14 Route d'Auray – ZA de Talhouët
56330 PLUVIGNER
Tel : +33966 90 42 70
Email : info@artosfrance.com
Siret : 34273353200044

MANUAL

Pneumatic Stripping Machine

AM.STRIP.1

Preliminary Remarks

First of all, we would like to thank you very much that you decided for the AM.STRIP.1 of the be-ri cable processing machinery programme. We hope that you can produce without further problems and reliably with this machine for many years. Should any defects arise or should you need further information concerning the application of the machine, please do not hesitate to contact us.

The manual on hand corresponds to the regulations in enclosure II A of the EC Machinery Directive 2006/42/EG. The original manual has been written in German language.

The manual is an important part of the supplied machine and should be kept near the machine for quick access. The manual has been structured chronologically and shows the necessary adjustments of the machine parameters, the safety devices etc. step by step. Thus, it considerably facilitates the safe work with the machine.

Before you take the AM.STRIP.1 into use, you have to study the manual carefully. It is important that the remarks in the manual are comprehensible. Please take care that each machine operator knows and acts according to the descriptions in the manual, especially to the remarks concerning the safety devices in chapter 3.4.2.

If you should not understand the function descriptions, remarks, technical explanations etc. in the manual, please contact your responsible representation resp. our factory in Münster/Germany:

FEINTECHNIK	**Tel.:**	**o251 / 96 115 - o**
R.Rittmeyer GmbH	**Fax:**	**o251 / 62 45 25**
Höltenweg 1o3	**Email**	**info@rittmeyer-beri.de**
D - 48155 Münster	**Website**	**www.rittmeyer-beri.de**

The AM.STRIP.1 usually is set up ex works for delivery to cut wires 1 x 0,75 mm², to a stripping length of 10 mm, with a working pressure of 4 bar, and is equipped with prismatic blades (V-blades)[1]. On request, any other equipment is available, especially if special equipment or special devices[2] are needed.

The machine is equipped with all necessary safety devices.

Always take care of the correct function of the safety devices.

Before removing the safety devices, the machine has to be disconnected from the compressed air net!

Pay attention to warning-notices and information signs on the machine.

The machine must be firmly mounted on the work table. Accessories see 7.2

For spare part orders, please give the name of the part requested, the order number, the machine type and the machine number.

While using the extended stop dog oo3.5127, the AM.STRIP.1 cannot be operated with prismatic blades resp. other overlapping blades.

1 see chapter 9.3
2 see chapter 9.2

1 Technical Data

Machine type	**pneumatic stripping machine**
Type name	**AM.STRIP.1**
Producer	**FEINTECHNIK R. Rittmeyer GmbH** **Höltenweg 103** **D - 48155 Münster** **phone 02 51 96 11 50** **fax 02 51 62 45 25** **Email: rittmeyer.be-ri@t-online.de** **Internet: www.rittmeyer-beri.de**
Sound level	**< 7o dB(A)**
Operating pressure	**3 - 7 bar**
Air consumption / stroke	**1,8 l at 6 bar**
Machine location	**table, work bench or similar**
Stripping length (total stripping)	**up to 65 mm**
Stripping diameter	**o,5 – 12,5 mm**
Local necessities (in mm) W x D x H	**340 x 440 x 200 mm**
Weight (without accessories)	**12,0 kg**
Standard blades[3]	**prismatic blades oo3.oo41**
Special blades	**see chapters 9.3 and 9.4**
Start impulse	**with foot switch**[4]

[3] is already fitted into the standard version of the machine
[4] is included in the standard accessories set

2 Short Description of the Machine

Please check the shipment for completeness, for visible or covered transportation damages etc. immediately after delivery of the new AM.STRIP.1. In chapter 7.2 you can find a list of the standard accessories' set. Please contact the responsible forwarder in case of possible transportation damages. Please contact your supplier if you miss accessory parts.

2.1 Appropriate Use

The AM.STRIP.1 is a semi-automatic stripping machine for stripping (and simple cutting) of round or flat cables with insulations made of different materials like synthetics, rubber, PUR, Teflon etc. for cables and wires.

The use of special blades[5] that are adapted to the cable in process, allows the processing of nearly all common cables. The blades can be changed within seconds and without any further tools.

2.2. Non-appropriate Use

The AM.STRIP.1 is not made for the processing of materials other than those, which are normally used for insulation and jacket materials of cables and electric conductors, or for other works as those described in chapter 2.1.

The machine is also not made for the processing of massive shields made of copper or harder materials, steel wire networks etc.

Non-appropriate use makes all guarantee and liability regulations ineffective.

2.3 Location / Room Climate

The AM.STRIP.1 has been constructed as a table instrument. Please take care that the room climate corresponds to the usual factory conditions. The machine is not intended to be operated in humid or wet rooms, in rooms with excessive dust production or in an environment containing explosives.

No liquids or parts may enter the casing of the AM.STRIP.1.

2.4 Functional Process

The round cable is put through the red cable guide oo3.oo49 (resp. a flat cable is put through the slit in the front plate oo3.5o91) in the front plate oo3.5o90 up to the adjustable stop dog. The single working steps are released with a foot switch oo3.6o33.

The working cycle for the stripping process functions as follows:

[5] also see chapters 9.3 and 9.4

A Initial position A: the blades are opened, the long cylinder oo3.6o6o is placed in the front[6]. The machine is in operating condition.

B After release of the front switch: the cross cylinders move together - and accordingly the clamp jaws oo3.5o36 / oo3.5o84 and the stripping blades. The cable is clamped, and the blades cut into the insulation.

C The long cylinder moves back to the stop dog - the insulation is removed by the blades. The stroke limitation oo3.5126[7] can be used for partial stroke.

D In the final position of the long cylinder, the stripping blades open again, and the clamp jaws set the cable free.

E You now have to remove the cable from the machine in order to exclude malfunctions caused by the blades that move forward again.

F The long cylinder moves to the initial position, and the open clamp jaws and blades accordingly.

In the standard version of the stripping machine AM.STRIP.1 the working cycle is only completed after the release of the foot switch. The release of the foot switch causes the stop of the working cycle - the machine moves back to the initial position.

3 Operation and Adjusting Possibilities

The machine is equipped with all necessary safety devices. In order to avoid injuries, the machine always has to be disconnected from the compressed air net, before performing any adjusting, modifications or maintenance work.

