



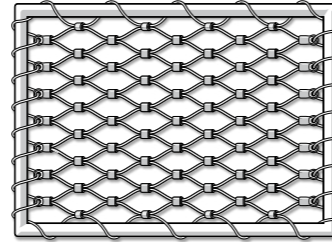
Autorisation DIBt Z-14.7-557

**Safeguarding quality in on-site swaging pursuant to national technical approvals (DIBt):**

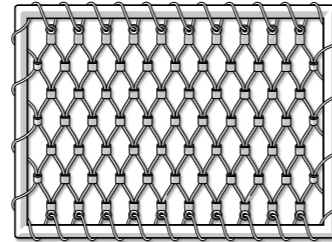
Webnet sleeves and eye ends must be swaged exclusively with our battery-operated swaging tools types **EK 50 ML**, **EK 1550 GLM**, **EK 354 ML** and **EK 6022 CL**.

During the swaging process, the jaws must make full-surface contact.

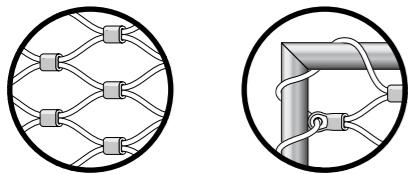
Perimeter type H24



Perimeter type V24



**Rope diameter**  
according to DIBt approval



Webnet rope ∅ mm	Perimeter rope ∅ mm
1,5	2
2	2,5
3	4

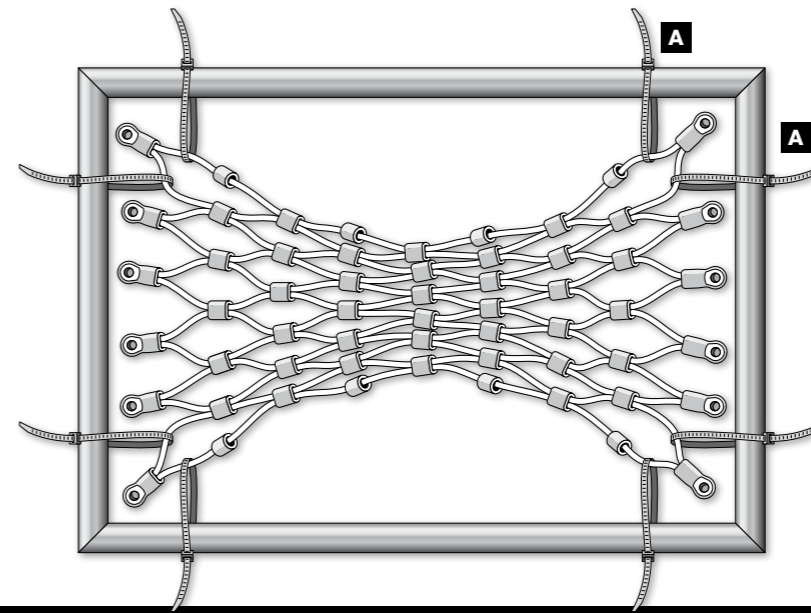


**On-site swaging** and the choice of the correct rope diameter with the matching **Webnet** sleeves and eye ends are the responsibility of the user. Full functionality is guaranteed only with **Jakob**<sup>®</sup> wire ropes and original **Webnet** swaging tools.



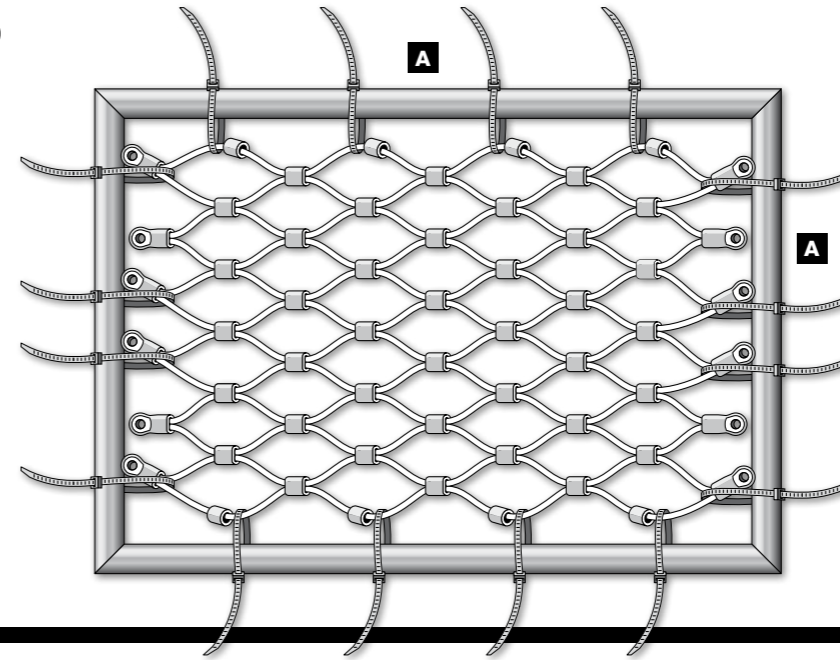
Detailed **assembly videos** at [jakob.com](http://jakob.com)

1



Center and attach **Webnet** at the **four corners** with cable ties **A**.

