

PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. AMP hand tools are intended for occasional use and low volume applications. AMP offers a wide selection of powered application equipment for extended-use, production operations.

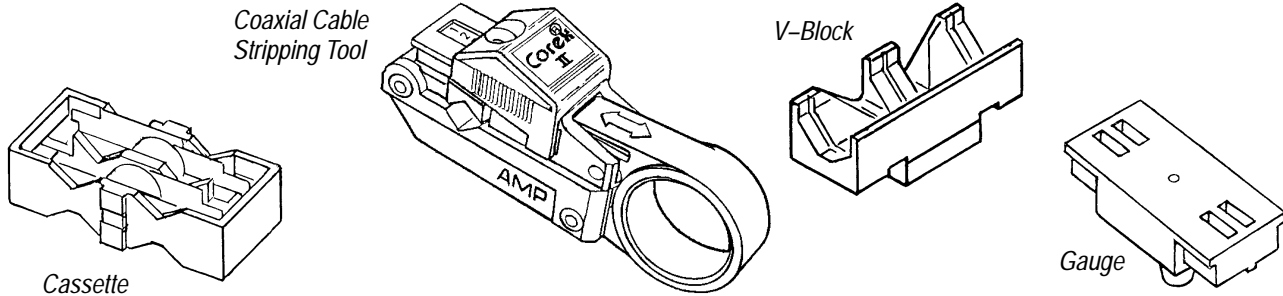


Figure 1

95-85, 95-84, 95-132

1. INTRODUCTION

The AMP Coaxial Cable Stripper Kits 603995-1 through -6 are capable of cutting and stripping five different sequential settings on three different areas of various coaxial cable sizes; see Figure 2. This sheet covers the cutting and stripping of the cable, the installation of new cutting blades, cassettes, adjustment gauge, V-blocks used for the various cable sizes, and adjustments and troubleshooting. See Figure 1.

NOTE

Dimensions on this document are in metric units [with U.S. customary units in brackets].

CAUTION

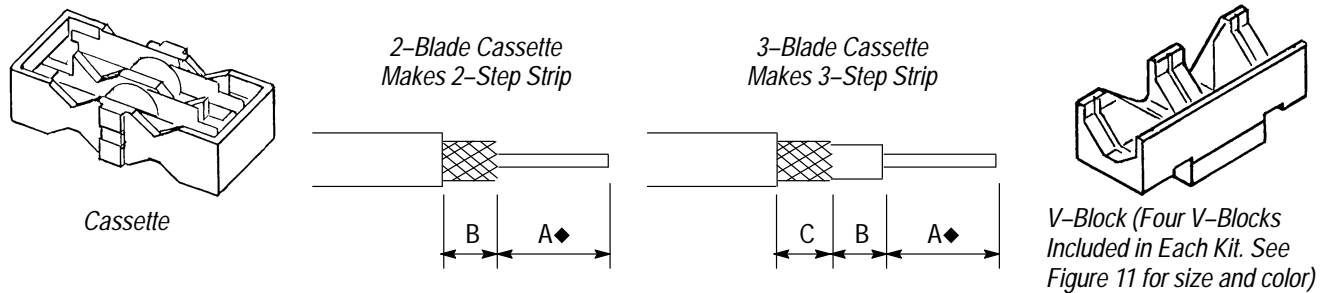
Do NOT use stripping tool on coaxial cables with drain wires.

CAUTION

A 3-step tool is not recommended for most styles of RG-62 cable, nor for many cable styles with cellular polyethylene or other soft dielectrics. Use 2-step tool instead.

Read these instructions thoroughly before using the tool.