Please note: The machine must be firmly mounted on the work table (screws see accessories 7.2).

3.1 Preparing Works

First check the machine for completeness and covered resp. visible transportation damages. **In order to avoid reaching into the working area of the AM.STRIP.1 from below, please screw the machine on a fixed working bench.** In addition, sew a waste management slit with a max. 2o mm width and a 13o mm length into the working plate of the bench. Then make two borings of ∅ 1o mm for the fixing screws. The necessary two fixing screws M 8 x 14o, two bolt washers 8,4 mm and two nuts M 8 are included in the standard equipment.

Put the screws from above into the corresponding borings in the back area of the machine frame, then fix them under the bench plate with washer and nut. Please find enclosed a drawing "Preparation of the Working Bench" ("Vorbereitung Arbeitstisch").

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6 "the long cylinder (resp. the blades) is placed in the front" implies that the blades are placed in this position directly behind the front plate

7 also see chapter 9.2

3.1.1 Connection for Foot Switch

First connect the tubes of the foot switch as follows:

- black air cable to 3 / 2 way valve oo3.6o24
- blue air cable to air distributor oo3.ooo2 above
- air cable "clear / white" with air distributor oo3.ooo2 below

The connection places on the machine are marked with the corresponding colours.

3.1.2 Connection for Compressed Air

The pressure regulator oo3.6091 (with the pin nipple oo3.6107) for the compressed air is placed at the right back wall of the machine (seen from the front). The standard equipment includes the locking coupling oo3.6106.

Fix the compressed air tube with the tube seal of the locking coupling and put it on the pin nipple.

By pulling back the release sleeve at the locking coupling, the AM.STRIP.1 can be disconnected from the compressed air net at any time. The pneumatic components of the machine will be automatically ventilated.

Please take care that only properly prepared compressed air is used which does not contain aggressive media.

3.1.3 Working Pressure

The working pressure is adjusted to 3 - max. 7 bar. The compressed air display oo3.6o19 is placed on the right back side of the machine (seen from above).

3.1.4 Protection Devices

- Push the Plexiglas protective cover into the guide grooves as far as possible and screw on the front plate with a hexagonal key
- Protective bonnet 2 safety switches
- Front plate 1 safety switch
- The safe position of the machine is interrogated via 2 safety switches in the machine frame

3.1.5 RESET Press Key

The RESET press key is located in the left cover sheet (drawing number oo9.6oo9). After pressing the RESET press key and when safety cover and front plate are in the correct position, the machine is ready for operation.

3.2 Operation Mode of the AM.STRIP.1[8]

Depending on the cable quality it is possible to regulate the stripping diameter up to 6 mm² with the pressing power of the clamp jaws[9] by means of the mechanic coupling of the clamp jaws 003.5036 / 003.5084 with the blade heads 003.5130/..31, when prismatic blades (V-blades) are used[10]. However, the use of die blades is recommended for usual stripping works.

The machine has to be adjusted according to the blade type chosen.[11]

3.3 Machine Adjusting Possibilities

You can - indirectly - adjust the cable diameter (3.3.1 ff.), the stripping length (3.3.2), the removal length (3.3.3) and the pressing power of the clamp jaws (3.3.4) on the AM.STRIP.1.

An optimum adjustment of the machine guarantees optimum stripping results.

3.3.1 Diameter

The operation mode of the machine also allows stripping (up to approx. 6 mm²) with V-blades. However, it is not common use. It is more recommended to use adapted die blades for stripping.

3.3.1.1 Adjustment Diameter for the Use of V-Blades (Prismatic Blades)

Our standard machines are supplied with V-blades that can be applied many-sidedly. Thus, it is possible to either cut or strip cables.

See sketch III in chapter 9.6, cutting of cables.

In order to strip cables with V-blades, please proceed as follows:

A Connect machine to compressed air net according to chapter 3.1 ff. - take care that the protection devices function correctly – press RESET press key.

Long cylinder moves to front position

B The clamp jaws have been adjusted ex works such that they clamp the cable centered to the blades. Take care that this central position is kept while you change diameters.

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8 also see chapter 2.4
9 see chapter 3.3.4
10 Whether the use of prismatic blades is recommended at all depends strongly on the quality requirements for the cut and the insulation
11 see chapter 3.3.2

Release a working cycle with the foot switch -without any cable inserted into the machine. Take care that the opening, formed by the V-blades, is larger than the inner cable-∅ to be processed, in order to avoid that the blades cut into the cable and are exposed to unnecessary wear. Chapter 2.4 B describes the status of the machine when checked.

In order to change the requested diameter, please set the adjusting screws oo3.5o35 for the adjustment of the clamp jaws **symmetrically** right and left.

When the preselected diameter the V-blades form after the lateral clamp cylinders have moved together is optically bigger than the inner cable diameter to which you want to strip, you can start the first stripping tests.

C Now insert your cable through the red guide sleeve and start the machine. Optimize the adjustment of the clamp jaws, until you gain the requested stripping results.

Please remove the processed cable from the machine, after the cable insulation has been stripped.

Take care that you never keep a firm hold to a cable which runs into the machine because of wrong adjustment of the clamp jaws - you could probably injure your hands.

3.3.1.2 Adjustment Diameter for the Use of Die Blades

Die blades do not shear but hit each other. The so formed die has to be adapted to the preselected cable diameter. In order to use optimum die blades, we recommend to send cable samples (approx. o,5-1 m) for the necessary tests to your supplier or directly to us. You can be sure of always using optimum die blades. Take care that the machine is adjusted the way that the clamp jaws do not clamp the cable too strong, to avoid clamp marks or damages to the cable[12]. The centering tools of the die-blades have to be adapted to the outer jacket of your cable to be processed.

3.3.1.3 Die blades "negative"

For some cables it could be senseful to use die-blades "negative", meaning with the bezel to the interior of the machine.

[12] also see chapter 3.3.4

3.3.1.4 Centering tools and die-blades

In those case when die-blades are ordered without having exemplars of the cable we send the die-blades together with not mounted centering tools.