2



Center and **tension Webnet** with cable ties **A**.

Wire rope cutter

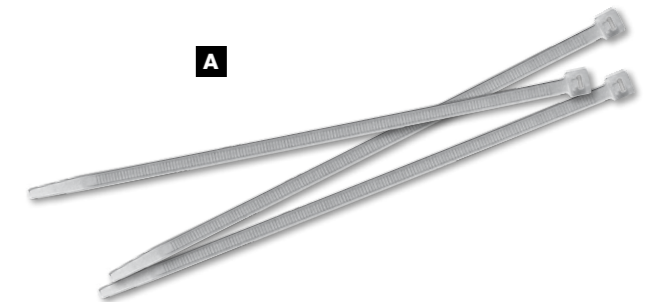
∅ max. 4 mm



No. **30740-0500**

Cable ties

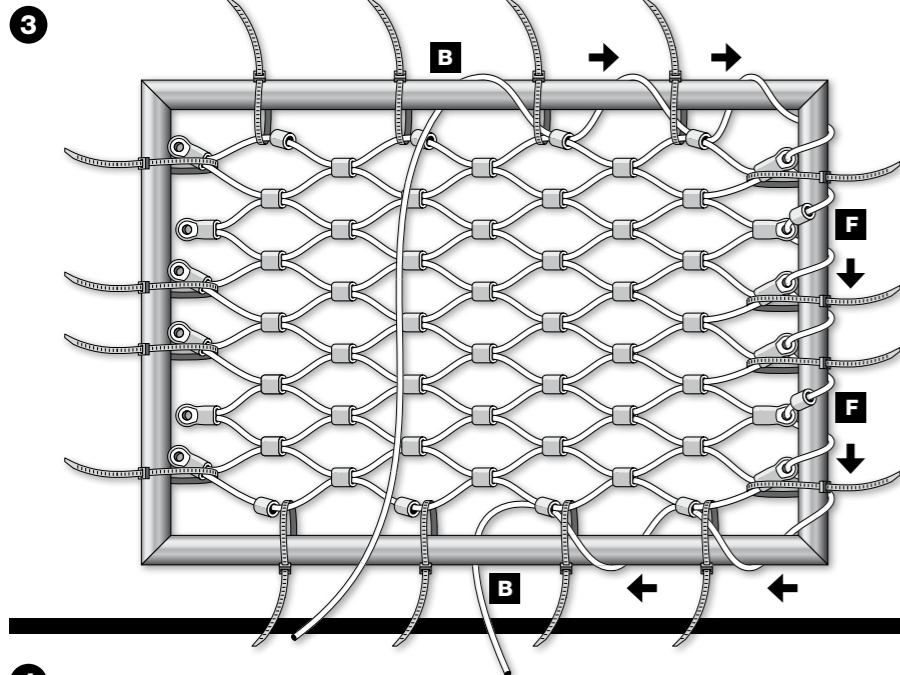
**A**



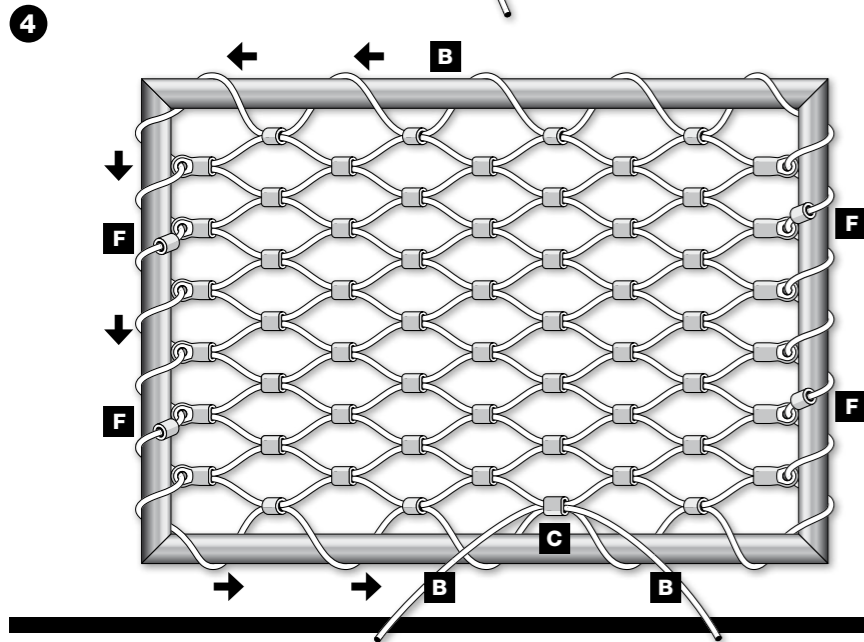
No.	Length ∅ mm
30916-0001	120
30916-0002	160
30916-0003	270
30916-0004	330



