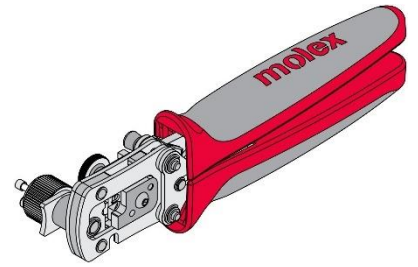


**Order Number
200218-3500**



Application Tooling Specification



FEATURES

- A full-cycle ratcheting hand tool ensures consistent stripping
- Ergonomically designed soft handles
- Accurately strip cable jacket, braid and dielectric with one tool
- Built-in cable cutter
- For terminal crimping, use hand tool 200218-3300

SCOPE

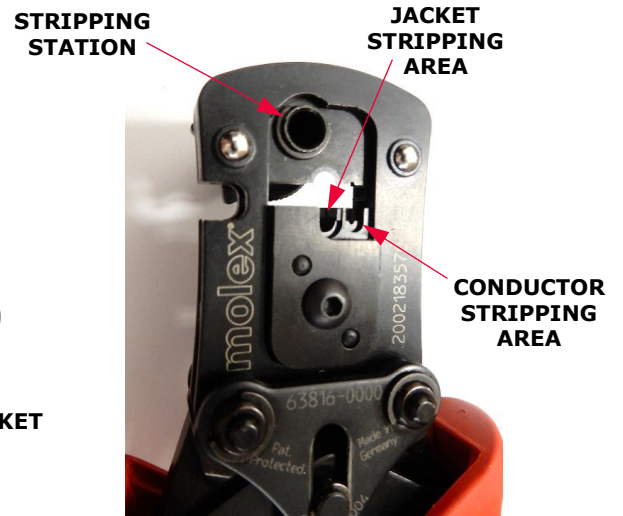
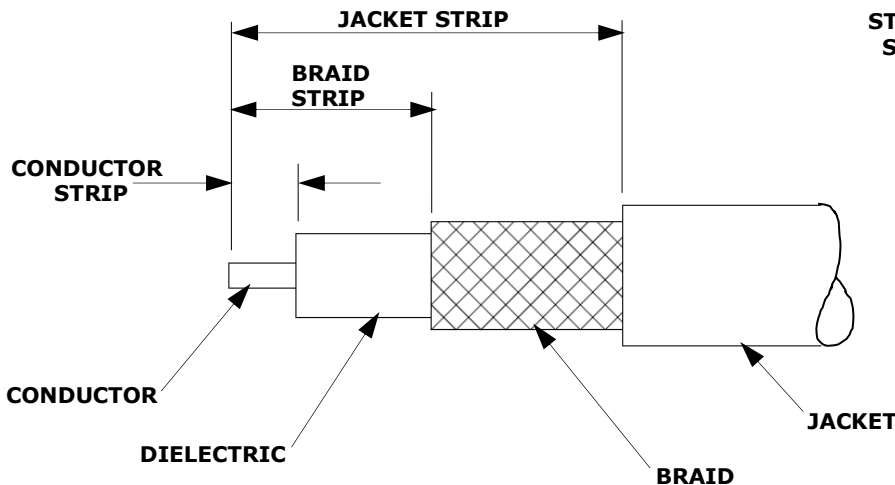
Products: LEONI and CONDUMEX RG58 Cables used with sealed FAKRA RG58 Pin and Receptacle Crimp Terminals.

Terminal Series No.	Terminal Order No.		Cable Type	Cable		Strip Length
	Reel	Loose Piece		Manufacturer	Part Number	
89556	89556-2511	—	RG58	LEONI	DACAR 037	See Figure 1
				CONDUMEX	800315-49	
89559	89559-1031	—	RG58	LEONI	DACAR 037	
				CONDUMEX	800315-49	