Then the customer needs mounting the centering tools by himself as follows:

1 mount one centering-tool at the backside of one blade (the side the bevel of the blade isn't visible) in that way, that the cable is centered

2 fix the blade with the mounted centering-tool (e.g. in a vise) and beat the centering-tool carefully back to a max. angle of about 5°, or curve the centering-tool with a claws. Please take care not to harm the blade.

3.3.2 Stripping Length

You can preadjust the stripping length with the stop plate with bar oo3.5o5o. At first disconnect the machine from the compressed air net. Remove the plexiglass cover oo3.oo53. Unscrew the clamp screw oo3.ooo7 on the piston rod of the stripping cylinder oo3.6o6o and adjust the stop dog to the requested length.

3.3.3 Removal Length[13]

You can adjust the removal length with the stroke limitation 003.5126 (see chapter 9.2).

Without stroke limitation, the long cylinder always makes the complete stroke movement of 75 mm. For economical reasons, we recommend the use of a stroke limitation for mostly short stripping lengths.

3.3.4 Pressing Power of the Clamp Jaws

In chapter 3.3.1 ff we have already described the mechanical adjustment of the pressing power of the clamp jaws.

If unwelcome markings should remain on the insulation coating of the cable, you can regulate the air pressure with the pressure regulating valve so far that you obtain an optimum adjustment of the pressing power. If still unwelcome clamp marks remain on the cable, you have the option of using special clamp jaws[14].

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13 "Removal length" is the distance to which the insulation coating of a medium is removed - measured from the round cut in removal direction. If the removal length is smaller than the stripping length, we speak of a "partial stroke"

14 also see chapter 9.2 - clamp jaws with Volcano oo3.5o57

3.4 Setting into Use

3.4.1 Preparation

A Preparation of the working bench (see chapter 3.1)
B Connect foot switch according to colour code (3.1.1)
C Connect air cable (to max. 8 bar; 3.1.2)
D Adjust working pressure at pressure regulator to 6-7 bar
E Fix plexiglass safety cover and front plate
F Press RESET press key

All cylinders now move to the initial position[15]

3.4.2 Safety Devices[16]

The AM.STRIP.1 is equipped with all necessary safety devices. However, no system can be completely protected against misuse. All modifications or amendments that are not made ex works by the manufacturer, or other measures that are not given in writing, will cease all guarantee and liability claims to be in force.

Never reach hands into the working area of the machine from below. Screw the machine firmly to the work table. Drill holes in the tabletop for supply lines. Screws etc. are supplied as standard accessories (see 7.2).

Because the insulation waste drops down from the machine, the AM.STRIP.1 is consequently not equipped with a bottom sheet. But since the machine is only 12 kg, the danger of an operator reaching his hand into the working area of the machine is given. To exclude such an accident, you have to fix the machine on the working bench.

The individual safety functions and elements[17] are described in the following:

3.4.2.1 Safety Switch - Plexiglass Safety Cover

Two micro ram valves oo3.6o27 are placed at the end of the grooves, where the plexiglass safety cover is put in. They will be activated in the moment of installing the safety cover.

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15 also see chapter 2.4

16 The following safety acts, regulations and standards have been considered for the construction of the AM.STRIP.1:
- EC Machinery Directive [(Original) Directive] 2006/42/EG, enclosure II A

17 also see chapter 6.1

3.4.2.2 Safety Switch - Front Plate

A small pin at the back side of the front plate oo3.5o90 / ..91 causes a ram to release a third safety switch.

3.4.2.3 Pneumatic Safety Stop (RESET press key)

By releasing the RESET press key, and with all safety switches activated and all safety covers correctly assembled, the pneumatic safety stop will be neutralized.

The cylinders move back to the initial position and the machine is ready to use.

It should not be possible to press the RESET press key and to start the machine with the foot switch while the front plate or safety cover are removed.

When you put in the safety cover or screw the front plate, the machine should not switch into the operating condition – this should only be possible after releasing the RESET press key.

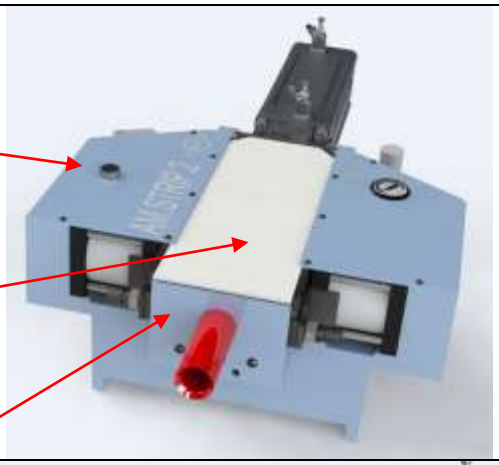
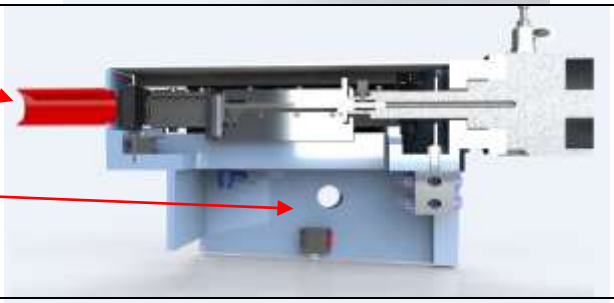
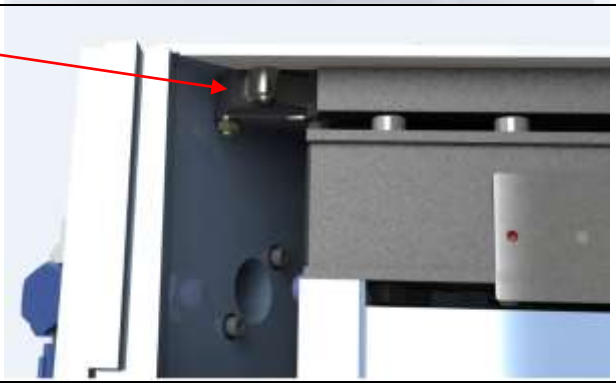
Please check regularly whether the necessary safety measures of the machine work correctly, and whether any danger for the operator is excluded.

3.4.2.4 Safety Switch Machine Frame

The safe position of the machine on the work table is monitored via two safety valves 004.6130 at the bottom of the machine frame. Lifting the machine deactivates all machine movements.