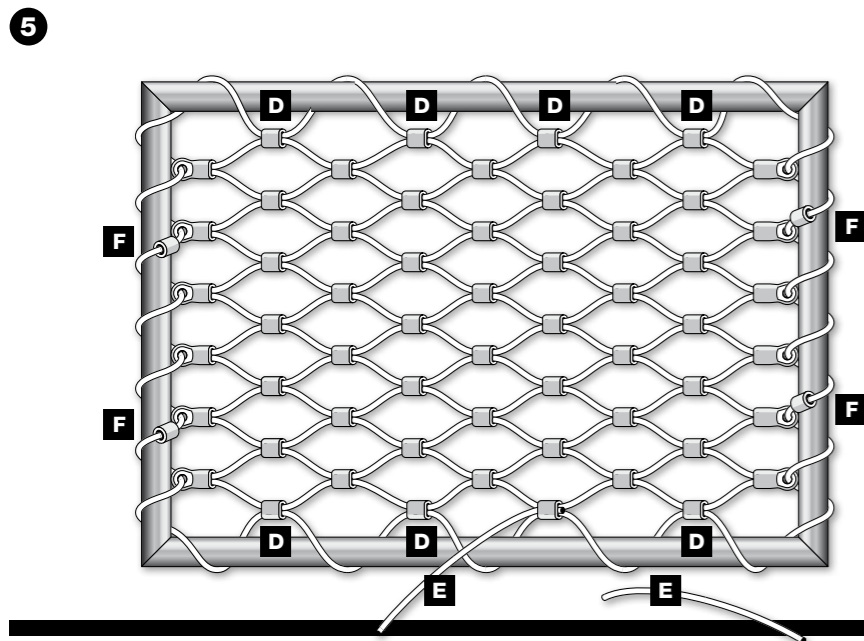
**Webnet assembly with perimeter type H24 or V24**



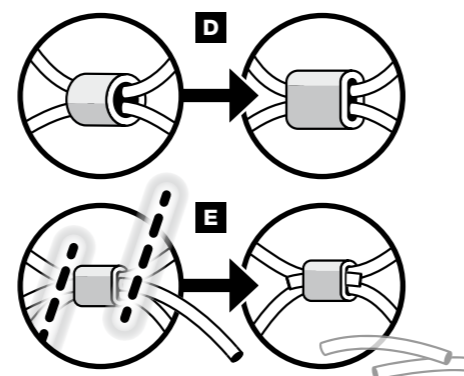
On one half of the frame, thread **lacing rope B** from the **middle of the top cross member to the middle of the bottom cross member**, going through each Webnet sleeve and eye ends as well as around the frame opposite each sleeve. Thread in same direction throughout. Depending on the size of the net, **stop sleeves F** must be fitted (see page 6).



Thread lacing rope **B** on the other side of the frame as described in step 3. The ends of both lacing ropes must be threaded through the **last sleeve C** and then **pulled taut**. Depending on the size of the net, **stop sleeves F** must be fitted (see page 6). **Swage** the sleeve **C** with the **Webnet tool** and remove all cable ties.



**Swage** the sleeves **D** with the **Webnet tool**, and cut off loose ends **E** of the lacing rope.



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**Battery-pow. swaging tool EK 50 ML**

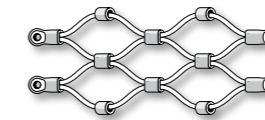
Corresponding to DIBt approval Z-14.7-557

Ø 1,5 / 2 mm

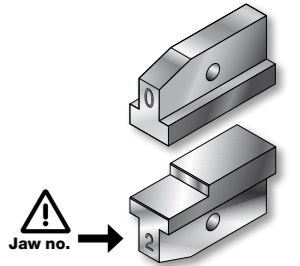


No. **30570-2008**

**Webnet rope**



**Perimeter rope**



Webnet rope	Perimeter rope	Jaws
Ø mm	Ø mm	No.
1,5	1,5 / 2	1,5 + 0
2	2 / 2,5 / 3	2 + 0

**Battery-pow. swaging tool EK 1550 GLM**

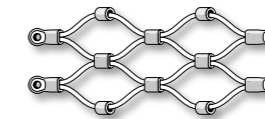
Corresponding to DIBt approval Z-14.7-557

