

# ELE-3COP-252

## Title - Primary Wire Preparation (Centre Strip).

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 centre stripping Primary 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 when preparing Primary wire (Centre strip).

### 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



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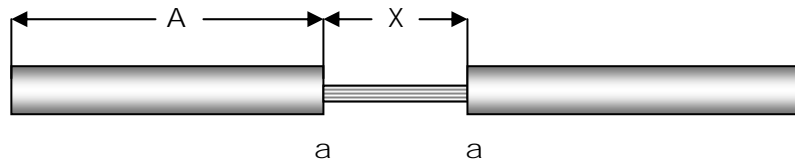
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#### 4 Health and Safety

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

Figure 1



Dimensions **A** and **X** to be specified in the relevant Process Control documentation. 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. 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. Propagate the notch through the jacket wall thus removing this section of cable jacket.

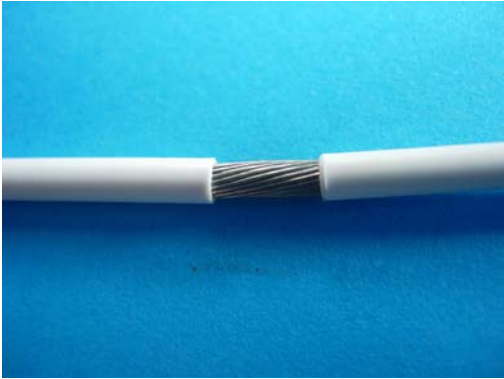
#### 6 Inspection Requirements

The length marked as X in Figure 1, shall be clean and free of insulation. The cut through the insulation shall be clean and the strands shall not be scraped, nicked, severed or otherwise damaged at plane a in Figure 1. Strands are not flattened, untwisted, buckled, kinked or otherwise deformed.

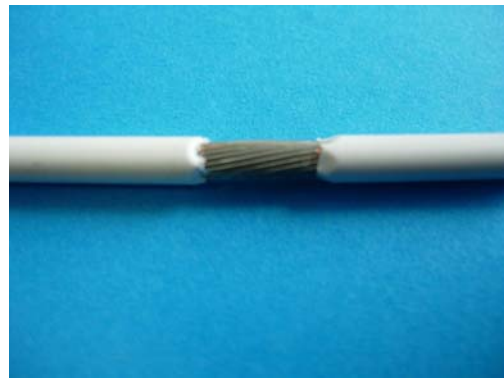
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### 7 Visual Standards



ACCEPTABLE



NOT ACCEPTABLE  
Insulation not cleanly cut



NOT ACCEPTABLE  
Damaged and nicked conductors

Rev No	CR No	Date	Raised	Approved
3	CR06-DM-071	19/04/06	John Cronin	Ken Wallington
4	CR09-DM-018	27/01/09	Paul Newman	Neil Dorricott
5	Visual Identity	06/06/11	Paul Newman	Neil Dorricott

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