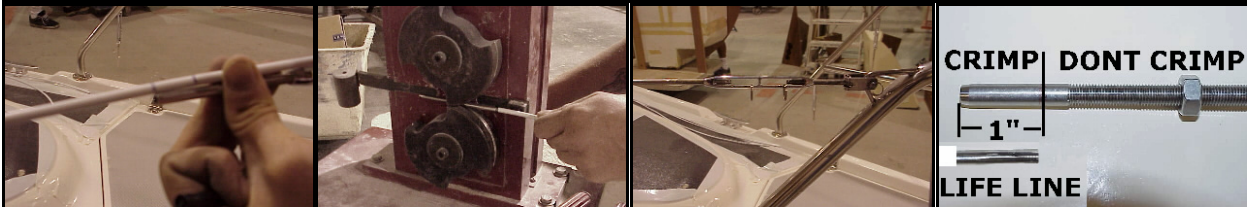
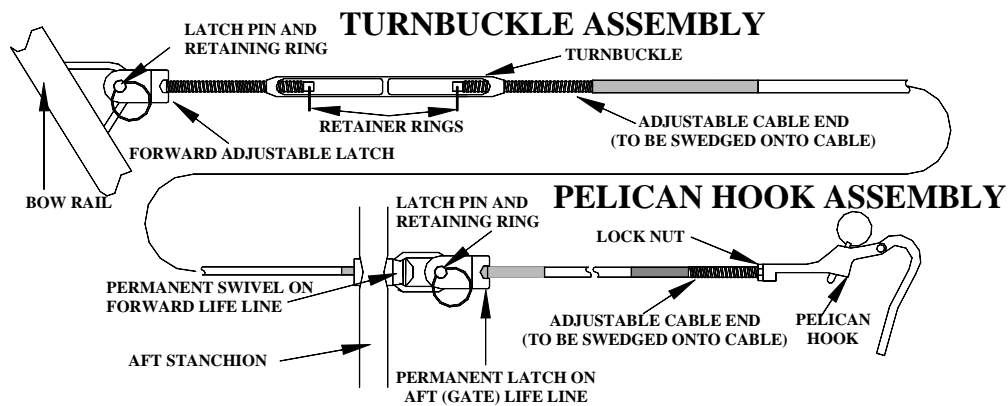


# SOP 356 LIFE LINE INSTALLATION



- Life lines consist of three sections. The forward section is permanent while the two aft sections (arch gate life lines and stern gate life line) are detachable on one end. There will be an upper and lower life line on the port side and the starboard side of the deck ( If life lines are different lengths the longer lines should go on top). All sections will be cut to length and assembled at installation. The forward section will be installed first then the aft section will be completed after the arch has been installed. The stern gate lifeline will be done after the stern rails are installed.
- Attach the turnbuckle assemblies to the bow rail by taking out the latch pin then sliding the latch into the loops on the bow rail and replacing latch pin and retainer ring (Don't put retainer ring all the way in as it will be taken back out). Do this for all four turnbuckles.
- Run the forward life line forward thru the aft stanchion then go thru the forward stanchion then on to the turnbuckle assembly. Pull line tight so the permanent swivel at aft end of line is tight against aft stanchion. Do this for all four life lines
- Adjust turnbuckle so only one thread (on both ends) is showing inside the turnbuckle. Hold life line and turnbuckle assembly together then mark the life line where the end of the turnbuckle meets it. Then mark another line one inch forward (this is where the life line will be cut). Using cable cutters cut life line to this length. Using a razor knife trim sheathing back to the mark one inch away from end. Do this for all four life lines.
- Remove adjustable cable from turnbuckle and remove life line and take them to the crimping machine. Place life line in cable end and place this assembly in crimping machine. While rolling this assembly through crimping machine push on life line to insure that there is no gap between the cable end and the sheathing on the life line. When this assembly has gone thru the crimping machine there will be a crimp line on the cable end, turn the assembly 90 degrees and roll the assembly thru the machine again, this will remove crimp line. Do this for all four life lines
- Undo turnbuckle and replace cable end back into turnbuckle so one thread is showing on the inside of turnbuckle. Replace turnbuckle onto bow rail and turn turnbuckle to tighten life line, place retainer rings in turnbuckle at this time. Do this for all four life lines.
- Installation of aft (gate) life lines are similar to forward life line. Attach the permanent latch on the aft life line to the permanent swivel on the forward life line by removing latch pin, hooking them together then replacing latch pin and retainer ring. Do this for all four life lines.
- Attach the life line cable to the adjustable cable end on the pelican hook assembly the same way the forward life lines were done.
- Installation of the stern gate life line is the same as the arch gate life lines except it is shorter and only one is needed.

**NOTE: BE SURE WHEN CRIMPING THAT YOU DO NOT CRIMP MORE THEN ONE INCH OF ADJUSTABLE CABLE END.**

Revision Dates:

Expected Time: 45 min.