3.4.2.5 Overview of safety devices

(Note: the following explanations show the AM.STRIP.2, a larger version of the AM.STRIP.1, as an example.)

Pneumatischer Sicherheitstaster (Pneumatic Safety Stop) 009.6009 Plexiglas-Sicherheitsabdeckung (plexiglass safety cover) 003.0213	
Frontplatte 003.0213 mit Hülse 003.0098 Stößelventil (ram valve) 004.6130	
Miniatur Stößelventil (micro ram valve) 003.6027	

Insertion sleeves

The sleeves are designed in accordance with DIN EN ISO 13857 to prevent the risk of them being picked through the machine.

4 Processing Possibilities

The AM.STRIP.1 is a universally applicable cable stripping and cutting machine. In chapter 1o.1, "Application Possibilities", the different application and processing possibilities are shown in a survey. In chapter 9.6 the construction variations are described in details.

5 Basic Construction and Modification Possibilities

5.1 Basic Construction

The basic construction corresponds to the standard delivery state of the AM.STRIP.1 - described in detail in chapter 9.6 I.

5.2 Modification / Change of Blades

A **Disconnect machine from the compressed air net**

B Remove plexiglass cover forwards

C Detach screw M4 in the blade-head with a fixed-spanner (standard equipment) and take out the blades

D Install necessary blades (see 9.3, 9.4 and enclosure 1o.1 "Application Possibilities") in reverse order

There are drillings in the stripping blades for an easy positioning.

Flat cutting blades and intermediates don't have these drillings – before tightening they must be fixed right below respectively left below

Do not put down the blade heads on the running surface because they are finely ground. Even slightest dirt could cause unnecessary wear.

6 Maintenance / Service

6.1 General Remarks

To comply with the legitimate claims to optimum operating and machine security we recommend a regular safety check of all construction parts and function cycles, according to the frequency of their use.

You can easily check the safety devices of the AM.STRIP.1 by testing whether the compressed air is immediately blown off, if one of the safety devices[18] described above is removed.

Never operate the machine, while the safety devices do not work correctly.

6.2 Slip Guides

Clean and grease the blade head-slip guides and their running surfaces once a week. We recommend additional cleaning in case of great dirtiness due to talcum and stripping rests.

6.3 Clamp Spindles

Oil the clamp spindles oo3.oo22 once a month with medium heavy machine oil.

6.4 Pneumatics

The control valves and cylinders have been durably oiled with pneumatic oil and do not need further maintenance. For maintenance and service references of the regulator valve see also precautions for safety filter-regulator 003.6065 *(compendium from the Manual of the producer of filter-regulator 003.6065* - chapter 9.6).

6.5 Machine Interior

Clean the working area of the machine from time to time carefully with brush and duster, depending on is dirtiness. We recommend an intermediate cleaning in case of great dirtiness due to talcum and stripping rests.

Take care that no foreign parts or liquids get into the casing openings.

Do not use compressed air in order to clean the working area! Foreign parts or talcum could get into unwelcome places and spoil the function.

[18] see chapters 3.4.2.1 + 3.4.2.2

7 Accessories

7.1 Blades

The standard versions of the AM.STRIP.1-machines are fitted with prismatic blades (V-blades). However, we recommend die blades, adapted to the cable, for optimum stripping results. Sometimes it can be useful to put in die blades "negatively" - the cutting bevel directed towards the machine interior - to achieve better stripping results. The available blade types are listed in chapters 9.3, 9.4 and in enclosure 1o.1.

7.2 Standard Equipment (not installed)

Qt	Text	Order-No.
1	foot valve, complete	oo3.5o4o
1	front plate with cable guide ∅ 13 mm	oo3.5o91
2	screws M8 x 14°	oo3.8o71
2	U-discs 8,4	oo3.8o72
2	nuts M8	oo9.8oo6
1	box of grease	oo3.8o54
1	fixed spanner, 3 mm	oo3.8o96
1	locking coupling	oo3.61o6
1	socket hook 4 mm	oo3.8o52
1	intermediate 5 mm	oo3.oo74

For table mounting:

2	screws DIN912 M8x140 8.8	
2	U-discs DIN 9021 M8	
2	Nuts DIN 934 M8	

7.3 Special Equipment and Special Devices (see chapter 9.2)

8 Warranty provisions

8.1 Services

We grant a warranty period of 1 year after the delivery date and for single-layer operation. The warranty covers materials and processing defects under conventional use[19] and in accordance with the intended applications presented in this operating manual.

During the warranty period, the FEINTECHNIK R.Rittmeyer GmbH or a representative authorized by the FEINTECHNIK R.Rittmeyer GmbH as the exclusive guarantor, commit themselves to either repair or replace the parts that have deemed faulty upon examination, without charging material or labor costs, provided that the faulty parts are sent to us in proper packaging and with carriage paid.

8.2 Limitations

The above warranty does not apply to devices for which unauthorized repairs were performed or in case of misuse, negligence or an accident. Warranty is excluded for devices, for which, according to our judgment, evidence is available and proves a use outside of the intended applications presented in this operating manual, or for which the serial number has been modified or removed.

The FEINTECHNIK R.Rittmeyer GmbH hereby disclaims any liability for the suitability or fitness for a particular purpose. The FEINTECHNIK R.Rittmeyer GmbH is not liable under any circumstances vis-à-vis the purchaser or a third party for any incidental or consequential damages or loss of profit or production due to a device defect or failure.

If the device is to be used for another application than those presented as intended applications in this operating manual, then a written confirmation of its applicability and suitability must be obtained in advance from the factory.

No person or company has the right in any way to change, modify or supplement the warranty provision.

[19] For these, please refer to sections 2.1 and 2.2.

