



Muncy™ Specials

Communications Plan

Course Objectives

- Learn common terminology.
- Learn how to request a quote.
- Learn how to measure critical fitting dimensions.
- Learn about different common surface finishes.

Common Terminology



- Common terminology reduces the risk of miscommunication on your special wire rope fitting needs.
- Ensures efficient, clear communications.
- NO MISTAKES!

Common Terminology

Button or Ferrule

- Specify if you are giving before swage or after swage dimensions.
- Wire rope size, O.D. and Length.
- Specify material and surface finish.
- Button for 1/8" wire rope with an after swage dimension of .75" O.D. and 2" long. Hot dip Galvanized.

Common Terminology

Threaded Studs

- Specify if you are giving before swage or after swage dimensions.
- Wire rope size, Shank O.D., Thread Length, Thread O.D., whether coarse or fine threads and if you need wrench flats- and where.
- Specify material and surface finish.
- Specify nut and washer if required.
- Threaded stud for 7/8" wire rope with an after swage shank O.D. of 1.75" and 5" of 1-3/4" National Course threads. Mechanical Zinc plated. Furnish one nut and one washer.

Muncy™ Specials Cheat Sheet

MUNCY™ MACHINE & TOOL CO., INC.

P.O. Box 205, Muncy, PA 17736-0205
Phone (570) 649-5188 • (800) 221-5143
Over 60 Years Serving The Wire Rope Industry

Machining Dimensions for Non-Standard Items

QTY _____
MATERIAL _____ BEFORE SWAGE ☐ AFTER SWAGE ☐ WRENCH FLATS ☐

Ball Shanks

Ball O.D.
Ball Diameter
1/2 or Full Ball



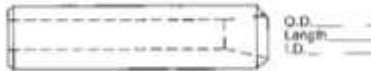
Shank
O.D.
Length
I.D.

BUTTONS



STB Style (A)

Threaded Sleeves (threaded after swaging)



Threaded Studs



TTS Style (B)



Fill in the blanks and fax to (570) 649-5856 for a quick quotation.



THE UPSON-WALTON COMPANY

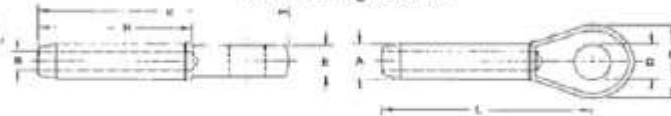
P.O. Box 205, Muncy, PA 17736-0205
Phone (570) 649-5188 • (800) 221-5143
Over 130 Years Serving the Wire Rope Industry

Machining Dimensions for Non-Standard Items Open Swage Socket

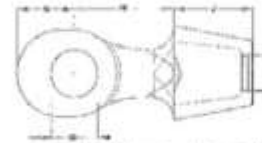
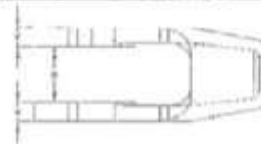