Ø 1,5 / 2 / 3 mm

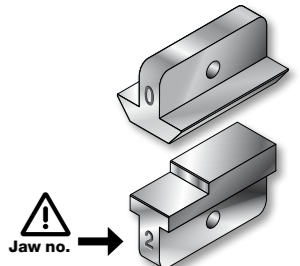


No. **30570-2005**

**Webnet rope**



**Perimeter rope**



Webnet rope	Perimeter rope	Jaws
Ø mm	Ø mm	No.
1,5	1,5 / 2	1,5 + 0
2	2 / 2,5 / 3	2 + 0
3	3	3 + 0
3	4	3 + 0

**Webnet swaging tool type 1**

Ø 1 / 1,5 mm



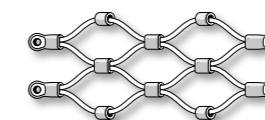
No. **30570-1500** 250 mm

Ø 1 / 1,5 / 2 mm

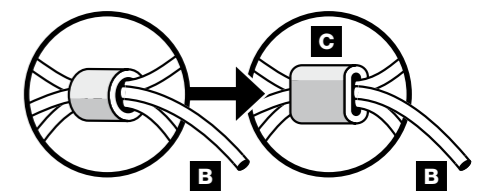


No. **30570-2000** 300 mm

**Webnet rope**



**Perimeter rope**

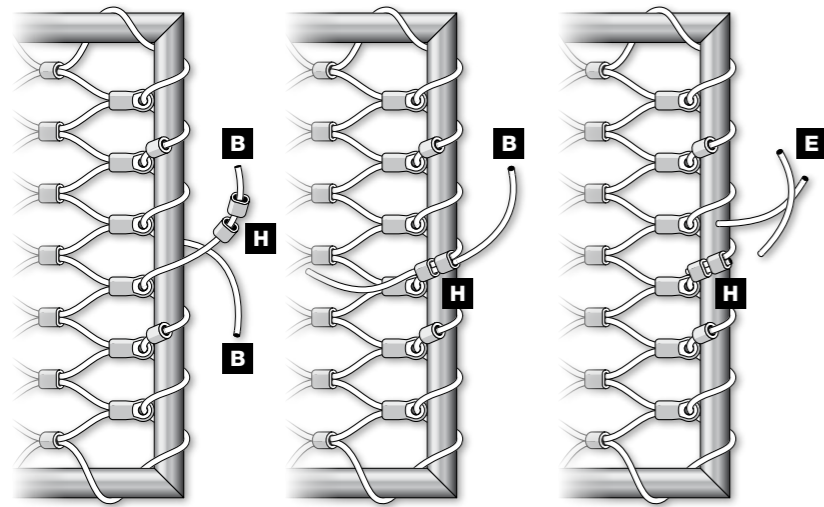


Webnet rope	Perimeter rope	Ø mm
Ø mm	No.	Ø mm
1	10820-0100-42	1
1 / 1,5	10820-0150	1,5
1,5 / 2	10820-0200	2
2	10820-0250	2,5



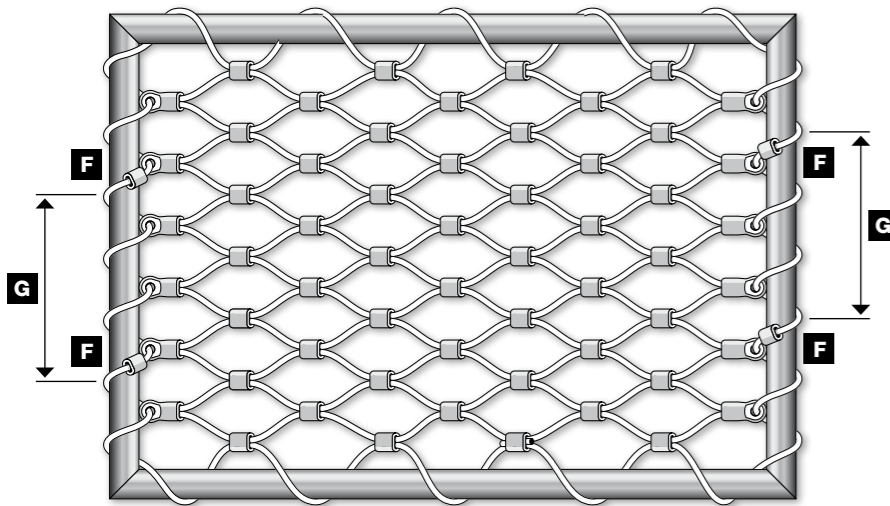
**Webnet assembly with perimeter type H24 or V24**

6



If the lacing rope **B** is connected on the **eye ends side**, the rope ends must be connected with two **crimping sleeves H**. The principle of binding is the same as described in **Figures 3 to 6**. Note the **final dimension** of the crimping in the table on page 7.

7



**Swage** the stop sleeves **F** with the **Webnet swaging tool**.

⚠ Depending on the **load situation** a stop sleeve is recommended every **10 to 15 meshes (G)**.

