



SWAGING SLEEVES

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**VANGUARD STEEL LTD.**

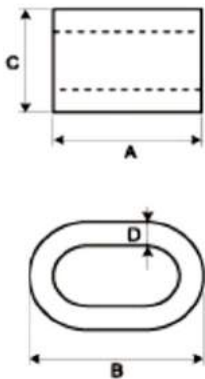


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## Duplex Eye Sleeves

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.

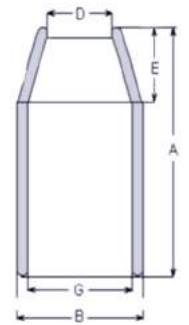
**Inspect swaging dies frequently for nicks or scratches, which should be polished out!  
Apply lubricants to the die blocks prior to swaging!**

## 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		1	2					
	A	B	D	E	G				
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
1-1/8"	4.81	2.50	1.28	1.25	1.94	2.25	2.13	117.04	29560108
1-1/4"	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.**



### General Warnings

All Vanguard rigging products are sold with the express understanding that both the purchaser and the end user are thoroughly familiar with the safe, proper and acceptable applications of the products.

It is the responsibility of the end user to establish proper safety programs and to provide thorough training for all personnel prior to use. The training programs must meet any federal/provincial/state/local code requirements, existing plant/site safety rules and regulations, and all instructions provided in the applicable section of this catalogue.

Product failure can occur due to abuse, misapplication, lack of maintenance, use by unqualified personnel and improper inspection prior to use. **Any failure of rigging products may result in property damage, personal injury and even death!!!!**

### Standards

There are numerous government and industrial standards that cover rigging products. This catalogue makes no attempt to reference all of them; it references to the standards that are most frequently asked about.

### Working Load Limit (WLL) – Safe Working Load (SWL)

The Working Load Limits shown in this catalogue are applicable to products that are new or “in as new” condition. The Working Load Limits ratings refer to the maximum amount of force or load that the rigging product can carry under normal working/environmental conditions. The Working Load Limits and Design Factor can be affected by wear, misuse, overloading, shock loading, side loading, corrosion, deformation, product alteration and other use conditions. Inspection of rigging products prior to use is required to determine whether the product continues to meet the assigned WLL provided in this catalogue, should be used at a reduced rating or removed from service.

**The WLL rating must never be exceeded!!!!**



### General information disclaimer

The contents contained in this publication are for general information only.

Although every effort has been made to assure the accuracy of the information at time of print, persons who use the Catalog should note that ratings, laws, rules, and policies change from time to time and that these changes may alter the information contained in this publication.

Vanguard Steel Ltd. assumes no liability for Catalog errors or omissions.

It is the responsibility of each person who uses this Catalog to ascertain current information that pertains to the individual lifting program, particularly with regard to satisfactory safety compliance requirements. Check your Provincial and Local safety standards before any operation or lift is attempted.

It is the responsibility of the person/operator to frequently search for updated reference information.

Do not use lesser than matching Grade components for any lifting application !

Do not use Slings, Chains or Accessories with signs of wear or deformation !

Inspections - Each day before being used, the sling and all fastenings and attachments shall be inspected for damage or defects by a competent person designated by the employer. Additional inspections shall be performed during sling use where service conditions warrant. Damaged or defective slings shall be immediately removed from service.