Revisions are provided in Section 9, REVISION SUMMARY



COAXIAL CABLE STRIPPER KIT PN	CASSETTE PART NUMBER AND COLOR	BRAID STRIP DIMENSION B	BRAID STRIP DIMENSION		PRODUCT	CABLE DIAMETER RANGE
			B	C		
2 STEP STYLE	603995-1	603996-1 RED	6 [.24]	---	SINGLE CRIMP BNC	2.54 - 7.62 [.10 - .30]
	603995-2	603996-2 BLUE	6.8 [.27]	---	COMM BNC	
	603995-3	603996-3 YELLOW	12 [.48]	---	UHF	
3 STEP STYLE	603995-5	603996-4 BLACK	---	5.5 [.22]	5.5 [.22]	DUAL CRIMP BNC
	603995-6	603996-5 WHITE	---	2.5 [.10]	6.8 [.27]	DUAL CRIMP COMM-BNC

◆ For "A" dimension, refer to instruction sheet for your specific product.

95-85

Figure 2

2. DESCRIPTION

The AMP Coaxial Cable Stripping Tool automatically strips coaxial cable with jacket diameter of 2.54 to 7.62 mm [.10 to .30 in.], with minor adjustments. Shipped with the tool are five color-coded cassettes, four V-blocks and hex wrench.

Kits come in two styles: a 2-step kit for 2-step stripping, and a 3-step kit for either 2-step or 3-step stripping. (the 3-step kit will accommodate both 2-step and 3-step cassettes.)

Cassettes have pre-set strip lengths. Refer to instruction material for your connector to determine your strip requirements, then refer to Figure 2 to find which cassette meets your strip requirements.

Note the parts of the coaxial cable stripping tool in Figure 3.

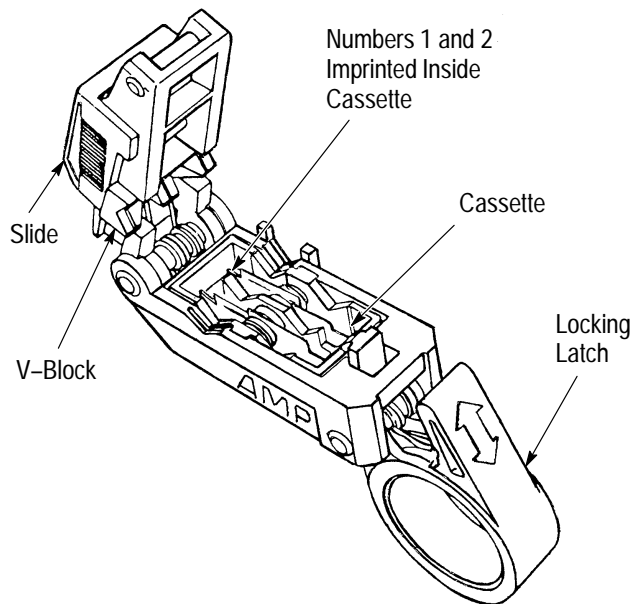


Figure 3

95-96

3. STRIPPING PROCEDURE

Follow these steps when stripping with the AMP Coaxial Cable Stripping Tool:

1. Adjust slide to position 4 or 5.
2. Open tool by rotating locking latch downward, as shown in Figure 4.
3. Mark jacket of cable for center conductor length. (If you have a simple wire cutter, ignore this instruction. You can cut center conductor to length after the strip or use conductor stop C-ST).
4. Hold the tool with the handle toward you and insert cable from left into the groove position. Close and latch tool. See Figures 5 and 6.

