

Main Items Required For Serving Procedure:



Serving Procedure

Select bobbin of correct size serving wire and load onto serving mallet. See Table 1.



Ensure serving wire is correctly wound around the serving mallet and check for correct tension. Too much tension will cause the wire to snap. Not enough tension and the serving wire will not grip the rope.



Wrap the serving wire around the rope 4-5 times to start the serving and twitch to ensure it is gripped to the rope.



Rotate the serving mallet around the wire rope and create a serving that is at least 6 x the rope diameter.



End the serving by wrapping a further 4-5 loops and twitching the wire, then cut the serving wire.



Clean the new serving with a cloth and cover with flux.

Heat the solder hammer until extremely hot but do not let it get hot enough to glow red.



Using the solder hammer apply solder to one side of the rope along the length of the serving. Once cooled, remove excess wire used for twitching.



Test Sample Preparation For Multi-Strand Ropes

Serve the rope either side of the intended cut position using annealed mild steel wire (not strand).

The diameter of the serving wire shall be selected to suit the rope diameter in line with Table 1 (the size of serving wire is not critical but should not be too thin and weak nor too thick that it will not form tight around the rope).

Two servings should be applied either side of the intended cut position, each serving to be at least 6 x rope diameters in length and approximately 1 rope diameter apart, see diagram.

Using a heavy soldering iron apply solder to one side of the rope along each length of serving to lock the wires together, see photograph.

Make the cut using an abrasive disc cutter.