9 List of Spare Parts

9.1.1 List of Spare Parts - Single Parts

Order No.	Assembly Parts	In Assembly Group:
oo3.ooo4	stop rod	oo3.5o43
oo3.ooo5	carrier screw	oo3.5128
oo3.ooo6	carrier	oo3.5128
oo3.ooo7	clamp screw	oo3.5128
oo3.o2o7	blade head bar, right or left	oo3.513o / .5131
oo3.oo22	clamp spindle	oo3.5o35
oo3.oo28	guide sleeve	oo3.5o35
oo3.o213	plexiglass cover	---
oo3.oo66	ram (for safety device)	---
oo3.oo67	spring (for safety device)	---
oo3.oo68	holding sheet	---
oo3.oo71 oo3.oo72 oo3.oo74	intermediate 2 x 12 x 25 3 x 12 x 25 5 x 12 x 25	--- --- ---
oo3.oo92	cable interguide, two-sided	---
	cable guide (M 2o x 1), ∅ 13mm (other bushing – ∅ on request)	

9.1.2 List of Spare Parts - Pneumatic Parts

Order No.	Pneumatic Parts	In Assembly Group:
oo3.6o6o	long cylinder (without accessories)	oo3.5128
.6oo2	cross cylinder (without accessories)	---
.6oo3	throttle for long cylinder	oo3.5128
.6111	water collecting glass, compl.	---
.6o19	manometer	oo3.6oo7
.6o22	swing screwing	oo3.5o48
.6o24	3 / 2 way valve	oo3.5o48
.6o25	swing screwing	oo3.5o48
.6o26	silencer	---
.6o27	micro ram valve	---
.6o29	tube PU 3; 1ooo mm; black	---
.6o32	screwing	oo3.5o4o
.6o33	foot valve (without accessories)	oo3.5o4o
.6o35	tube Flexo; 2ooo mm; blue	oo3.5o4o
.6o36	tube Flexo 55; 2ooo mm; white	oo3.5o4o
.6o37	tube ∅ 6; 2ooo mm; black	oo3.5o4o
.6o38	screwing	oo3.5o4o
.6o39	o - ring	---
.6o43	safety cover for foot valve	---
.6o65	filter – regulator	---
.6130	micro ram valve	---

9.1.3 List of Spare Parts - Assembly Groups

Order No.	Standard Assembly Groups
oo3.5131	blade head, right (without intermediates)
.5130	blade head, left (without intermediates)
.5o35	adjusting screw / clamp jaw compl.
.5o36	clamp jaw right compl.
.5o84	clamp jaw left compl.
.5128	long cylinder compl.
.5o38	blade head guide, right
.5o39	blade head guide, left
.5o4o	foot valve compl.
.5133	cover sheet, right
.5o42	cover sheet, left
.5o44	roller lever
.5091	front plate 13 with sleeve
.5090	front plate with slit
.5o48	valve block
.5o5o	stop plate with bar
.5o61	cutting stop pipe

9.1.4 List of Spare Parts - Accessories and Special Devices

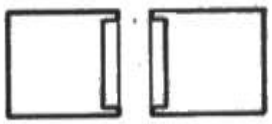
Order No.	Accessories and Special Devices
003.0049	cable guide sleeve, adapted to cable-∅
.0215	elevated plexiglass cover
.51o6	slitting equipment (see Application Possibilities of the AM.STRIP.1, 1o.1)
.5o15	cutting guide for flat cable
.5o16	stripping guide for flat cable (with front plate)
.5o23	holding plate with special pipe
.5127	stripping stop dog (up to 25o mm stripping length)
.5126	stroke limitation ∅ 20 mm (for quicker working cycle)
.5o57	clamp jaw with Volcano
.5o58	blade head construction I "cutting and stripping" (see Application Possibilities of the AM.STRIP.1, 1o.1)
.5o59	blade head construction II "cutting and stripping, in steps" (see Application Possibilities of the AM.STRIP.1, 1o.1)
.5o6o	blade head construction III "stripping, in steps" (see Application Possibilities of the AM.STRIP.1, 1o.1)
.5o82	cable guide blade set, adapted to customer's cable
.5o43	cutting stop dog up to 500 mm
.5o49	holding plate with pipe
	Intermediates:
003.0073	4 x 12 x 25
003.0075	6 x 12 x 25
003.0076	8 x 12 x 25
003.0077	12 x 12 x 25
003.0078	20 x 12 x 25
003.0079	25 x 12 x 25
003.0080	40 x 12 x 25

9.2 Accessories and Special Devices

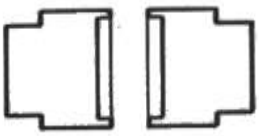
Order No.	Description	Technical Description
oo3.51o6	**slitting equipment**	for slitting and stripping of wideband cables **max. cable width: up to 2o mm** **max. stripping length: up to 25 mm** **max. outer-∅ of the single stranded wire: 2,o mm** (see Application Possibilities of the AM.STRIP.1, 1o.1)
.5o15	**cutting guide** for flat cable	allows the exact cutting of flat cables **max. cable thickness: 3 mm** **max. cable width: 3o mm**
.5o16	**stripping guide** for flat cable (with front plate)	allows the exact stripping of flat cables **max. cable thickness: 3 mm** **max. cable width: 3o mm**
.5o23	**holding plate** with special pipe	for the guidance of round cables while cutting - the inner-∅ of the pipe is adapted to each cable
.o215	**elevated cover**	necessary accessory for the use of the slitting equipment
.5127	**stripping stop dog** (with partial stroke)	allows the adjustment of stripping lengths up to **25o mm** in partial stroke
.5126	**stroke limitation** (∅ 20 mm)	for partial stroke. Additionally, the working stroke of the long cylinder can be adapted to the stripping length, and the working cycle time is shortened.
.5o57	**clamp jaws with Volcano**	for more careful clamping of the insulation
.5o58	**blade head construction I** "cutting and stripping"	allows cutting and stripping of two-core cables **in one step**, adjustable from **3-68 mm** (see *Application Possibilities of the AM.STRIP.1*, 1o.1, cable example 2)
.5o59	**blade head construction II** "cutting and stripping in steps"	the cutting and stripping of two-core cables in steps is released by means of offset installed, one-sided die and cutting blades (see *Application Possibilities of the AM.STRIP.1*, 1o.1, cable example 8)
.5o6o	**blade head construct. III** "stripping in steps"	same as construction II but without cutting blades (see *Application Possibilities of the AM.STRIP.1*, 1o.1, cable example 7)