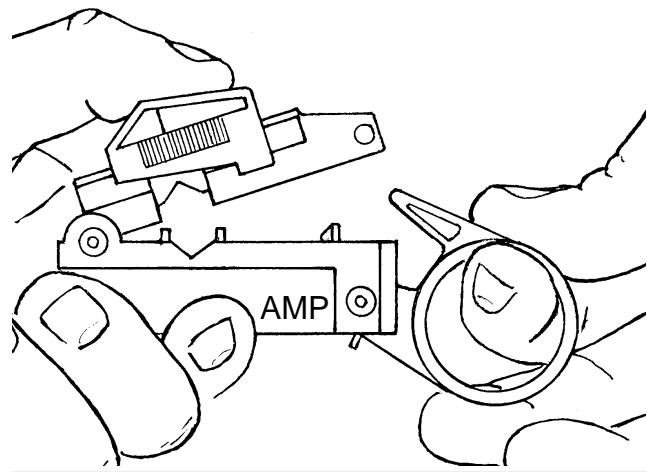


Figure 4

95-86

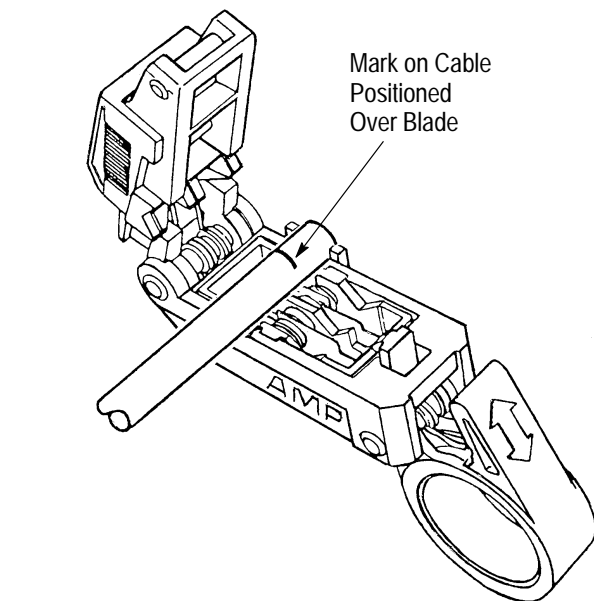


Figure 5

95-87

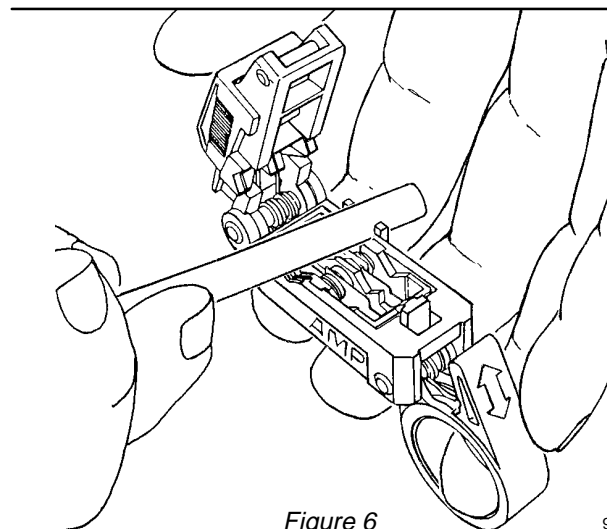


Figure 6

95-88

RECOMMENDED SETTINGS		
COAXIAL CABLE	V-BLOCK	SLIDE POSITIONS
RG 58	BLUE	3, 2, 1
RG 59, 62	BLUE	5, 4, 3
RG 174, 188, 316	WHITE	4, 3
RG 6	YELLOW	5, 4, 3
BELDEN 8281	YELLOW	5, 4
RG 195, 180	RED	4, 3, 2

Figure 7

5. Push slide forward to appropriate start position (see Figure 7). Make sure proper V-block is installed.

6. Rotate tool around cable about five times (see Figure 8). Push slide forward to next position in sequence. Rotate tool again. Then push slide forward to final position and rotate tool final five times.

7. Move slide back one position. Then pull cable out carefully while squeezing tool (see Figure 9). If there is too much resistance or strip is imperfect, refer to Section 4.