Rope Dia.	A	B	C	Pin Length	F	F	H	L	M	O	Y

Closed Swage Socket



Rope Dia.	A	B	C	D	E	H	K	L



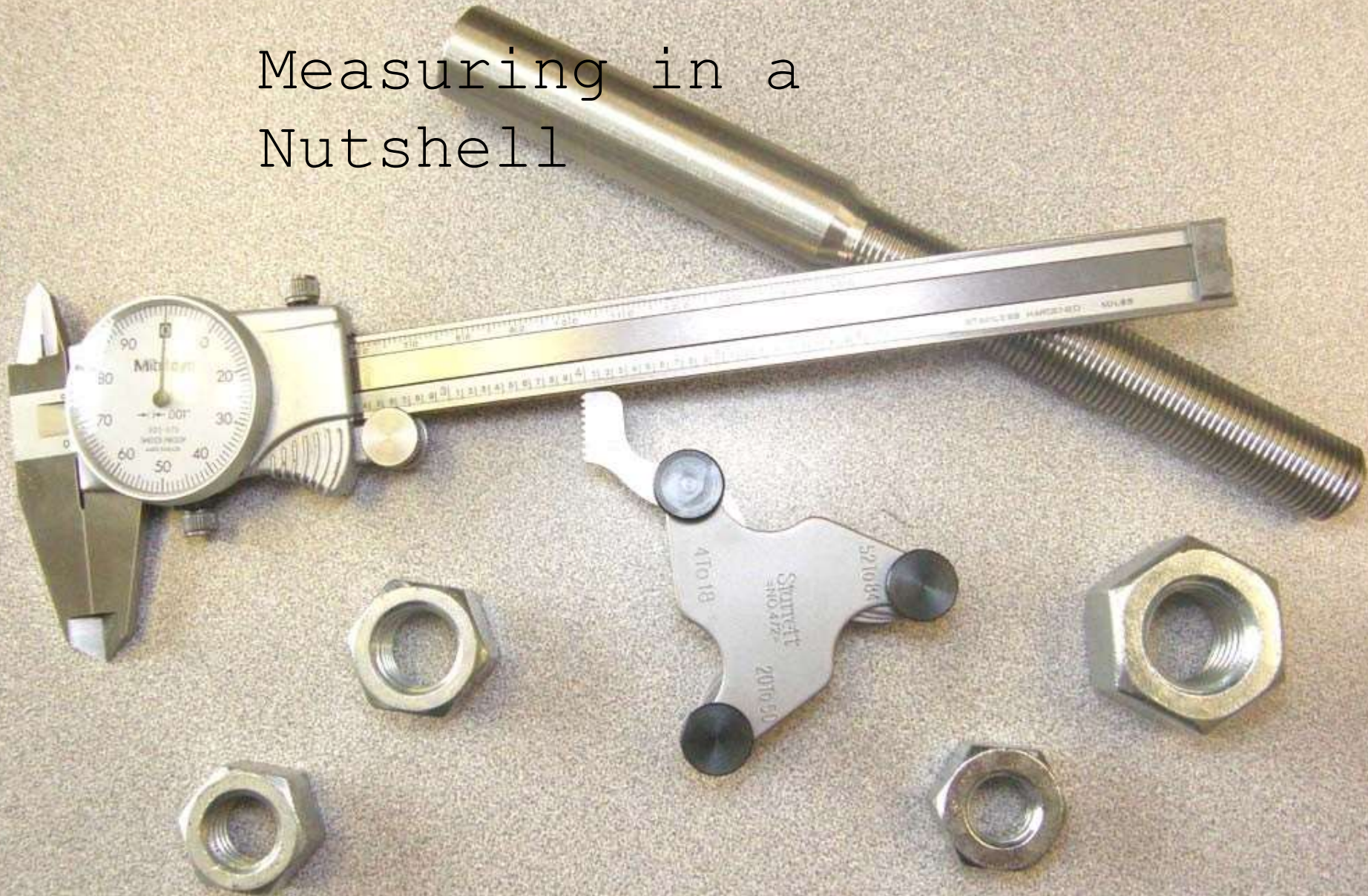
Muncy™ Special Sockets

Rope Dia.	
B	
J	
M	
N	
O	
V	

Fill in the blanks and fax to (570) 649-5856 for a quick quotation.



