

# WIRE & DYFORM RIGGING SYSTEMS

## SWAGE TERMINALS

Swage terminals are principally used to terminate 1 x 19 stainless steel wire strand and Dyform. They may also be used on flexible wire ropes with a wire core. All swaging machines work by firmly squeezing the material of the terminal into the interstices of the wire. In the Wire Teknik roller swaging machine (detailed on page 29) the terminal is drawn through passive rollers. All types of machine can produce a swage as strong as the wire when adjusted and used correctly. Other acceptable methods of swaging include hydraulic presses with suitable die sets and rotary hammer swaging.

Gibb swage terminals are manufactured from 316 stainless steel. Lesser grades do not have sufficient corrosion resistance, particularly in tropical waters. Material hardness is controlled to ensure ease of swaging. Gibb swage terminal dimensions comply with the US military standard that has been used exclusively for many years in the USA, UK and Australia. All terminals are compatible with current UK and US practice as regards pin sizes and fork widths.

Gibb swage terminals are available in several different forms.

**EYE TERMINALS** are widely used to attach to most tangs and to rigging screw forks. The traditionally styled 546 eye terminals are machined from solid bar.

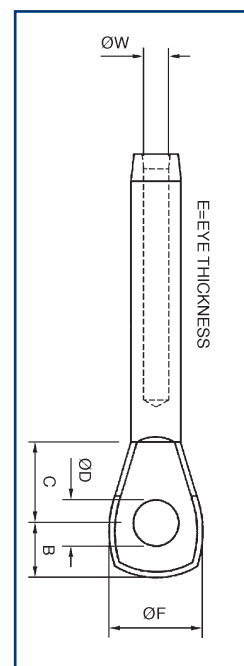
**FORK TERMINALS** are not as common, but are useful in split backstays, for example, or wherever a single link plate is fitted.

**STUD TERMINALS** are the most commonly used turnbuckle to wire connections.

**TOGGLE FORK TERMINALS** can be selected where the wire terminal is subjected to fluctuating side loads and fatigue, such as running backstays and lifelines.

We are pleased to quote for cable sizes outside the range detailed here.

EYE SWAGE TERMINAL						
PART#	WIRE Ø	B	C	Ø D	E	Ø F
	mm	mm	mm	mm	mm	mm
METRIC DIMENSIONS						
546-2.5-1/4	2.5	6.5	11.5	6.5	5.5	13.0
546-3-1/4	3	7.0	11.0	6.5	5.5	13.0
546-4-5/16	4	8.2	13.0	8.1	6.7	16.0
546-5-3/8	5	11.0	17.0	9.7	8.0	19.0
546-6-7/16	6	12.5	19.5	11.3	9.5	23.0
546-7-1/2	7	14.5	22.5	13.0	10.8	27.0
546-8-1/2	8	16.0	23.0	13.0	12.5	27.0
546-8-5/8	8	18.0	25.0	16.2	12.5	33.0
546-10-5/8	10	18.0	28.0	16.2	13.5	33.0
546-12-3/4	12	21.0	39.0	19.2	18.0	40.0
546-14-7/8	14	25.0	41.0	22.5	21.0	47.5
546-16-1	16	27.5	44.5	25.7	24.0	54.0
546-19-11/8	19	30.0	50.0	29.0	25.7	57.0
546-22-11/4	22	38.0	55.0	32.0	33.0	63.0
546-26-11/4	26	42.0	61.0	35.0	31.3	69.0
USA - IMPERIAL DIMENSIONS						
	ins	ins	ins	ins	ins	ins
N546-0308	3/32	0.256	0.453	0.256	0.217	0.512
N546-0408	1/8	0.256	0.453	0.256	0.217	0.512
N546-0510	5/32	0.323	0.512	0.319	0.264	0.630
N546-0612	3/16	0.394	0.669	0.382	0.315	0.748
N546-0716	7/32	0.492	0.768	0.445	0.374	0.906
N546-0816	1/4	0.531	0.945	0.512	0.374	1.024
N546-0916	9/32	0.571	0.886	0.512	0.425	1.063
N546-1016	5/16	0.630	0.906	0.512	0.492	1.063
N546-1020	5/16	0.709	0.984	0.638	0.492	1.299
N546-1220	3/8	0.709	1.102	0.638	0.531	1.299
N546-1424	7/16	0.827	1.535	0.756	0.709	1.575
N546-1624	1/2	0.827	1.535	0.756	0.709	1.575
N546-1828	9/16	0.984	1.614	0.886	0.827	1.870
N546-2032	5/8	1.083	1.752	1.012	0.945	2.126
N546-2436	3/4	1.181	1.969	1.142	1.012	2.244
N546-2840	7/8	1.496	2.165	1.300	1.126	2.480
N546-3244	1	1.654	2.402	1.378	1.232	2.717