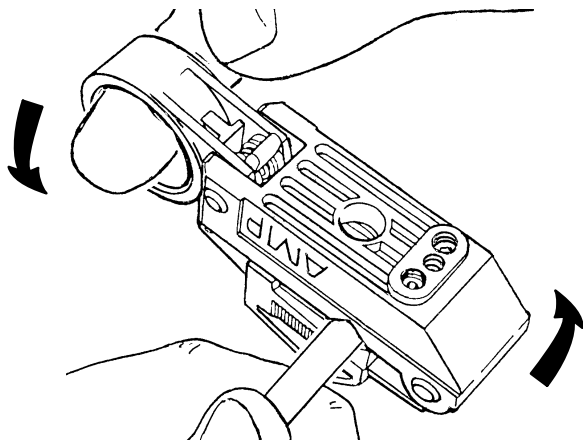


Figure 8

95-89

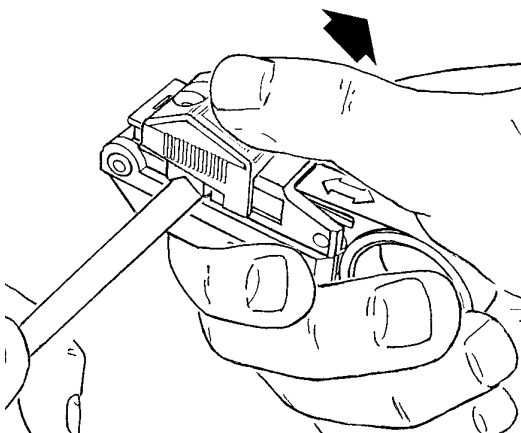


Figure 9

95-90

4. ADJUSTING THE TOOL

1. Inspect your first strip. Determine how deeply each blade has scored the cable. See Figure 10 for the proper direction you may have to adjust.

2. Adjust blade depth to match your cable by turning hex screws at base of tool (see Figure 10).

NOTE *If a blade is near its proper depth, turn its screw approximately one-quarter turn ($\pm 90^\circ$). If a blade is farther from its proper depth, turn its screw approximately three-quarter ($\pm 270^\circ$) to one complete turn ($\pm 360^\circ$).*

NOTE *Adjust tool so that the appropriate slide progression works correctly (see Figure 7); develop your own 2- or 3- stage sliding sequence.*

3. Try stripping again per Section 3, following Steps 1 through 7. If strip is still not acceptable, adjust blades again, following instructions in Steps 1 and 2.

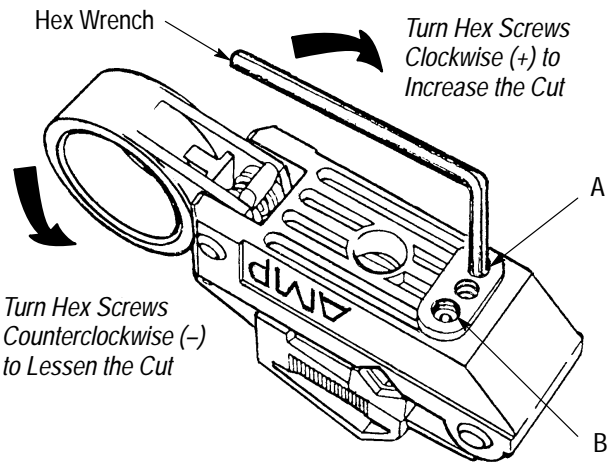


Figure 10

95-91

5. SOLUTIONS TO TYPICAL PROBLEMS

If braid is *twisting* too much, turn hex screw to increase cut of braid-cutting blade one-quarter turn **CLOCKWISE (+90°)**, and *turn* hex screw for jacket-cutting blade one quarter turn **COUNTERCLOCKWISE (-90°)**.

If, after repeated adjustment, most of the braid will not cut properly, the blade set is probably worn out. Reverse cassette to try new blade set.

With RG-174 or other very thin cable, very fine adjustment is needed. Expect to make several small adjustments, approximately one-twelfth turn ($\pm 30^\circ$), to reach proper blade depth. Use a fresh blade set. Use only high quality thin cable.

6. REPLACEMENTS

6.1. Replacement V-Block Selection

Select proper V-block by outside diameter of wire (see Figure 11).