9.3 Standard blades
(003... for AM.STRIP.1, 004... for AM.STRIP.2)

Flat stripping blades I
003.0037; 004.0037

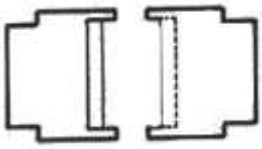


Flat stripping blades II
003.0038; 004.0038



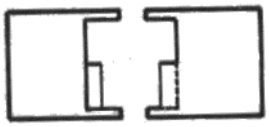
Flat shear blades I
003.0039; 004.0039

Flat shear blades II
003.0040; 004.0040

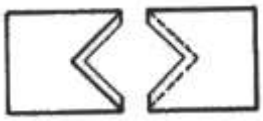


Special Flat stripping blades
003.0086; 004.0096

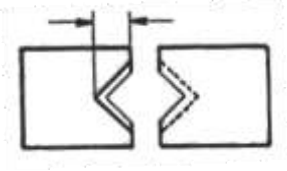
Flat shear blades, half-sided
003.084; 004.0094



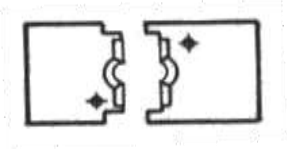
Prismatic blades
003.0041; 004.0041



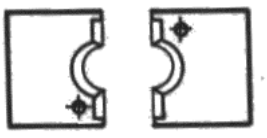
Prismatic blades (Special length)
003.0088; 004.0098



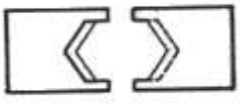
Die blades I (up to 9,9 mm ø)
003.0035; 004.0035



Die blades I (up to 10 mm ø)
003.0036; 004.0036



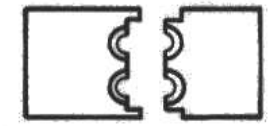
Special die blades
003.0089; 004.0099



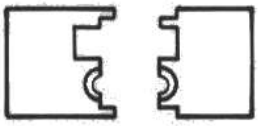
Slitting blades
003.0114

9.4 Special blades

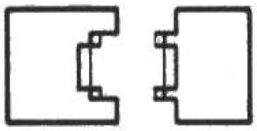
Die blades double
003.0081; 004.0091



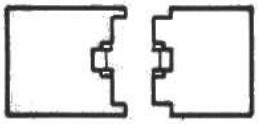
Die blades one-sided
003.0082; 004.0092



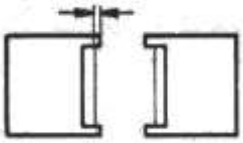
Flat stripping blades, with side cut
003.0100; 004.0113



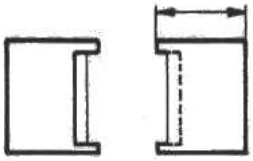
Flat die blades
003.0099; 004.0112



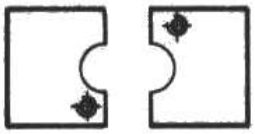
Flat stripping blades offset
003.0085; 004.0095



Flat shear blades spec. length
003.083; 004.0093



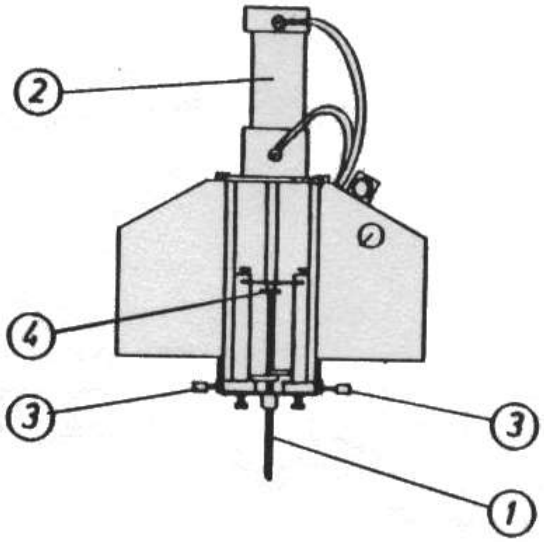
Special centering tools
003.0090; 004.0100



9.5 Possible Structures of the AM.STRIP. - Machines

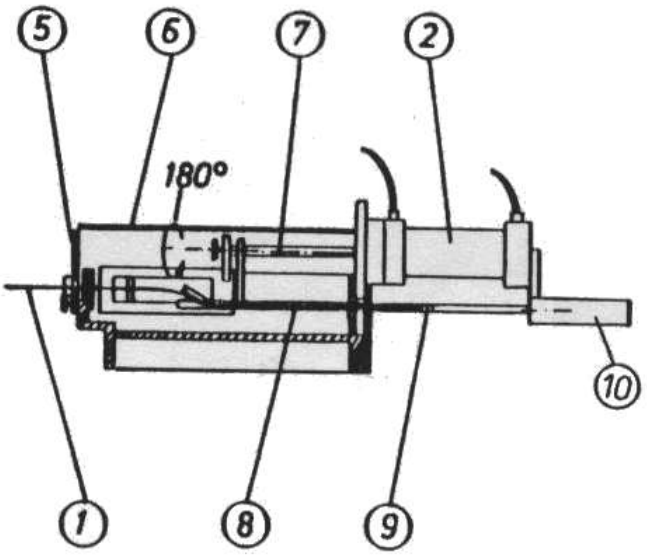
Basic structure
(for all standard stripping operations)

This structure corresponds to the standard delivery equipment of the AM.STRIP. machines



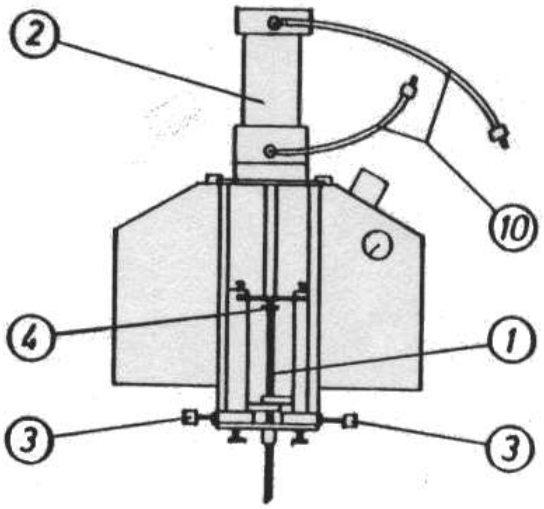
Stripping
(for larger stripping length with partial stroke)

