



Calibration Procedures

For Custom Stripmaster® and Custom Stripmaster® Lite Wire Strippers with Die-Type Blades



Step 1

Place the lower stationary blade half over the blade mounting studs.



Step 2

The blade dogleg should be attached first then depressed to seat itself. Slightly depress blade handle to allow the blade to be properly seated. Insert the dogleg of the upper movable blade into the locating slot of the side latch.



Step 3

Position the blade retaining plate over the mounting studs. Install split lock-washers and hex nuts onto the mounting studs. Do not tighten hex nuts at this time.



Step 4

First, position the lower blade half cutting surface in line with the lower gripper pad surface by slightly depressing the gripper handle.

Next, depress both handles just enough to allow the top and bottom blade surfaces to meet. (Exerting too much pressure on the handles could

force the bottom blade out of alignment.) Now tighten the hex nuts to a maximum torque value of 10 in. lbs.



Step 5

Visually check the upper and lower blade alignment by depressing the blade handle only until the blade surfaces make contact. Leaving the

gripper pads in the open position, look at the blade cutting holes and mating surface between holes. This is most effectively accomplished with a light source behind the stripper. Look for light in cracks between the cutting holes. If light can be seen in these areas, inspect the blades' mating surfaces for debris or imperfections. Clean the blades and check for light "leaks" again. If the blades have debris or imperfections, set-up was not correctly performed. In this case, repeat the set-up procedures.

Step 6

The final checking procedure to confirm proper blade set-up and calibration is to perform a series of strips on wire samples for which the blades were designed. In doing so, be sure the one-step stripping action is smooth with positive slug removal. During the stripping process check that the wire does not slip in the grippers and that the wire is not excessively bent by the gripper pads. Finally, closely inspect the stripped wire to be certain there are no nicks, scrapes or other defects in the conductor.

Should any of the above occur, repeat the blade set-up and calibration procedures. Also, be certain that the sample wire is indeed correctly matched with the cutting blades used. Refer to the blade reference charts on pages 20 through 22 for blade selection guidelines.

Optical Comparator

Some customers will have access to an optical comparator which can assist in determining proper blade alignment. In this case, light is used to project blade gap onto a screen. A template affixed to the screen verifies blade hole size and position. A fixture should be used for repeat comparisons. This fixture blocks the moveable blade into the stationary blade.

Caution: Never plug or mechanically gauge blade holes as this could result in damage to the blade.

With the cutting blades properly set-up and calibrated, the Custom Stripmaster® and Standard Stripmaster® Wire Strippers provide automatic, repeatable and superior quality wire stripping in a wide variety of production applications. Quality control and efficiency are assured.