

Form D-2 - Rope Quality Control Checklist

(For double braid ropes, separate forms should be used for the core and the cover, or this form should be modified with separate columns for core and for cover.)

Manufacturer					
QA Supervisor's or Deputy's name					
Dates					

Order Information

Purchaser				
Order number		Order date		
Order description				

Manufacturing Information

Rope design		Rope size			
Material designation					
Manufacturing Specification designation					
Rope production length		Production dates			

Material Quality

Material of proper designation was used?	
Basic yarn containers used in making this rope bore acceptance labels dated	

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Yarn and Strand Making

	<i>Nominal value*</i>	<i>Unit</i>	<i>Allowable deviation**</i>	<i>Production value</i>	<i>Unit</i>
Size of basic yarn, (denier or tex)			+/- 5%		
Twist of basic yarn			+/- 5%		
Ply count of intermediate yarn (number of basic yarns)			+/- 5%		
Ply count of rope yarn (number of intermediate yarns)			+/- 5%		
Twist of rope yarn			+/- 5%		
Number of rope yarns per strand			+/- 2%		
Gearing of stranding machine			0		
Speed of stranding machine			+/- 10%		
Strand closing die bore diameter			+/- 3%		
Yarn lay length in strand (measured on stranding machine)			+/- 5%		

Arrangement of rope yarns per layer in stranding machine register plate								
<i>Layer</i>	<i>Centre</i>	<i>2</i>	<i>3</i>	<i>4</i>	<i>5</i>	<i>6</i>	<i>7</i>	<i>8</i>
Nominal number*								
Production number								

* Given in Manufacturing Specification

** The manufacturer may set more stringent allowable deviation limits.

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Rope Making

	<i>Nominal value*</i>	<i>Unit</i>	<i>Allowable deviation**</i>	<i>Production value</i>	<i>Unit</i>
Total number of strands			0		
Number of strands per carrier (single- and double braid only)			0		
Number of strands in parallel path (single and double braid only)			0		
Bore diameter of rope closing die			+/- 3%		
Gearing			0		
Strand tension weights or springs			+/- 5%		
Maximum speed of rope production			0		
Lay length of strands in rope			+/- 5%		

Strand splices (double braid only)

Length of rope produced	
Number of strand splices	
Spacing of strand splices	

Heat setting (heat-set ropes only)

	<i>Nominal value*</i>	<i>Unit</i>	<i>Allowable deviation**</i>	<i>Production value</i>	<i>Unit</i>
Heat-set temperature					
Heat-set exposure time					
Heat setting media i.e. hot air, steam, etc.					

* Given in Manufacturing Specification

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