BEFORE CABLE PREPARATION

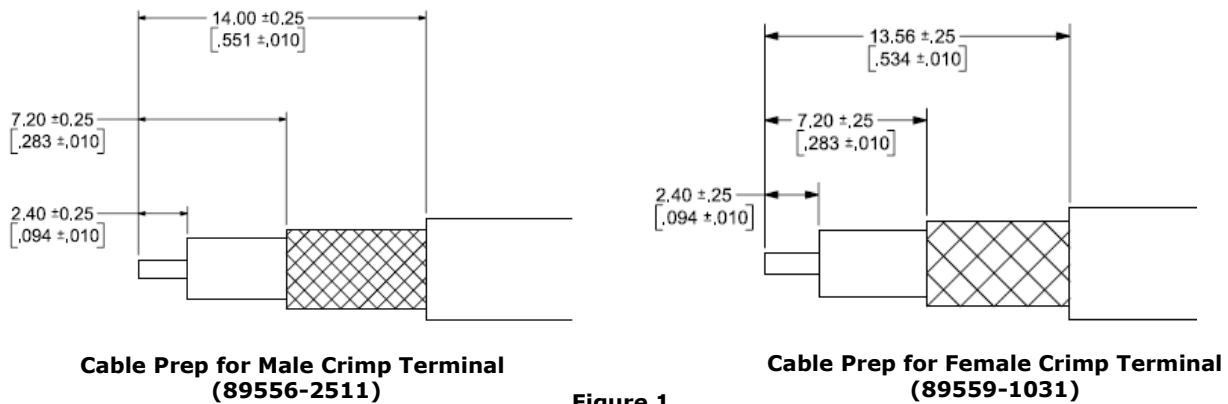
The FAKRA connector’s end cap, cable seal and crimp tube must be loaded on the RG58 cable before preparing the cable.

DEFINITION OF TERMS



CABLE STRIP SPECIFICATION

The prepped cable should measure as follows:



Notes

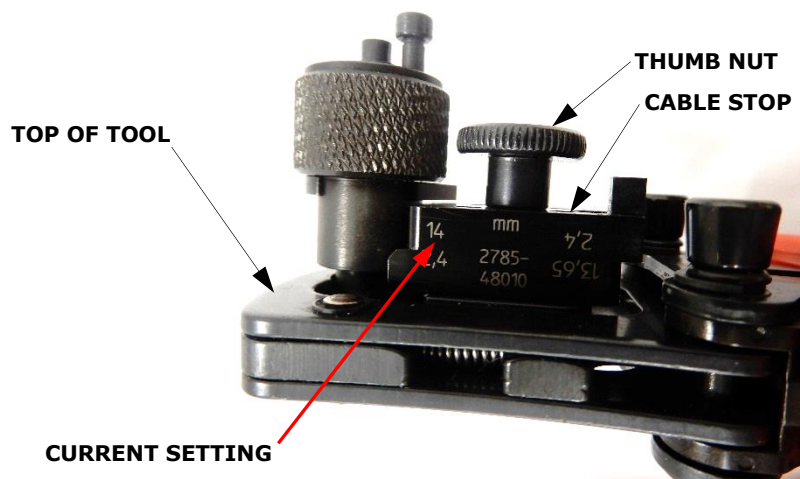
1. This tool should only be used with the RG58 cables specified in this document.
2. Variations in tools and cable construction may affect stripping quality.
3. Molex does not repair hand tools. See warranty on page 7. The replacement parts listed are the only parts available for repair. If the handles or strip tooling become damaged or worn, a new tool must be purchased.
4. Molex does not certify hand tools.

SETUP

To create the required jacket strip length (see Figure 1), the cable stop needs to be in the correct position.

The jacket strip length setting is visible from the side of the tool. The number on the cable stop closest to the top of the tool is the current setting. See Figure 2.