Measuring in a Nutshell



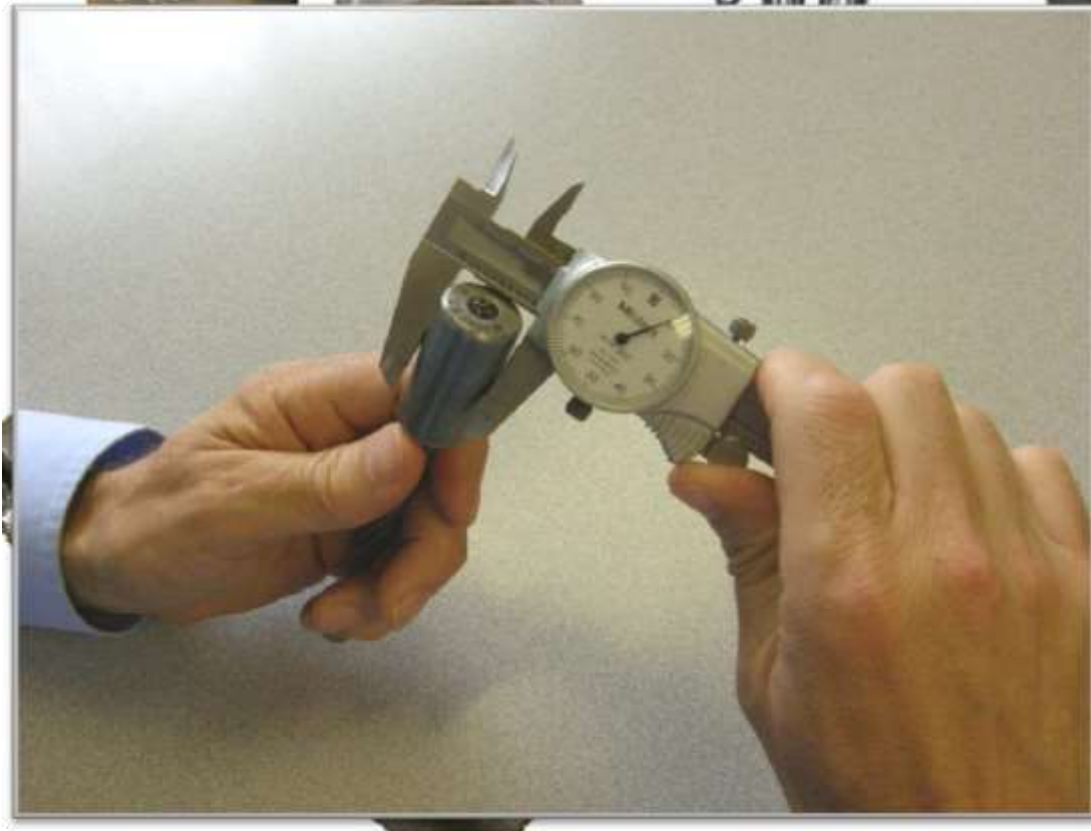
Calipers

Overview

- Zeroing
- Calibration
- Measuring Outside Diameters
- Measuring Inside Diameters
- Measuring Hole depths