**Webnet swaging tool type 1**

Ø 1 / 1,5 / 2 / 2,5 mm



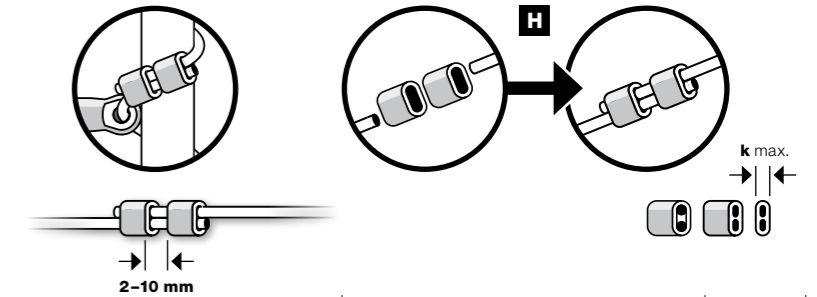
No. **30570-1500** 250 mm

Ø 1 / 1,5 / 2 / 2,5 mm



No. **30570-2000** 300 mm

**Crimping sleeve**



No.	For perimeter rope	
	Ø mm	k max. mm
<b>30583-0100-01</b>	<b>1</b>	2,5
<b>30583-0150-01</b>	<b>1,5</b>	2,6
<b>30583-0200-01</b>	<b>2</b>	3,0
<b>30583-0250-01</b>	<b>2,5</b>	3,9