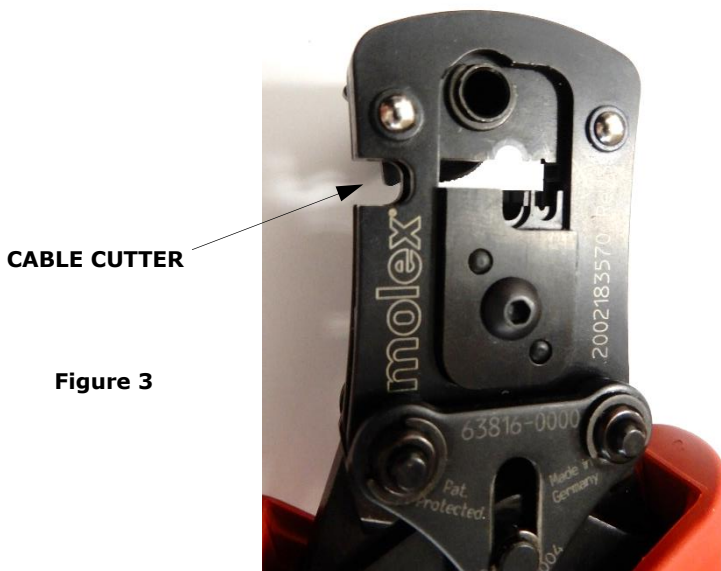
To change the cable stop setting, remove the thumb nut. Remove the cable stop, rotate it 180° and reinstall the cable stop. Tighten the thumb nut to hold the cable stop in place.



OPERATION

Cable Cutting

A cable cutter is available on the side of the hand tool for cutting bulk RG58 cable. See Figure 3.



Squeeze the tool handles together until the ratchet releases. Release the handles, allowing them to spring open.

Place the cable inside the opened cable cutter. To prevent an angled cut, hold the cable square to the hand tool frame and squeeze the tool handles together until the ratchet releases.

Release the tool handles and remove the cut cable.

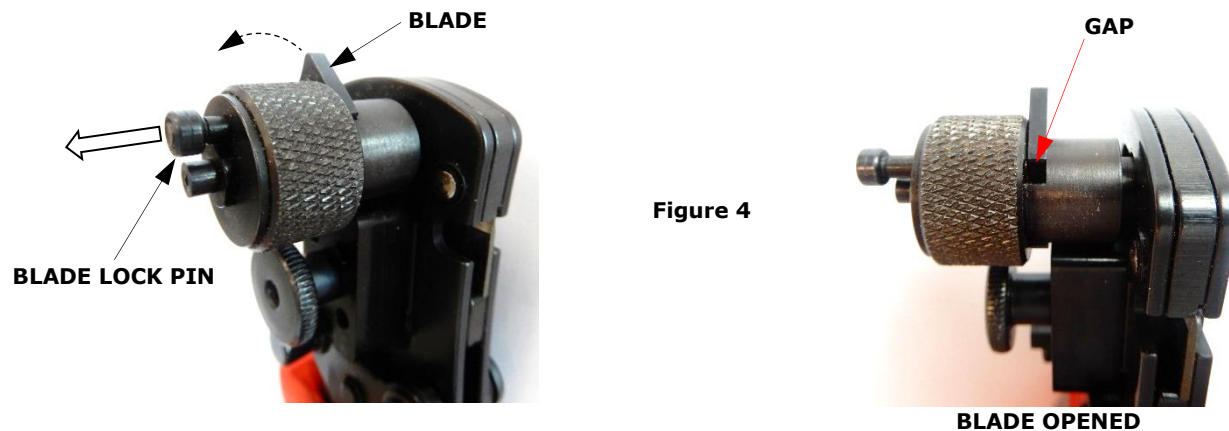
Cable Stripping

The cable is stripped in three steps: braid strip, jacket strip and conductor strip. Refer to the Definition of Terms section to identify the three stripping areas on this tool.

Note: Stripping must be performed in this sequence.

Step 1: Braid Strip

1.1 Open the stripping blade by pulling out the blade lock pin and pivoting the blade open. When the blade is opened, a gap is visible in the tool. See Figure 4.



Cable Prep Tool for Sealed FAKRA RG58 Pin and Receptacle Assemblies

- 1.2 Insert the RG58 cable into the stripping station until it stops. The cable is fully inserted when the eject pin is fully extended. See Figure 5.