V-BLOCK		
PART NUMBER	CABLE OUTSIDE DIAMETER	COLOR
603997-1	3.0 - 5.0 [.12 - .20]	RED
603997-2	5.0 - 6.4 [.20 - .25]	BLUE
603997-3	6.4 - 7.6 [.25 - .30]	YELLOW
603997-4	2.5 - 3.0 [.10 - .12]	WHITE

Figure 11

6.2. Changing V-Block

1. Open tool fully (Figure 12) until the springs holding V-block release.
2. Pull out V-block and replace with selected V-block.

NOTE With white V-block, you must position springs in holes.

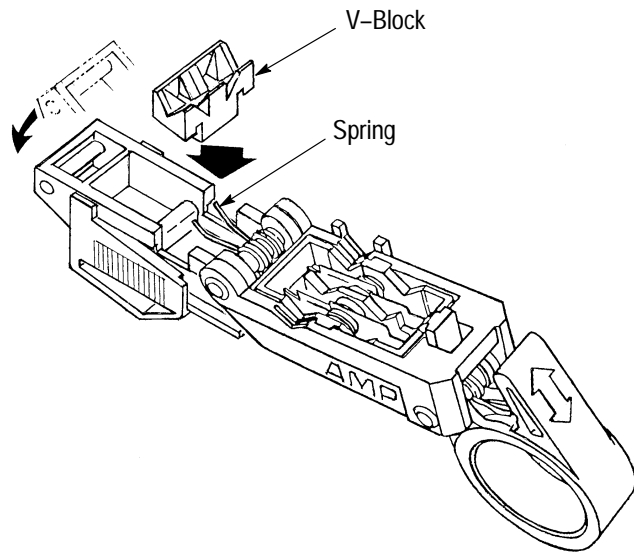


Figure 12

95-92

6.3. Cassettes

Each cassette contains 2 sets of cutting edges. Cassette can be reversed each time a blade set wears out. Numbers 1 and 2 are printed inside cassette to determine usage.

A. To Change or Reverse Cassette

Move locking latch in direction of arrow, then push cassette out of tool by inserting wrench through hole in bottom of tool. Figure 13.

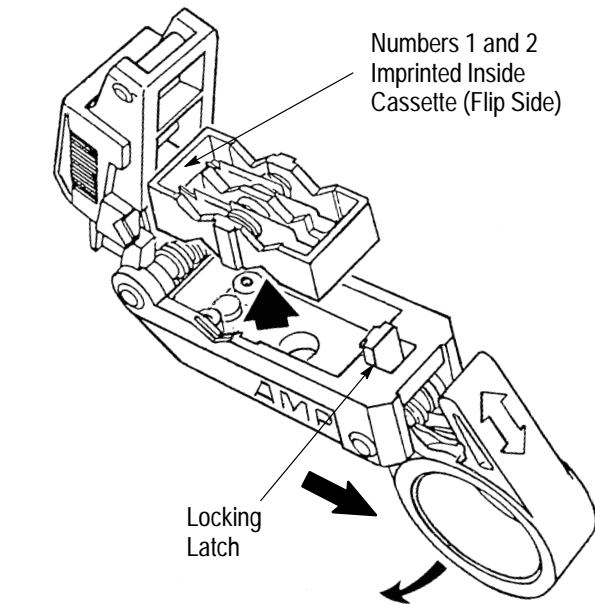


Figure 13

95-93

B. Step Strip With 2-Bladed Cassette

This procedure is recommended only in those cases where the 3-step strip you require is not available in one of the standard AMP Series cassettes.

If your required strip length is as shown in Figure 14, choose the 2-step cassette that matches your "C" dimension.

Mark cable at length "A+B" from end. Figure 15.

1. Open tool, insert cable from left, and locate mark on cable over the right hand blade.
2. Close and latch tool and strip cable according to Section 3.