**Webnet swaging tool type 1**

Ø 1 / 1,5 / 2 / 2,5 / 3 / 4 mm



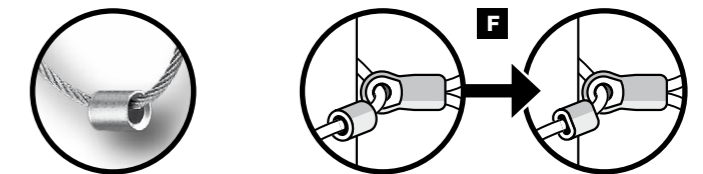
No. **30570-1500** 250 mm

Ø 1 / 1,5 / 2 / 2,5 / 3 / 4 mm



No. **30570-2000** 300 mm

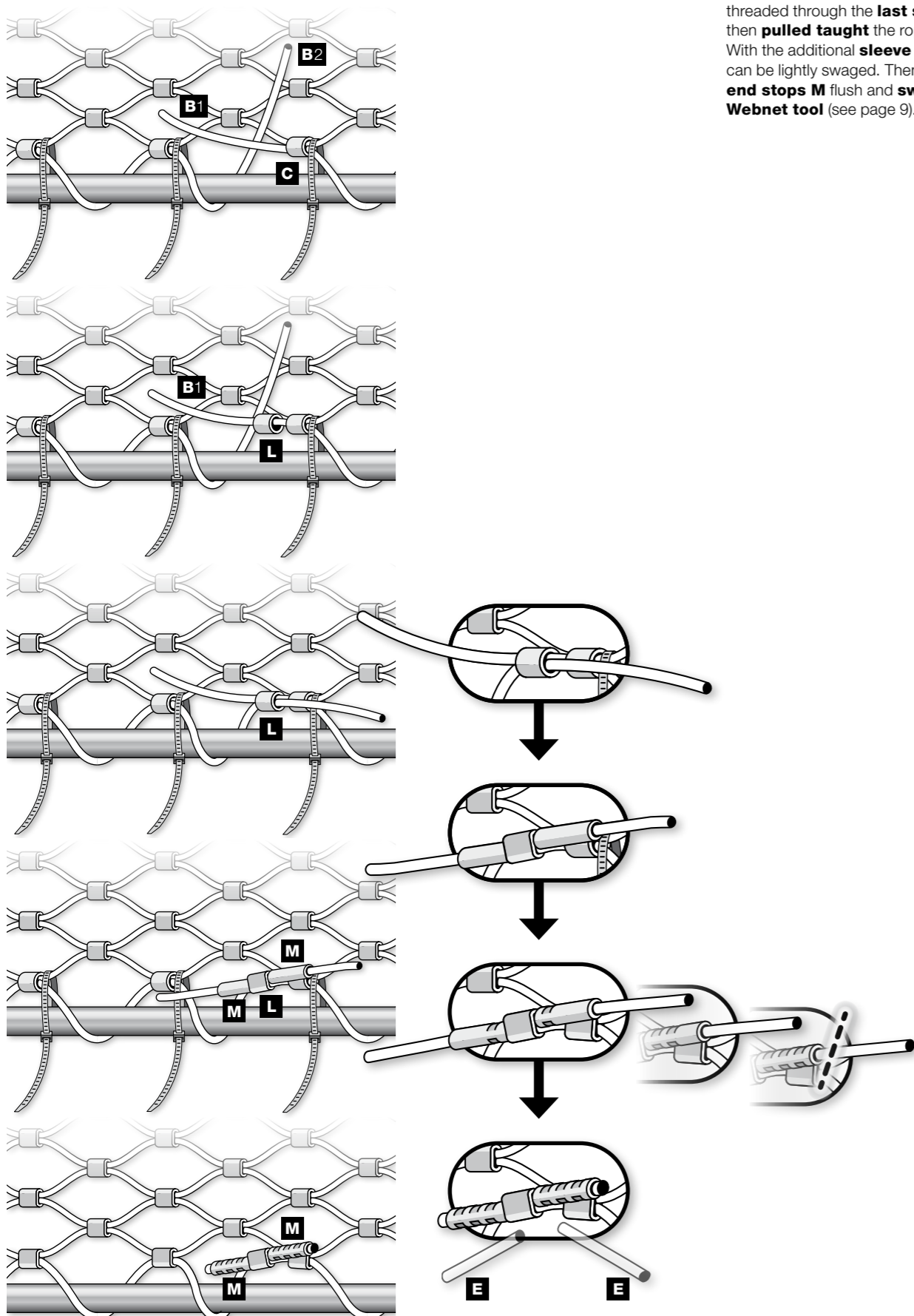
**Stop sleeve**



No.	For perimeter rope	
	Ø mm	k max. mm
<b>30584-0100</b>	<b>1 / 1,5 / 2</b>	2,5
<b>30584-0150-10</b>	<b>2,5 / 3</b>	3,0
<b>30584-0200-10</b>	<b>4</b>	3,9



8



**Larger lacing rope diameter**  
for  $\varnothing$  2 and 3 mm Webnet ropes:  
Thread lacing rope **B** as described in step 3 to 4. The end of lacing rope **B1** must be threaded through the **last sleeve C** and then **pulled taught** the rope ends **B1/B2**. With the additional **sleeve L**, the rope ends can be lightly swaged. Then push on the two **end stops M** flush and **swage** them with the **Webnet tool** (see page 9). Cut rope ends **E**.

**Abbildungen**  
Einbindeseil **B**  
Hülse **L**  
Endhülsen **M**

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**Perimeter rope**

$\varnothing$  2,5 / 3 / 4 mm



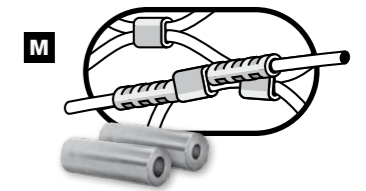
**Sleeve**

$\varnothing$  2,5 / 3 / 4 mm



**End stop**

$\varnothing$  2,5 / 3 / 4 mm



Webnet rope	Perimeter rope	Perimeter rope	Sleeve	Perimeter rope	End stop
$\varnothing$ mm	No.	$\varnothing$ mm	No.	$\varnothing$ mm	No.
2	10820-0250	2,5	30584-0200-01	2,5	30584-0250-02
2	10830-0300	3	30584-0200-01	3	30584-0300-02
3	10830-0400	4	30584-0300-01	4	30584-0400-02

**Webnet swaging tool type 2**

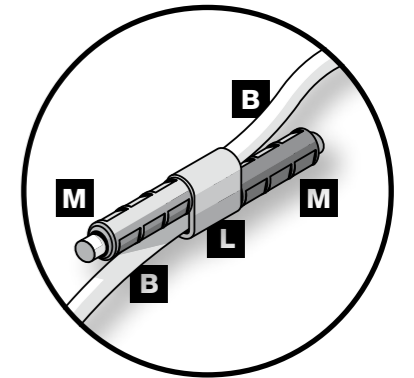
$\varnothing$  2,5 / 3 / 4 mm



No. 30570-2001

Replacement jaws

No. 30570-2001-01



Lacing rope	Insert marking
$\varnothing$ mm	No.
2,5 / 3 / 4	H3 - H3

**Battery swaging tool EKM 6022 CL**

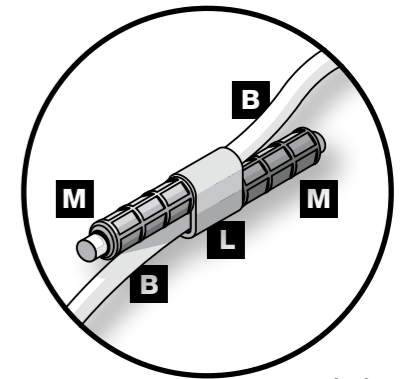
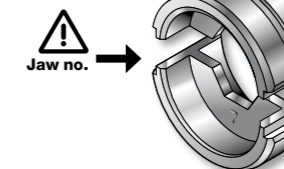
$\varnothing$  2,5 / 3 / 4 mm