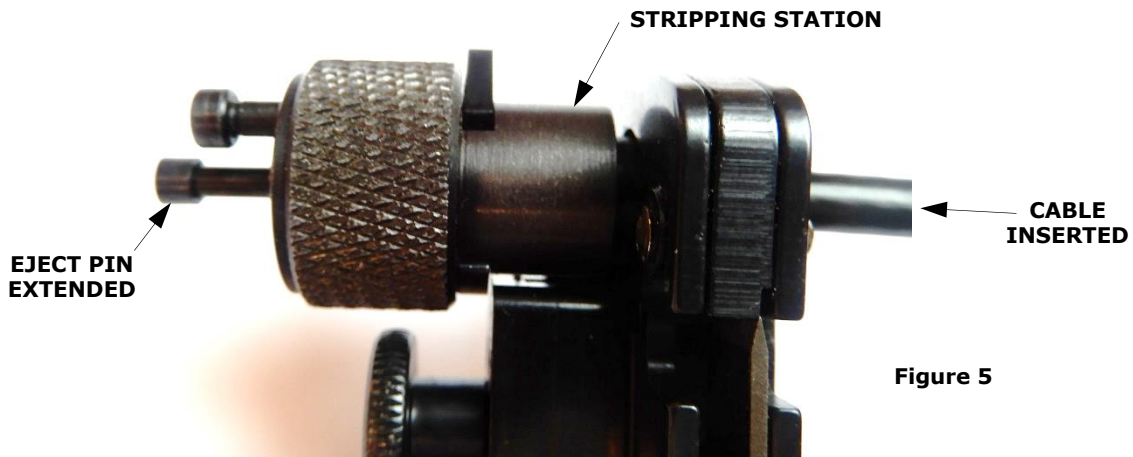


Figure 5

- 1.3 Hold the cable securely so that it does not move out of the stripping station. Then, close the stripping blade until the blade lock pin snaps in (the gap in the tool also will be closed). See Figure 6.

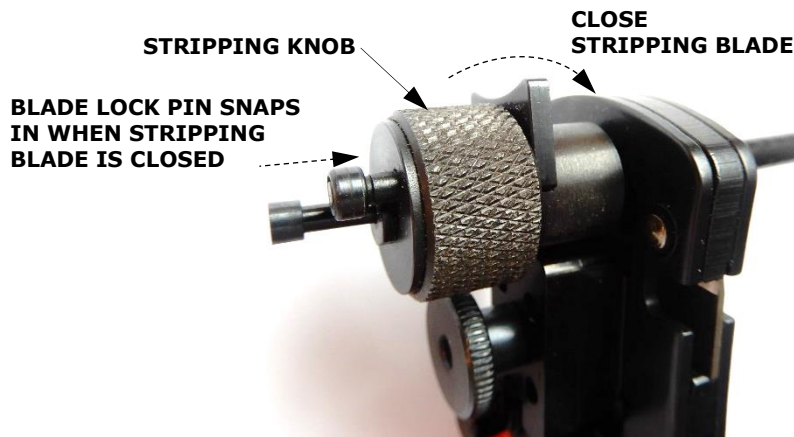


Figure 6

- 1.4 Hold the cable to prevent it from rotating, and turn the stripping knob several revolutions. When it becomes easier to turn the knob, stop.
- 1.5 Open the stripping blade by pulling out the blade lock pin and pivoting the blade open. Make sure the blade is fully open by checking for the gap in the tool. See Figure 7.