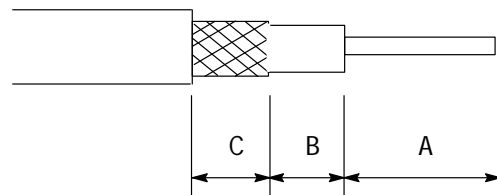


Figure 14

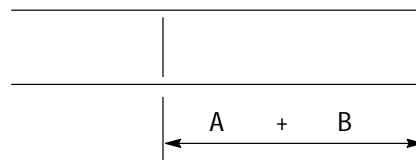


Figure 15

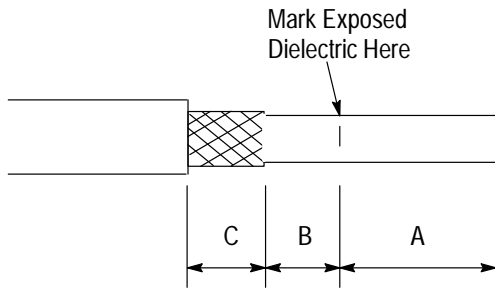


Figure 16

NOTE

An adjustment of the tool might be necessary. A correct strip is shown in Figure 16.

3. Mark exposed dielectric at length "A" from end.
4. Remove dielectric at the mark with a simple wire stripping plier. See Figure 17.

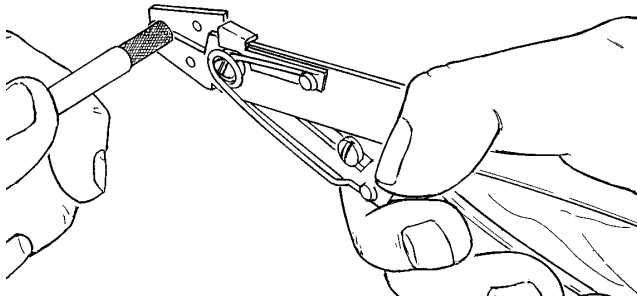


Figure 17

95-95

The slide is a unique and important part of the stripper. The slide allows you to ease the blades into the cable, reducing the friction on the braid and dielectric as you strip.

NOTE

Always use your slide when you strip.

Adjust your tool for the appropriate slide progression. If your cable size does not appear in Figure 7, develop your own 2- or 3-stage sliding sequence.

NOTE

Always step back to position 1 on slide before pulling out of tool.

7. ADJUSTMENT GAUGE

1. Open the tool by rotating locking latch downward as shown in Figure 18.

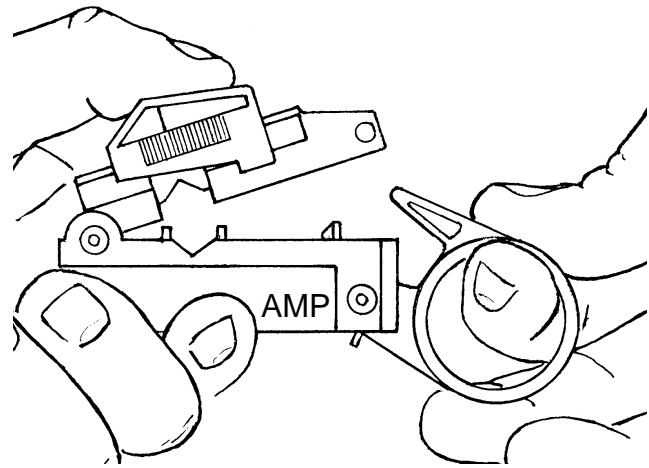


Figure 18

95-86

2. Push the cassette out of the tool by inserting the wrench, or appropriate object, through hole in the bottom of the tool. See Figure 19. Turn blade adjustment screws (see Figure 10) counterclockwise until they are fully retracted.