No. 30570-2003

Jaws

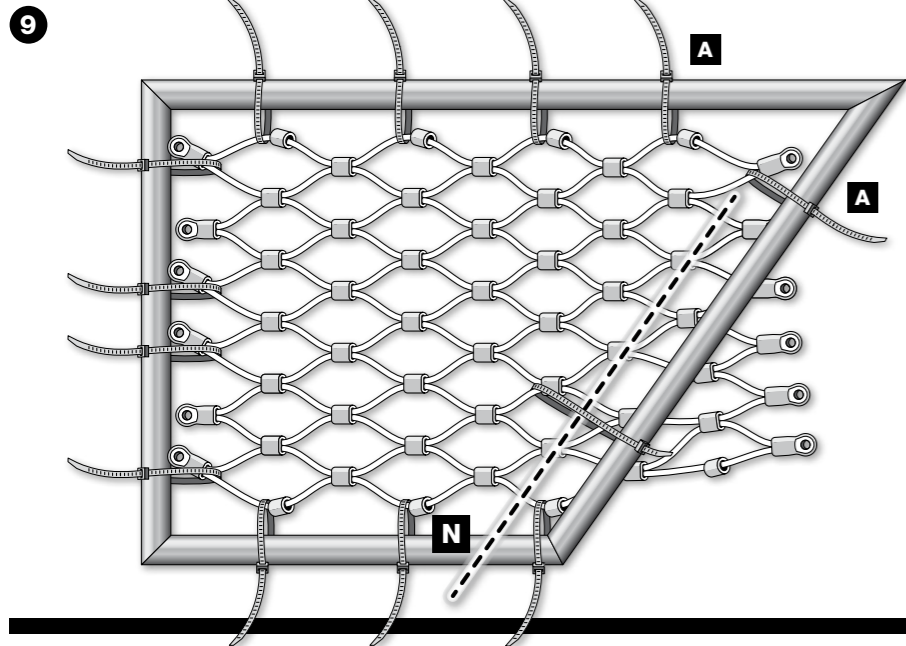
No. 30575-0700-10



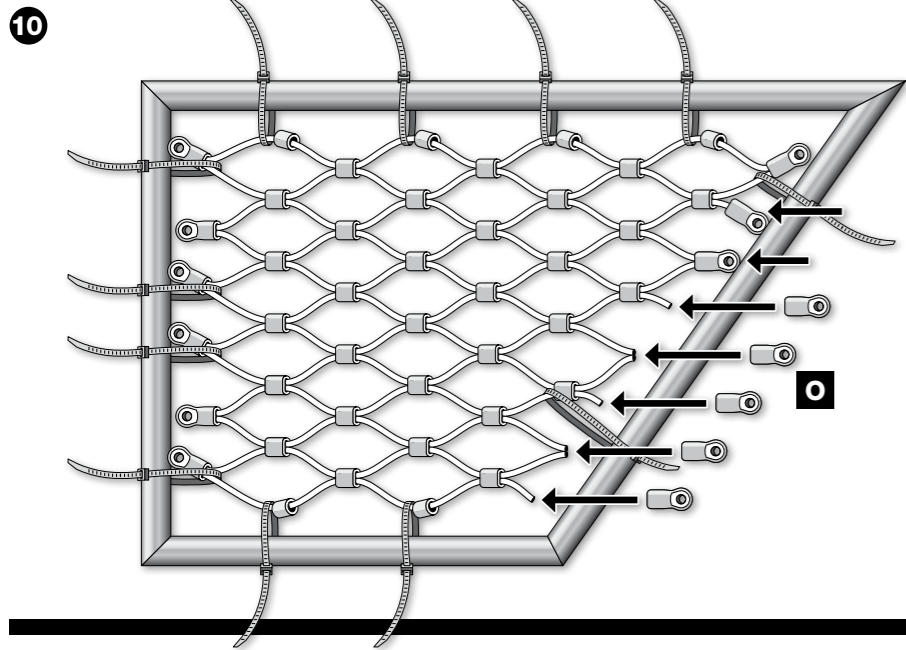
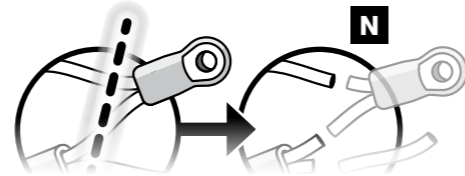
Lacing rope	Jaws
$\varnothing$ mm	No.
2,5 / 3 / 4	7