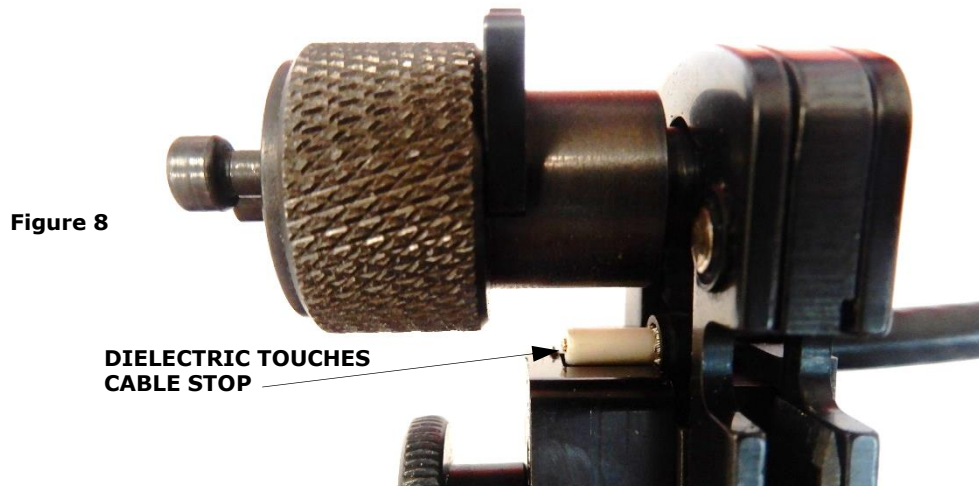
Figure 7

Cable Prep Tool for Sealed FAKRA RG58 Pin and Receptacle Assemblies

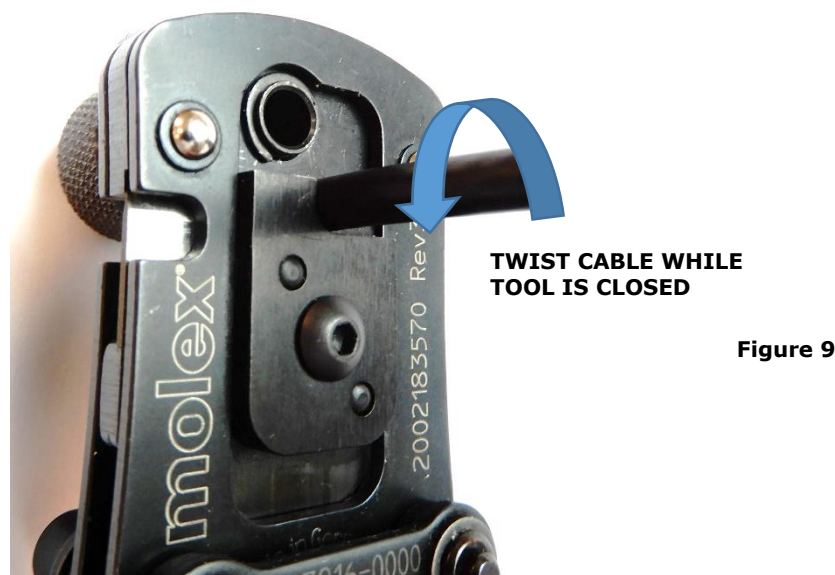
- 1.6 Remove the stripped cable from the stripping station by pushing on the eject pin.
- 1.7 Remove the cut slug from the cable. It works best to twist the slug several times (twisting the slug will break free any braid strands that did not get cut) before pulling it off the cable.
- 1.8 Remove any braid debris from the cable and tool before proceeding to the next step.

Step 2: Jacket Strip

- 2.1 Ensure the cable stop is in the correct position for the jacket strip length needed (see Setup).
- 2.2 Squeeze the tool handles together until the ratchet releases. Release the handles, allowing them to spring open.
- 2.3 Place the cable in the jacket stripping area (left side stripping area) and push it forward until the dielectric stops on the cable stop. See Figure 8.



- 2.4 While holding the cable against the cable stop, close the tool by squeezing the handles together until the ratchet releases.
- 2.5 While holding the tool handles closed, twist the cable several turns. This helps the stripping blades cut cleanly through the cable jacket. See Figure 9.



- 2.6 Release the tool handles and remove the cable. Pull off the jacket strip slug.

Step 3: Conductor Strip

- 3.1 Squeeze the tool handles together until the ratchet releases. Release the handles, allowing them to spring open.
- 3.2 Place the dielectric in the conductor stripping area (right side stripping area) and push it forward until the dielectric stops on the conductor stop. See Figure 10.