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**American Rigging Supply, Inc.**  
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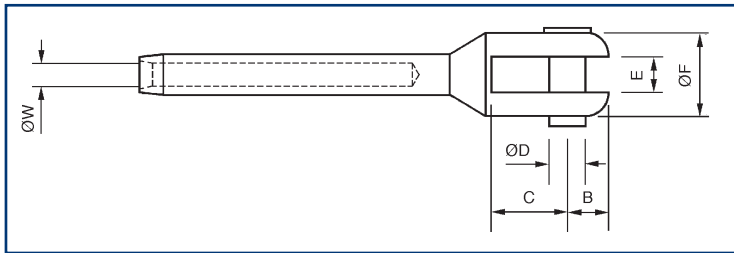


## FORK SWAGE TERMINAL

PART#	WIRE Ø mm	B mm	C mm	ØD mm	E mm	ØF mm
METRIC DIMENSIONS						
547-2.5-1/4	2.5	8.0	13.0	6.3	6.3	14.0
547-3-1/4	3	8.0	13.0	6.3	6.3	14.0
547-4-5/16	4	10.0	16.0	7.9	7.9	19.0
547-5-3/8	5	12.0	19.0	9.5	9.5	22.0
547-6-7/16	6	14.0	22.0	11.1	11.1	28.5
547-7-1/2	7	16.0	25.5	12.7	12.7	31.5
547-8-1/2	8	16.0	25.5	12.7	12.7	31.5
547-8-5/8	8	20.0	32.0	15.8	15.8	37.8
547-10-5/8	10	20.0	32.0	15.8	15.8	37.8
547-12-3/4	12	24.0	38.0	19.0	19.0	47.3
547-14-7/8	14	28.0	44.5	22.2	22.2	54.0
547-16-1	16	32.0	51.0	25.4	25.4	63.3
547-19-11/8	19	36.0	57.0	28.5	28.5	69.6
547-22-11/4	22	40.0	63.5	31.7	31.7	76.0
547-26-13/8	26	44.0	70.0	35.0	35.0	82.5

### USA - IMPERIAL DIMENSIONS

	ins	ins	ins	ins	ins	ins
N547-0308	3/32	0.315	0.512	0.248	0.248	0.551
N547-0408	1/8	0.315	0.512	0.248	0.248	0.551
N547-0510	5/32	0.394	0.630	0.311	0.311	0.748
N547-0612	3/16	0.472	0.748	0.374	0.374	0.866
N547-0714	7/32	0.551	0.866	0.417	0.437	1.122
N547-0814	1/4	0.630	1.004	0.430	0.500	1.240
N547-0916	9/32	0.630	1.004	0.500	0.500	1.240
N547-1016	5/16	0.630	1.004	0.500	0.500	1.240
N547-1020	5/16	0.787	1.260	0.622	0.622	1.488
N547-1220	5/8	0.787	1.260	0.622	0.622	1.488
N547-1424	7/16	0.945	1.496	0.748	0.748	1.862
N547-1624	1/2	0.945	1.496	0.748	0.748	1.862
N547-1828	9/16	1.102	1.752	0.874	0.874	2.126
N547-2032	5/8	1.260	2.008	1.000	1.000	2.492
N547-2436	3/4	1.417	2.244	1.122	1.122	2.740
N547-2840	7/8	1.575	2.500	1.248	1.248	2.992
N547-3244	1	1.732	2.756	1.378	1.378	3.248