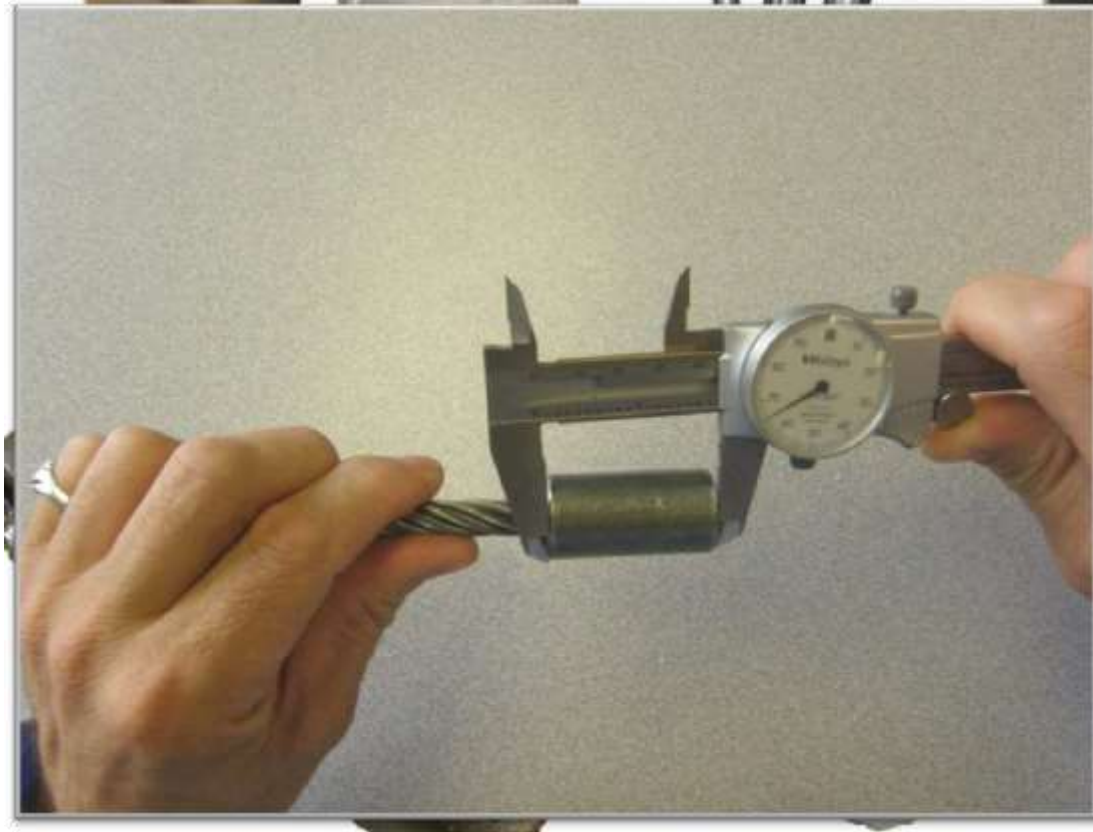


Measuring O.D.



Measure the O.D. taking an average to account for flashing from the swaging process.

Measuring Length



Measure the O.D. taking an average to account for flashing from the swaging process.

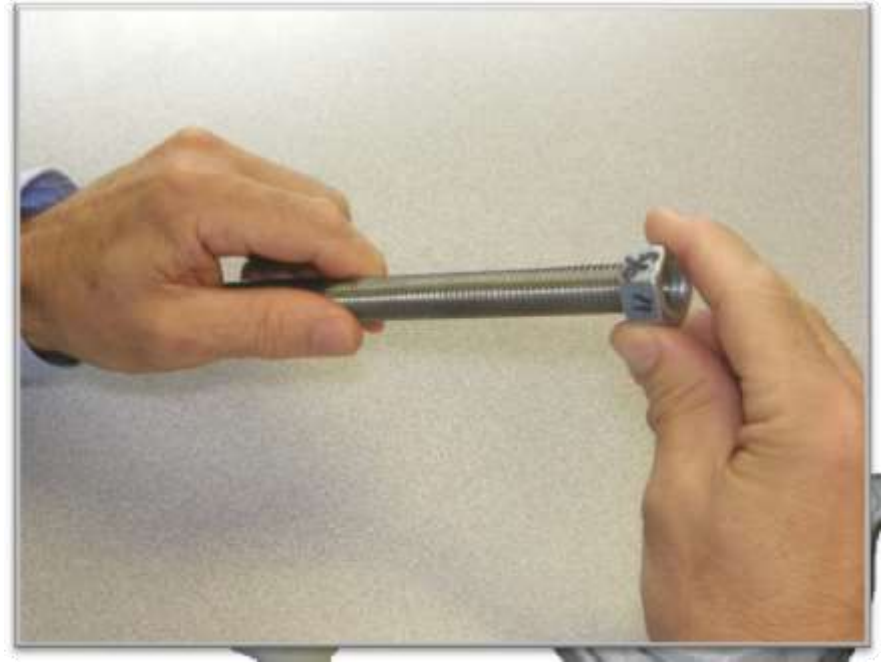
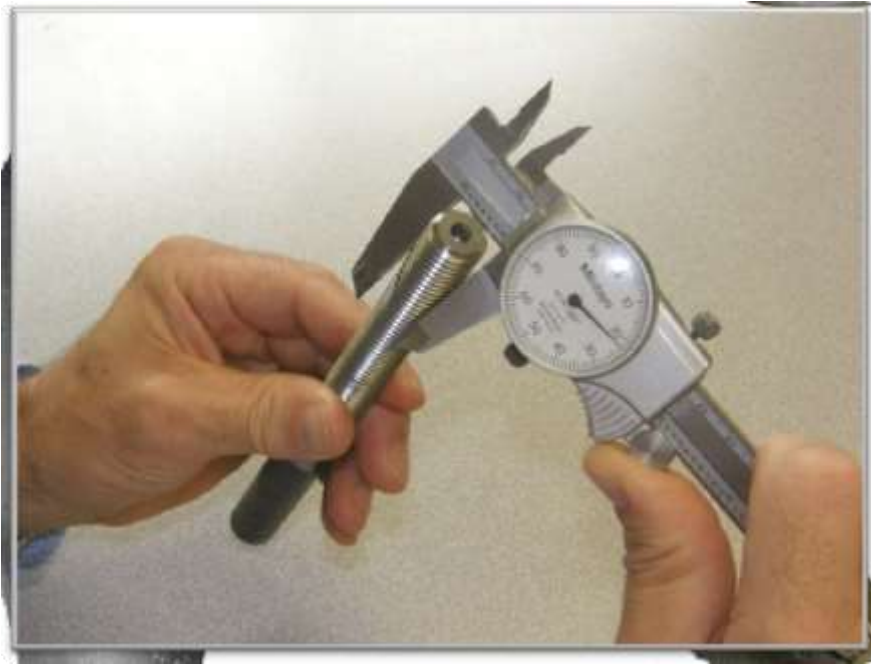
Measuring Threads



