

## POTTING PROCEDURE: PHILLYSTRAN® PSWR

360-2/06

**Caution:** All work must be performed in a well ventilated area.

### PREPARATION OF THE PHILLYSTRAN® PSWR ROPE END:

1. Insert the rope through the base of the fitting until it extends a sufficient distance from the fitting mouth to permit end preparation.
2. Measure and mark off the length of the jacket to be removed. This length is primarily dependent upon the depth of the fitting basket; however, allowances also must be made:
  1. To insure that the rope end will not protrude above the potting medium in the finished termination.
  2. To permit the jacket to be split and extend 1/2 the basket length into the fitting.

**Example:** Fitting basket length 4". Remove 2" of jacket. Split 1-1/2" of jacket and leave remaining 1/2" intact (area located at base of fitting).

3. Wrap vinyl tape over the rope end where it will extend into the fitting to increase the rope diameter and provide a snug fit.
4. Remove the jacket, splitting and severing it, using a soldering gun equipped with a cutting tip. Be sure the heat generated by the gun does not exceed 500°F (260°C). Split the jacket into three or four sections.
5. Unlay the bare end of the rope down to the individual fibers forming a broom. Where bundles of fibers have been wrapped with a single yarn to hold them together during manufacture, unwrap the yarn to completely free the fibers.  
**Figure 1** shows a PSWR finished end ready to be potted .
6. Pull the broomed rope end down into the fitting, positioning it so that the jacket extends the proper distance into the basket and the upper end of the broom will be completely embedded in the potting medium. Make sure the fibers are evenly distributed within the basket.
7. Seal the area where the rope enters the fitting with putty or duct seal to prevent leakage of the resin from the basket.
8. Secure the fitting in a vertical position being sure that the axes of the fitting and rope are in line and that the sealant at the base of the fitting remains in tight contact with the fitting and rope. **Figure 2**

### MIXING POURING AND CURING

**Note:** Socketfast Blue, the resin potting compound used to terminate Phillystran® PSWR rope, is a two component system available in pre-measured units. Once mixed, the compound has a gel time or pot life of 20-30 minutes at 70°F (21°C). Gel time increases at lower temperatures and decreases at higher temperatures. The compound is designed for optimum application performance at 75°F (23.9°C), and should not be used at material temperatures below 65°F (18.3°C) or above 85°F (29.4°C). When the ambient temperature is out of this acceptable range it will be necessary to warm or cool both the fitting and the resin components, prior to mixing and pouring.



**Figure 1**



**Figure 2**



**Figure 3**

1. Mix the potting compound following the manufacturer's directions.
2. Because of the density of the Phillystran® PSWR fiber broom when pulled down into the fitting basket, it is necessary to form a channel for the potting medium to insure complete saturation of the broom. This is accomplished by inserting a narrow stick into one side of the basket and gently moving the fibers to one side. The mixed potting compound is then poured into the resulting channel at a rate which allows displaced air to escape and which does not flood the top of the basket. **Figure 3** After a few minutes, it may be necessary to add more potting compound to fill the basket. With the basket full, the displaced fibers are moved back into their original position to assure even distribution within the fitting.
3. After the compound has gelled, wait 30 minutes or until the heat has dissipated before moving the assembly.
4. A cure period of 24 hours at 65°F (18.3°C) or higher is required to attain satisfactory holding power. Curing at lower ambient temperatures can be accomplished by placing and maintaining the finished termination in a temperature environment of 65°F (18.3°C) or higher.

**CAUTION: Break Strength:** The breaking strength of a rope is the load at which a new rope will break when tested under laboratory conditions. Break strength should not be mistaken for safe working load. **Safe Working Load:** Because of the wide range of rope use, rope condition and the degree of risk of life or property, it is not possible to make a blanket recommendation for safe working load. It is ultimately dependent on the rope user to determine what percentage of break strength is their own safe working load. **Wear:** Ropes wear out with use; the more severe the usage, the greater the wear. It is often not possible to detect wear on a rope by visible signs alone. Therefore, it is recommended that the rope user determine a retirement criteria for ropes in their application. For assistance in developing safe working load and retirement criteria for each application please call or write Phillystran, Inc.

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