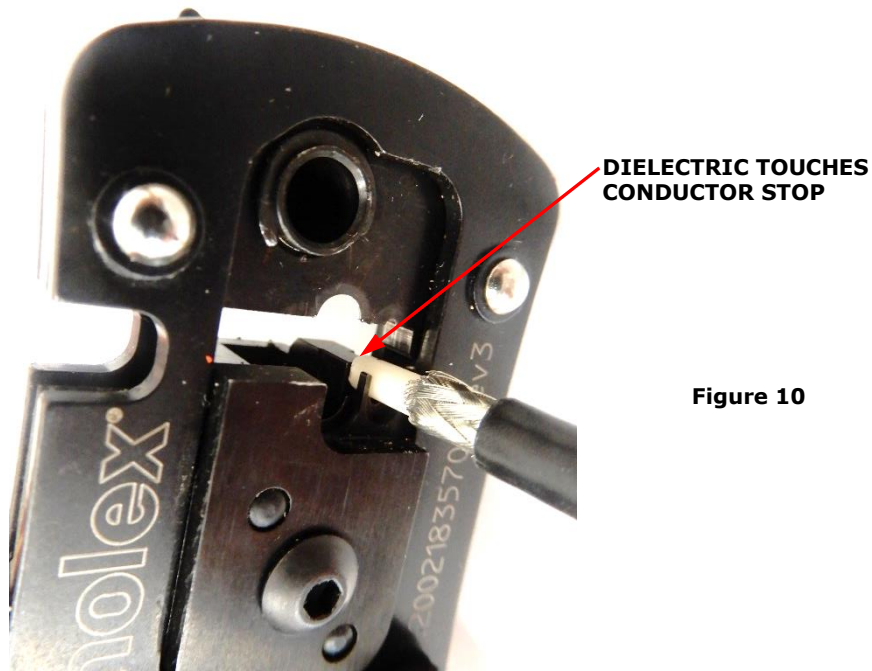


Figure 10

- 3.3 While holding the dielectric against the conductor stop, close the tool by squeezing the handles together until the ratchet releases.
- 3.4 While holding the tool handles closed, twist the cable several turns. This helps the stripping blades cut cleanly through the dielectric. See Figure 11.

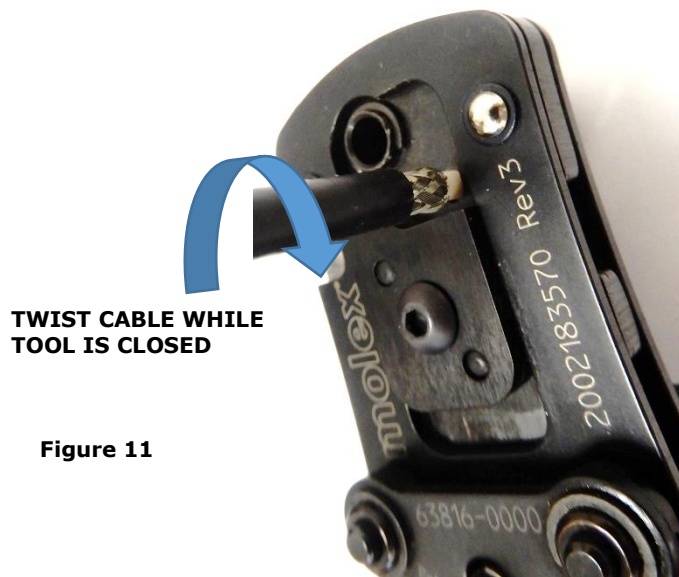


Figure 11

- 3.5 Release the tool handles and remove the cable. Pull off the dielectric slug.

MAINTENANCE

It is recommended that each operator of the tool be made aware of and responsible for the following maintenance steps:

1. Remove dust, moisture and other contaminants with a clean brush or a soft, lint-free cloth.
2. Do not use any abrasive materials that could damage the tool.
3. Make certain all pins, pivot points and bearing surfaces are protected with a thin coat of high-quality machine oil. Do not oil excessively. The tool was engineered for durability, but like any other equipment, it needs cleaning and lubrication for maximum service life. Light oil (such as SAE30 oil) used at the oil points every 5,000 cycles or 3 months will significantly enhance the tool life.
4. Wipe excess oil from the hand tool, particularly from the stripping area. Oil transferred from the stripping area onto certain terminations may affect the electrical characteristics of an application.
5. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping dies, and store the tool in a clean, dry area.

Tool Jams

Should this tool ever become stuck or jammed in a partially closed position, **Do Not force the handles open or closed**. The tool will open easily by lifting the ratchet release lever. See Figure 12.