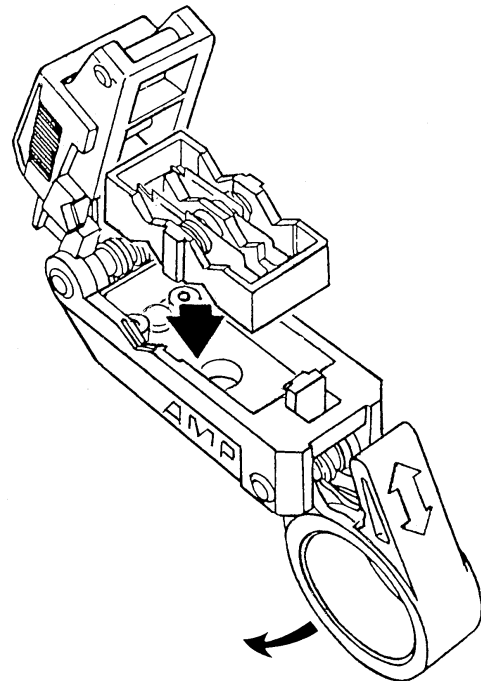


Figure 19

95-94

7.1. Installation of Adjustment Gauge

The gauge is marked with different cable types. Install gauge so that the markings, which correspond to the cable type to be stripped, are above the adjustment screws; see Figure 20. Close the tool.

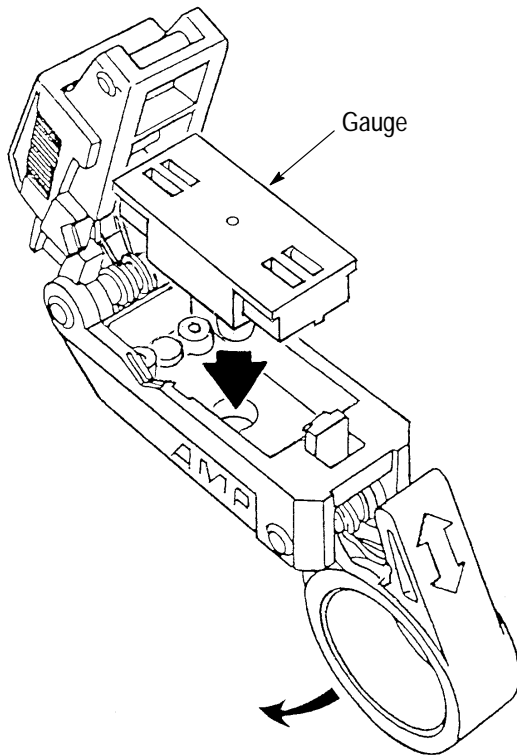


Figure 20

95-94A

7.2. Screw Adjustment

1. Rotate the blade adjustment screws (A or B) clockwise until they touch the gauge; see Figure 21.
2. Open the tool and remove the gauge.
3. Install the cassette, and the tool is now ready for use.

8. REPLACEMENT PARTS

The parts listed in Figures 2 and 11 are customer-replaceable. A complete inventory can be stocked and controlled to prevent lost time when replacement

of parts is necessary. Order replacement parts through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (38-35)
AMP INCORPORATED
P. O. BOX 3608
HARRISBURG, PA 17105-3608

9. REVISION SUMMARY

Since the previous release of this sheet, the following changes were made:

Per EC 0220-0827-94:

- Revise and add all new text and art.

Per EC 0990-0252-93:

- Updated format.
- Added metric units.
- Added Section 9, REVISION SUMMARY.

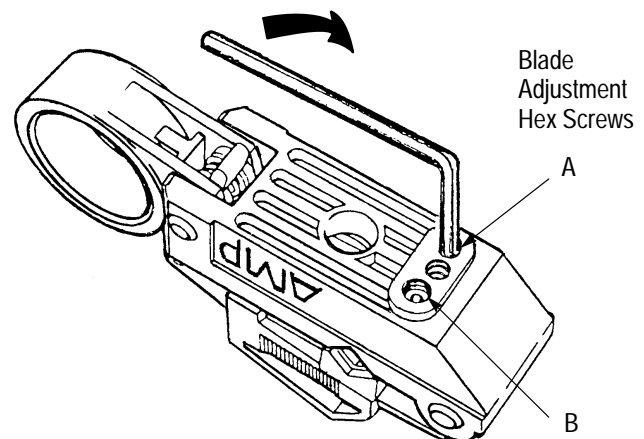


Figure 21

95-91