1. remove front plate (Pos. 5) and plexi glass cover
2. pull out long cylinder (Pos. 2) upwards, rotate piston rod with carrier (Pos. 7) 180°
3. put in extended stop dog (Pos. 8; special equipment)
4. put in again long cylinder (air connection are above!)
5. fix cover pipe (Pos. 10) to long cylinder
6. put in elevated plexi glass cover (Pos. 6; special equipment)
7. put in again front plate
8. adjust stop pipe (Pos. 9) to desired length



Cutting A
(standard construction)

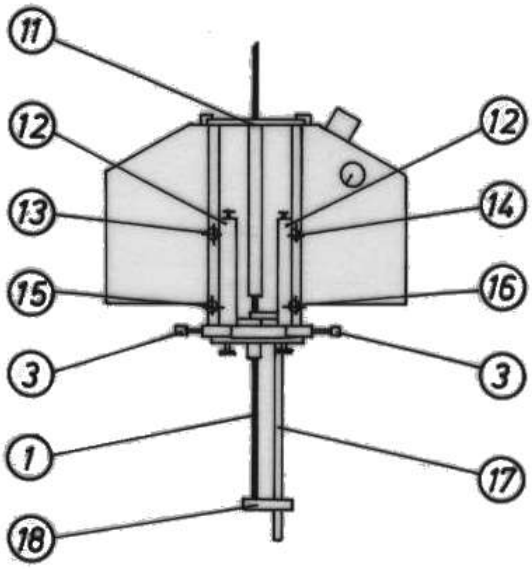
1. release overhead line (Pos. 10)
2. open clamping jaws with adjusting spindle completely (Pos. 3)
3. adjust cable stop dog (Pos. 4) to desired length
4. foot valve only operates cross cylinder



Cutting B
(with stop dog)

1. remove long cylinder
2. put in plate with guide pipe (Pos. 11)
3. fix stop dog (Pos. 17) into frame
4. open clamp jaws with adjusting spindle (Pos. 3) completely
5. clamp blade heads (Pos. 12)

   AM.STRIP.1 2x1 screw (S) Pos. 15 / 16
   AM.STRIP.2 2x2 screw (S) Pos. 13 / 14 / 15 / 16
6. adjust stop pipe (Pos. 18) to desired length
7. foot valve only operates cross cylinder



9.6 Operating Instruction for the SMC Air Combination

1. PRECAUTIONS FOR SAFETY

Precautions shown here are to ensure the product is used correctly and safely, and to prevent hazard and damage inflicting upon people from occurring. These precautions are divided into three categories, "Caution", "Warning", and "Danger" to indicate the degree of possible hazard and damage, and urgency.
As all these are important for safety, never fail to follow them in addition of ISO4414, JIS B8370, and other safety regulations.

⚠ Caution : Possible harmful effects are expected to be on people and possible loss is expected only of objects when wrong operation occurred.

⚠ Warning : Possible loss or serious injury of people is expected when wrong operation occurred.

⚠ Danger : Imminent danger that possible loss or serious injury of people is expected without evacuation.

※1) ISO4414 Pneumatic fluid power–Recomendations for the application of equipment to transmission and control systems.

※2) JIS B 8370 Common regulations for pneumatic systems.

⚠ WARNING

①Suitability of pneumatic equipment should be determined by a designer of the pneumatic system or a person who prescribes its specifications.

Since the product shown here is used in various operating conditions, its suitability to a system should be determined by the pneumatic system designer or the person prescribes its specifications based on necessary analysis and tests. The person who determined the suitability of the system is responsible for the performance at a certain point of time and safety assurance of this system.
A system should be constructed by referring to the latest product information and catalogues, discussing all the contents of specifications, and considering possibilities of equipment failure.

②Equipment should be handled by those who have sufficient knowledge and experience

Compressed air fluid could be hazardous if it is handled incorrectly. Assembly, operation and maintenance of machinery and equipment for which pneumatic apparatuses are used should be performed by those who have sufficient knowledge and experience.

③Never handle the machinery or equipment, or never take out the apparatus until safety is confirmed

a. Check and maintenance of machinery or equipment should be performed after it is confirmed that dropping or uncontrollable running prevention measures are taken for the equipment on which the product is mounted.
b. Apparatuses should be taken out after it is confirmed equipment corresponding to air supply, that is an energy source, should be turned off; and compressed air in the system should be exhausted.
c. Re-starting of machinery or equipment should be done with ample care after it is confirmed that prevention measure s for sudden movement are taken.

④When the product is used in the following conditions or environment, considerations for safety measures should be given along with consultation to our company

a. Outdoor usage, or usage in conditions or environment outside of the specifications indicated.
b. Usage for nuclear power, railroad, air navigation, vehicle, medical equipment, appliances contactin food and beverage, entertainment apparatuses, emergency shutdown circuits, clutch/break circuits for pressing, and safety devices.
c. Usage for applications which especially require safety because considerable effects to people and properties are expected.

Design

⚠ Warning

○Air combination

① If any leakage isn't permitted due to ambient environment or fluid other than air is used, contact SMC.

② External parts including the bonnet, bowl, the sight dome are made of resin. Organic solvents including, thinner, acetone, alcohol, ethylene chloride, chemicals including sulphuric acid, nitrate and hydrochloric acid, cutting oil, synthetic oil, estel-base compressor oil, alkali, kerosene, gasoline, lock material of screw are harmful. Don't use the regulator where containing those.

③ Protect from ultra violet ray and radiation heat by shield.

④ If output over setting pressure may cause damage and operating failure of the machine and equipment installed secondary side, be sure to place safety device.

⚠ Caution

○Regulator and Filter-regulator

① Air consumption from release port is 0.1L/min(ANR) or less.

Selection

⚠ Warning

○Air combination

① Mineral grease used for internal sliding surface and packing may leak to the outlet. Please contact SMC if this is a problem.

○Regulator and Filter-regulator

① Residual pressure(outlet pressure) is not released even if releasing inlet pressure. Select the regulator with counter flow function. Without the function, residual pressure may not be eliminated.

② Long absence of operation or operation with outlet circuit sealed or balance circuit may cause pressure fluctuation in outlet set pressure. Please consult SMC if this is a problem.

③ Set pressure of outlet pressure shall be 85% or less of inlet pressure. Pressure over 85% makes operation susceptible to flow and inlet pressure which lead to cause unstable operation.

④ Maximum set pressure range in the spec. has margin. Pressure set may be higher than the maximum value.