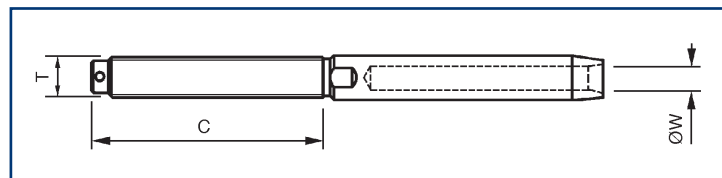
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## SWAGE STUD TERMINAL

PART#	WIRE Ø mm	THREAD UNF	C mm
METRIC DIMENSIONS			
555-030-1/4	3	1/4	41.0
555-040-5/16	4	5/16	51.0
555-050-5/16	5	5/16	51.0
555-050-3/8	5	3/8	65.0
555-060-3/8	6	3/8	65.0
555-060-7/16	6	7/16	72.0
555-070-7/16	7	7/16	72.0
555-070-1/2	7	1/2	80.0
555-080-1/2	8	1/2	80.0
555-080-5/8	8	5/8	95.0
555-100-5/8	10	5/8	95.0
555-120-3/4	12	3/4	110.0
555-140-7/8	14	7/8	138.0
555-160-1	16	1	155.0
555-190-1 1/8	19	1 1/8	176.0
555-220-1 1/4	22	1 1/4	206.0
555-260-1 3/8	26	1 3/8	219.0

### USA - IMPERIAL DIMENSIONS

	in	UNF	in
N555-0408	1/8	1/4	1.614
N555-0612	3/16	3/8	2.559
N555-0814	1/4	7/16	2.835
N555-0816	1/4	1/2	3.150
N555-0916	9/32	1/2	3.150
N555-1016	5/16	1/2	3.150
N555-1020	5/16	5/8	3.740
N555-1220	3/8	5/8	3.740
N555-1624	1/2	3/4	4.331
N555-1828	7/16	7/8	5.433
N555-2032	5/8	1	6.102
N555-2436	3/4	1 1/8	6.929
N555-2840	7/8	1 1/4	8.110
N555-3244	1	1 3/8	8.622



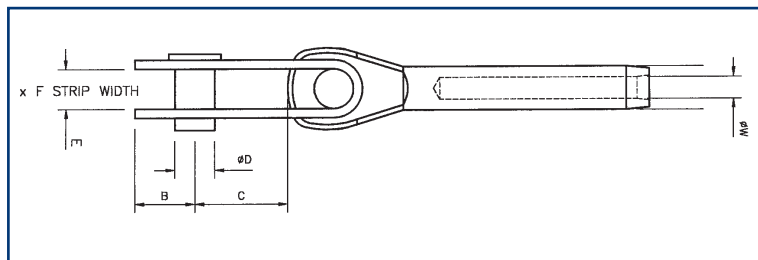
This list covers only part of our range. Larger sizes are available and we would be glad to quote for special lengths, thread specifications, etc. Order by cable dia. and thread dia. Our standard threads are RIGHT HAND. For LEFT HAND add 'L' to the part number, ie, 555 - 030 - 1/4L.

# SWAGE TERMINALS

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## TOGGLE FORK SWAGE TERMINAL