Overview

- Determining thread O.D.
- Determining thread Length
- Determining thread pitch (National coarse or National fine)

Measuring Threads- O.D.



Measure thread outside diameter with a caliper or with a nut that you know the size.

Measuring Threads- Thread Length



Thread length is measured to the end of a nut that is threaded all the way up the threaded portion of the threaded stud.

Measuring Threads- Thread Pitch



Thread pitch can be determined using a pitch gage or with nuts that you know the size and pitch. You can also measure one inch and count the number of threads in that one inch section.



Wrench Flats



Wrench Flats at the Nose



- Located at the nose of the fitting.

- Cheapest way to add a wrench flat.



- Wrench flat does not disappear when swaged.

- Avoids accidental thread damage on installation.

- Does not weaken the fitting.

Wrench Flats between Threads and Shank



- May degrade ultimate strength of the stud.
- Accidental damage to threads on installation.
- Wrench flats may distort or disappear on swaging.

Wrench Flats

At the End of the Threads

- Most costly way to add threads.
- Accidental damage to threads on installation.
- Will not distort or disappear during swaging.
- Threads at the wrench flat area have reduced tensile strength.



"Odd Ball"

Applications



- Our niche *is* the "Odd Ball" wire rope fitting.
- We make to your specifications.
- We stock over 250 tons of steel to service your needs.
- Our goal is to have your non-standard threaded studs and buttons out our door in 2-4 working days.
- Specialty items not from barstock may take longer.

Surface Finishes



Surface Finishes

Electro Plated- Clear



- Shiny metallic finish.
- Rated to 12 hours in a salt fog cabinet.
- Roughly 1-2 years of corrosion resistance.
- Does not alter any dimensions.
- Aesthetically pleasing.

Surface Finishes

Electro Plated- Yellow Chromate



- Shiny yellow metallic finish.
- Rated to 96 hours in a salt fog cabinet.
- Does not alter any dimensions.
- Aesthetically pleasing.

Surface Finishes

Cadmium Plating



- Dull smooth metallic finish.
- Rated to 244 hours in a salt fog cabinet.
- Does not alter any dimensions.

Surface Finishes



- Hot Dip Galvanizing
- Dull smooth or rough metallic finish.
- Corrosion resistance for 10's of years. 50-100 years is not uncommon.
- Depends on where the galvanize part is located... City, rural, submerged...
- Slightly alters dimensions.

Thank You!

Questions?