ELE-3COP-261

Title – Screened Component Wire Preparation.

Before starting work please read this document carefully and note the guidance given.

1 Purpose and Scope

This COP describes the procedure to be used when preparing screened and jacketed component wire. The instructions in this document take preference over IPC/WHMA requirements, as do the drawing and any customer documentation.

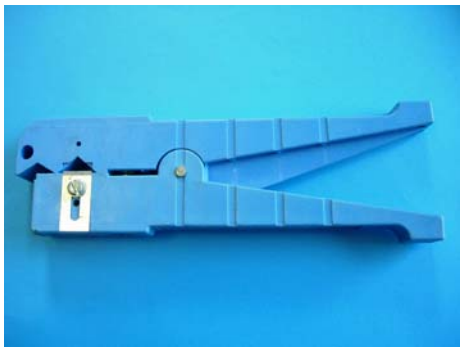
2 Performance Objective

This code of practice is produced to support operators already trained in the installation of heat shrinkable and harnessing products. It identifies the procedure to be used for screened and jacketed component wire preparation.

3 Materials and Equipment:

Ideal Strippers

Cable Dia. (mm)	Part No.	Replacement Blade Set Part No.
Up to 3.1 mm	45 – 162 - 341	L9225
3.2mm to 5.5mm	45 – 163 - 341	L9225
4.8mm to 7.9mm	45 – 165 - 341	L9225
6.4mm to 14.3mm	45 – 164 - 341	L9226



4 Health and Safety

Adhere to local Codes and Regulations relating to Safe Working practices. For the U.K. adhere to requirements of the Health and Safety at Work Act 1974 and subsequent amendments.

A knife should never be used for wire stripping as this can easily cause personal injury and conductor damage.

5 Procedure – Cutting

End Strip

Set the depth of the blades to approximately 75% of the jacket thickness.
Ensure the wire sits in the "V" notch.
Strip back the jacket and shield to the required dimension.
Rotate the tool once around its circumference and remove the tool.
Flex the cable so as to propagate the notch through the jacket wall and slide off the jacket.
Slide back shield and using side cutters trim back to the edge of the wire jacket ensuring a good clean edge. (See Figure 1)
Strip back the jacket to the required dimension. (Default dimension is 6mm).
Ensure the wire sits in the "V" notch.
Rotate the tool once around its circumference and remove the tool.
Flex the cable so as to propagate the notch through the jacket wall. (See Figure 2)
As a rule the second section of jacket should be removed after the solder Sleeve device has been slid on. Where this is not possible take great care that the shield is not disturbed. (See Figure 3)

Figure 1

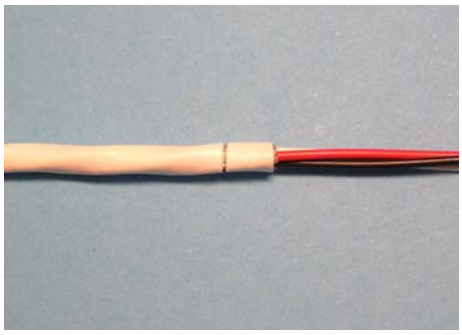


Figure 2

Figure 3

Centre Strip

Set the depth of both of the side blades and the front blade on the front of the tool to approximately 75% of the thickness of the wire jacket.
Position the tool so that the cable sits into the 'V' notch directly underneath the side blade.

Rotate the tool once around its circumference and remove the tool.
Flex the cable so as to propagate the notch through the jacket wall. (See Figure 4)
Position the wire jacket to be removed (Section X) so that the cable sits into the 'V' notch directly underneath the front blade.
Press the blade into the cable jacket and remove the tool. (See Figure 5)
Propagate the notch through the jacket wall thus removing this section of cable jacket. (See Figure 6)


Figure 4


Figure 5


Figure 6

6 Inspection Requirements

The cut through the insulation shall be clean and the strands shall not be not scraped, nicked severed or otherwise damaged.
Strands are not flattened, untwisted, buckled, kinked or otherwise deformed.
Component wire insulation is not nicked or otherwise damaged.

7 Visual Standards

See Figures 1, 2, 3, 4, 5 and 6.

Rev No	CR No	Date	Raised	Approved
3	CR06-DM-071	16/05/06	John Cronin	Ken Wallington
4	CR09-DM-018	17/02/09	Paul Newman	Neil Dorricott
5	Visual Identity	06/06/11	Paul Newman	Neil Dorricott