PART NO.	WIRE Ø	B	C	ØD	E	F
METRIC DIMENSIONS						
	mm	mm	mm	mm	mm	mm
551-1/4-3	3	8.0	16	6.3	7.0	16.0
551-5/16-4	4	10.0	18	7.9	9.0	20.0
551-3/8-5	5	12.0	20	9.5	11.0	20.0
551-7/16-6	6	16.0	26	11.1	14.0	25.0
551-1/2-7	7	20.0	38	12.7	18.0	30.0
551-1/2-8	8	20.0	35	12.7	18.0	30.0
551-5/8-8	8	20.0	44	15.8	19.0	40.0
551-5/8-10	10	20.0	44	15.8	19.0	40.0
551-3/4-12	12	28.0	52	19.0	23.0	50.0
551-7/8-14	14	28.0	60	22.2	25.0	50.8
551-1-16	16	32.0	63	25.4	28.0	63.5
551-11/8-19	19	36.0	66	28.0	31.5	63.5
551-11/4-22	22	40.0	79	31.8	34.5	76.2
551-13/8-26	26	43.5	100	35.0	38.0	76.2
USA - IMPERIAL DIMENSIONS						
	ins	ins	ins	ins	ins	ins
N551-0308	3/32	0.315	0.630	0.248	0.276	0.630
N551-0408	1/8	0.315	0.630	0.248	0.276	0.630
N551-0510	2/31	0.394	0.709	0.311	0.354	0.787
N551-0612	3/16	0.472	0.787	0.374	0.433	0.787
N551-0712	7/32	0.500	1.024	0.437	0.551	0.984
N551-0816	1/4	0.787	1.496	0.500	0.709	1.181
N551-0916	9/32	0.787	1.496	0.500	0.709	1.181
N551-1016	5/16	0.787	1.378	0.500	0.709	1.181
N551-1020	5/16	0.787	1.732	0.622	0.748	1.575
N551-1220	3/8	0.787	1.732	0.622	0.748	1.575
N551-1424	7/16	1.102	2.047	0.748	0.906	1.969
N551-1624	1/2	1.102	2.047	0.748	0.906	1.969
N551-1828	9/16	1.102	2.362	0.874	0.984	2.000
N551-2032	5/8	1.260	2.480	1.000	1.102	2.500
N551-2436	3/4	1.417	2.598	1.102	1.240	2.500
N551-2840	7/8	1.575	3.110	1.252	1.358	3.000
N551-3244	1	1.713	3.937	1.378	1.496	3.000



## SWAGE DIMENSIONS

Detailed below is a table of BEFORE and AFTER swage dimensions. This is an essential reference point to ensure that the correct dies have been used and that the swage has been completed successfully.

### REFERENCE TABLE FOR SWAGE DIMENSIONS

WIRE DIA.		DIAMETER BEFORE SWAGING		DIAMETER AFTER SWAGING	
(mm)	(in)	(mm)	(in)	(mm)	(in)
2.5	3/32	5.53/5.41	0.218/0.213	4.82/4.70	0.190/0.185
3.0	1/8	6.35/6.22	0.250/0.245	5.56/5.44	0.219/0.214
4.0	5/32	7.54/7.42	0.297/0.292	6.35/6.23	0.250/0.245
5.0	3/16	9.12/9.00	0.359/0.354	7.95/7.83	0.313/0.308
5.5	7/32	10.84/10.72	0.427/0.422	9.50/9.35	0.375/0.368
6.0	1/4	12.54/12.42	0.494/0.489	11.12/10.95	0.438/0.431
7.0	9/32	14.30/14.18	0.563/0.558	12.70/12.50	0.500/0.492
8.0	5/16	16.13/16.01	0.635/0.630	14.30/14.07	0.563/0.554
9.0 - 10	3/8	17.85/17.73	0.703/0.698	15.90/15.70	0.625/0.618
11	7/16	19.84/19.71	0.781/0.776	17.47/17.27	0.688/0.680
12	1/2	21.44/21.32	0.844/0.839	19.05/18.82	0.750/0.741
14	9/16	25.00/24.88	0.984/0.979	22.23/22.00	0.875/0.866
16	5/8	28.17/28.05	1.109/1.104	25.40/25.15	1.000/0.990
19	3/4	34.52/34.40	1.359/1.354	31.75/31.44	1.250/1.238
22	7/8	40.46/40.21	1.593/1.583	36.50/36.20	1.437/1.425
26	1	46.02/45.77	1.812/1.802	41.28/40.97	1.625/1.613

NOTE: 3.5mm Wire uses 4mm Dies