55	29560132	
1-3/4"	7.25	3.84	1.94	1.97	3.13	3.84	3.10	365.50	29560148	
2"	8.50	4.38	2.25	2.25	3.63	3.81	3.56	514.00	29560200	



Note

The cold swaging of sleeves is a delicate process, requiring considerate movement of the steel in the fitting, as it is forced under great pressure to flow into the crevices between wires and strand, as well as elongating parallel to the wire rope. For this reason, swaging must be performed by way of multiple pressings. This will also prevent excessive 'flashing', a term used to describe the material which is squeezed out into the area between the die faces.

Excessive flashing can result in scoring and/or cracking of the sleeves!

Inspect swaging dies frequently for nicks or scratches, which should be polished out!

Apply lubricants to the die blocks prior to swaging!

After swaging, measure the OD of the sleeve and compare the results against the figures shown in the table to assure that the sleeve has been properly swaged.

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