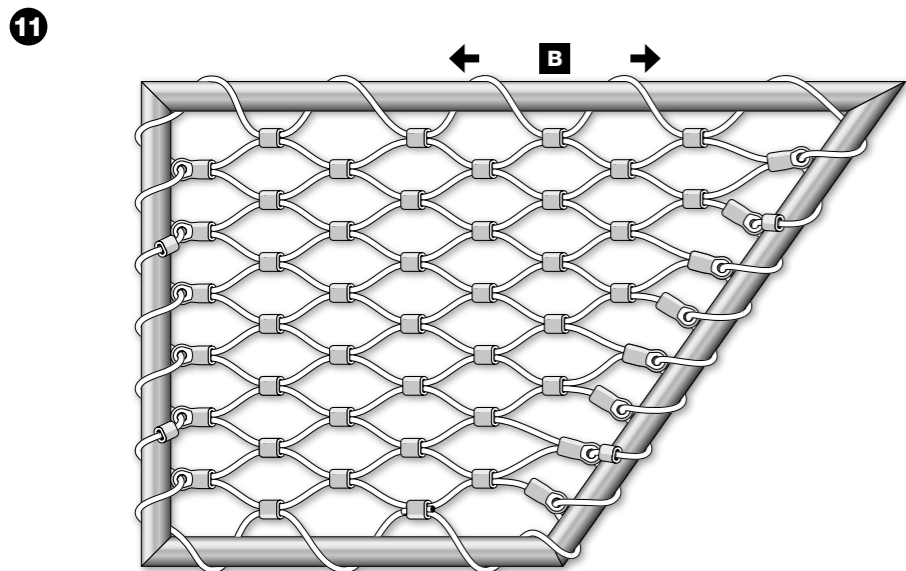
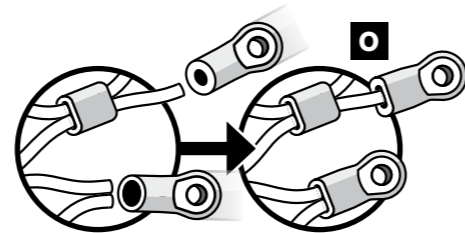
**Webnet assembled in inclined frames with perimeter type H24**



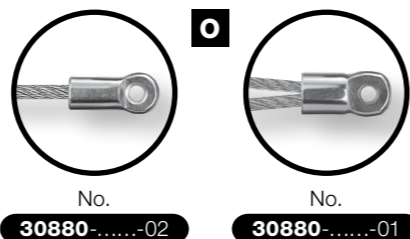
**Center and tension Webnet** with cable ties **A**. **Mark** all cutoff points **N** along and parallel to the skew side, and **cut**. If necessary, **remove** the Webnet sleeves at the **intersections**.



Use the **Webnet tool** to **swage** the **Webnet eye ends O** onto the **loose ends** of the wire rope. Make sure you choose the right Webnet eye end type for **one or two rope ends!**



The principle of lacing **B** is the same as described in **Figures 3 to 8**.



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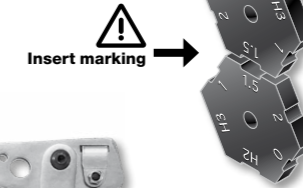
**Webnet swaging tool type 2**

Ø 1 / 1,5 / 2 mm



Replacement jaws

No. **30570-2001-01**



**Webnet eye end**



No.	Rope Ø mm	Insert marking
30880-0100-02	1	1 - 1
30880-0100-01	1	
30880-0150-02	1,5	1.5 - 1.5
30880-0150-01	1,5	
30880-0200-02	2	2 - 2
30880-0200-01	2	

-02 for one rope  
-01 for two ropes

**Battery swaging tool EK 354 ML**

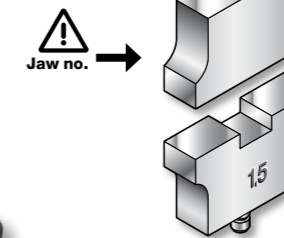
Corresponding to DIBt approval Z-14.7-557

Ø 1 / 1,5 mm



Jaws

No. **30575-0004-...**



**Webnet eye end**



No.	Rope Ø mm	Jaws No.
30880-0100-02	1	1
30880-0100-01	1	30570-0004-10
30880-0150-02	1,5	1.5
30880-0150-01	1,5	30570-0004-15

-02 for one rope  
-01 for two ropes

**Battery swaging tool EKM 6022 CL**

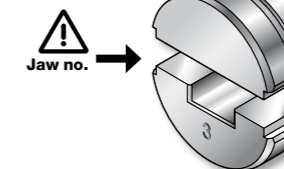
Corresponding to DIBt approval Z-14.7-557

Ø 1 / 1,5 / 2 / 3 mm



Jaws

No. **30575-0003-...**



**Webnet eye end**



No.	Rope Ø mm	Jaws No.
30880-0100-02	1	1
30880-0100-01	1	30570-0003-10
30880-0150-02	1,5	1.5
30880-0150-01	1,5	30570-0003-15
30880-0200-02	2	2
30880-0200-01	2	30570-0003-20
30880-0300-02	3	3
30880-0300-01	3	30570-0003-30

-02 for one rope  
-01 for two ropes

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