Warranty

This tool is for cable stripping purposes only. All tools are warranted to be free of manufacturing defects for a period of 30 days. Should such a defect occur, Molex will repair or exchange the tool free of charge. This repair or exchange will not be applicable to altered, misused or damaged tools. This tool is designed for hand use only. Any clamping, fixturing or use of handle extensions voids this warranty.

CAUTION: Repetitive use of this tool should be avoided.

PARTS LIST

Item	Order Number	Description	Quantity
1	63816-0000	Hand Crimp Frame (Short)	1
2	63816-0001	Locking Pin	2
3	63600-0525	Handle Spring	1
4	63600-0520	Crimping Spring	1

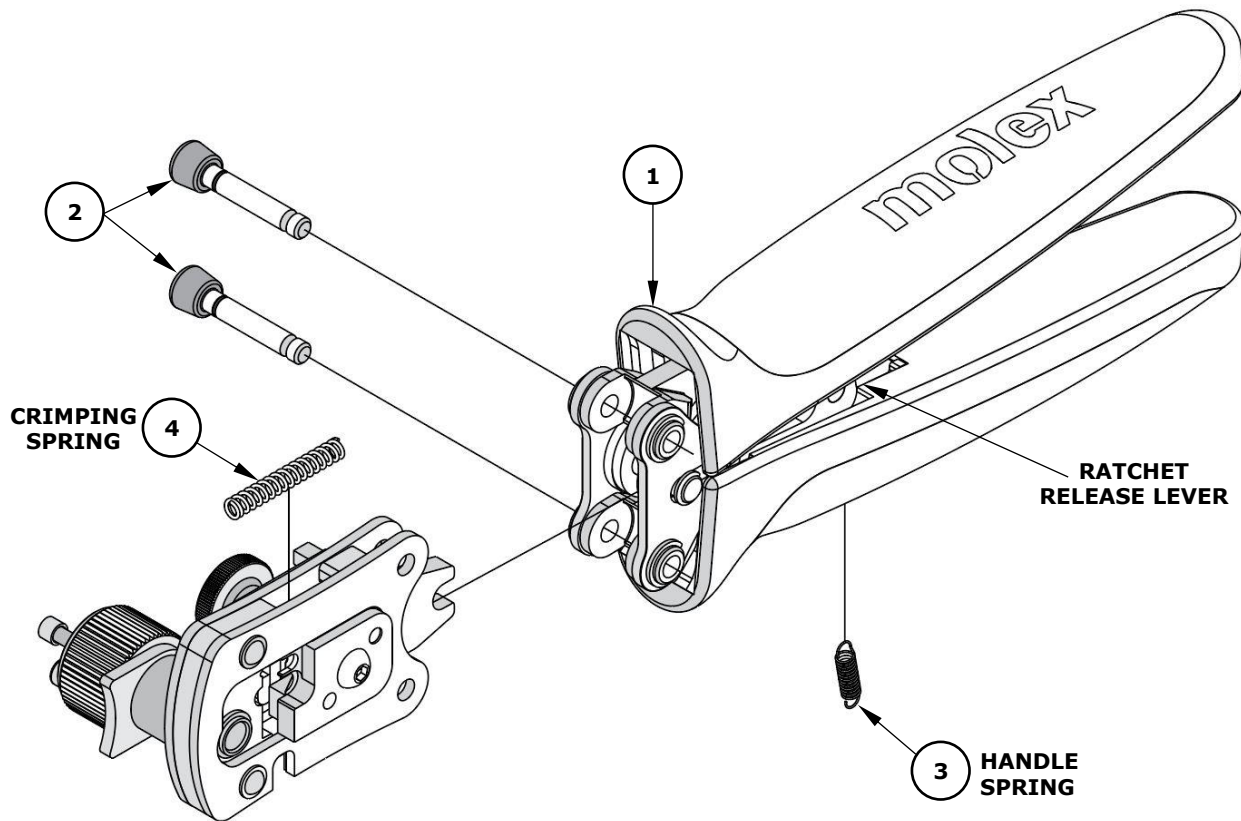


Figure 12

Application Tooling Support

Phone: (402) 458-TOOL (8665)
E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling

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