⑤ If regulator is used with circuit which require high exhaust sensitivity or set precision, please consult SMC.

○Lubricator

① The use at high frequency such as the use in press machine may damage internal components and cause operating failure of the equipments installed to secondary side.

② Small air consumption may prevent the oil from dropping. Decide the size which can flow the air necessary to drop required amount of oil.

③ Do not supply the air from secondary side (reverse air flow). Otherwise, internal components may be damaged.

④ If piping is branched at primary side, the oil may flow back. Avoid the reverse flow by install check valve (AKM series) to primary side.

Installation・Adjustment

⚠ Warning

○Air combination

① Connect the air combination ensuring the direction of "IN" and "OUT" for air direction or an arrow. Wrong connection lead to cause malfunction.

② Install vertically so that outlet of drain would turned downward. Use with the outlet of drain turned lateral or upward causes malfunction.

③ Make a space to provide easy access at the bottom when replacing element or draining. For dimensions of the space, refer to Outside dimensions.

○Regulator and Filter-regulator

① Operate the pressure adjusting handle manually. Tools may break the handle.

② Adjust the pressure ensuring inlet pressure and outlet pressure. Excessive rotation may cause internal parts.

③ Confirm set pressure is as requied periodically because secondary pressure may change for extended operation.

○Lurbricator

① Adjust oil needle by manual in AL20～60. Rotate clockwise for increase and anticlockwise for decrease. Adjustment with a tool may damage the needle. Twice rotation from the condition closed fully makes the needle opened fully. Do not give any rotation to the needle after opening fully.

⚠ Caution

○Air combination

① Don't drop nor apply impact during transportation or installation. gauge. These lead to cause precision failure of pressure.

② Don't install where highly humid or temperature is high. Or pressure gauge may malfunction.

○Regulator and Filter-regulator

① Adjust pressure incrementally. Pressure may become lower than set pressure if adjusted by decreasing the value. Rotate the handle clockwise to raise the set pressure. Counterclockwise, reduce the pressure.

② Outlet pressure may rise if eliminate the inlet pressure after pressure setting and supply pressure again. The pressure becomes close to the set pressure after air is consumed in outlet.

③ For the regulator with the pressure gauge, don't apply pressure over the maximum scale of the pressure gauge in order to protect the gauge.

Piping

⚠ Warning

○Air combination

① Flash or clean piping before piping to eliminate flaw, cutting oil, solid foreign material. Remaining of these lead to cause malfunction.

② When screw in piping or fitting, avoid entering of chips and sealing materials from piping screws into the inside of equipment. Or malfunction is led to occur. When use sealing tapes, leave 2 threads of a screw and starts taping.

③ Hold the female screw side and screw in piping with recommended tightening torque. Insufficient tightening torque lead to cause loose piping or sealing failure. Excessive torque may lead to cause screw breakage. Tightening without holding female screw side applies excessive force to the piping bracket which lead to cause breakage.

Recommended tightening torque Unit:N·m

Screw	M5	1/8	1/4	3/8	1/2	3/4	1
Torque	*1	7~9	12~14	22~24	28~30	28~30	36~38

*1:After tightening fitting, tighten approx. 1/6 more by using tool.

④ Don't apply any torsional moment, or bending moment except the weight of this product itself. External pipings need its support separately. Hard piping like steel tube is susceptible to excessive moment load or vibration. Insert the flexible tube to cancel the influence.

⚠ Caution

○Lubricator

① Avoid rising piping and branch of the piping at secondary pressure side. Otherwise, lubricating failure may be caused.

Air source

⚠ Warning

○Air combination

① Use clean air. Compressed air containing chemicals, organic solvent, synthetic oil or corrosive gas may lead to cause breakage of parts or malfunction.

② Air containing much drain lead to cause malfunction. Install the air drier or the after-cooler before the regulator.

Maintenance

⚠ Warning

○Air combination

① Maintenance or check should be done by following the procedure in the operation manual. Incorrect handling of the product may cause breakage or malfunction of the equipment or device.

② Perform periodical check to find crack, flaw or other deterioration on resin bowl. If any of them is seen, as malfunction is caused, replace with new bowl or metal bowl.

○Air filter, Lubricator, Filter-regulator and Mist separator

① Check the dirt of resin bowl periodically. If any dirt is seen, replace with new bowl. And if removing off the dirt by washing instead of replacement, never use washing material other than neutral detergent. Otherwise, the bowl is damaged.

② Open and close drain cock manually. Open and close by a too may damage the drain cock

③ Replace the element two years after starting to use it or before pressure drop of 0.1MPa or more is seen. Continuity of the use after the replacement period may damage the element.

⚠ Caution

○Regulator and Filter-regulator

① For First-aid for setting failure or leakage, check the internal valve sliding surface or the valve seat before giving first-aid treatment.

○Air filter, Filter-regulator and Mist separator

② Drain the bowl by opening drain cock before the drain level in the bowl reaches baffle plat

9.7 Product Information Fluid Grease

siebert

Gear Grease EP 4222

Gear Grease EP 4222 is a nature coloured sodium saponified lubricating grease based on mineral oil.

NLGI-Grade

0

Application

Gear Grease EP 4222 is suitable for lubrication of industrial gears, gears of motorcycles and other stationary motor gear units.

For the application of **Gear Grease EP 4222** the size and power as well as the sealing of the gear have to be take into account.

Properties

- corrosion resistant
- high pressure load capacity
- good adhesiveness

Technical Data

operating temperature for long-term lubrication	-30 to +100°C
drop point ASTM D 2265	approx. 150°C
worked penetration ASTM D 217	355 to 385 1/10 mm
water resistance DIN 51 807 T1	3 – 90
SKF Emcor Test IP 220/85	corrosion degree 0/0
base oil viscosity at 40°C ASTM D 445	approx. 140 mm²/s
designation DIN 51 502 ISO 6743-9	GP O H-30 ISO-L-XCABB 0

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

Edition

08/01 sm

Siebert GmbH
Erkelenzer Straße 36, 41179 Mönchengladbach
Tel. +49 21 61 58 69-0, Fax +49 21 61 58 69-93
www.siebertgmbh.com, eMail vertrieb@siebertgmbh.com

10 Enclosures

10.1 Drawings

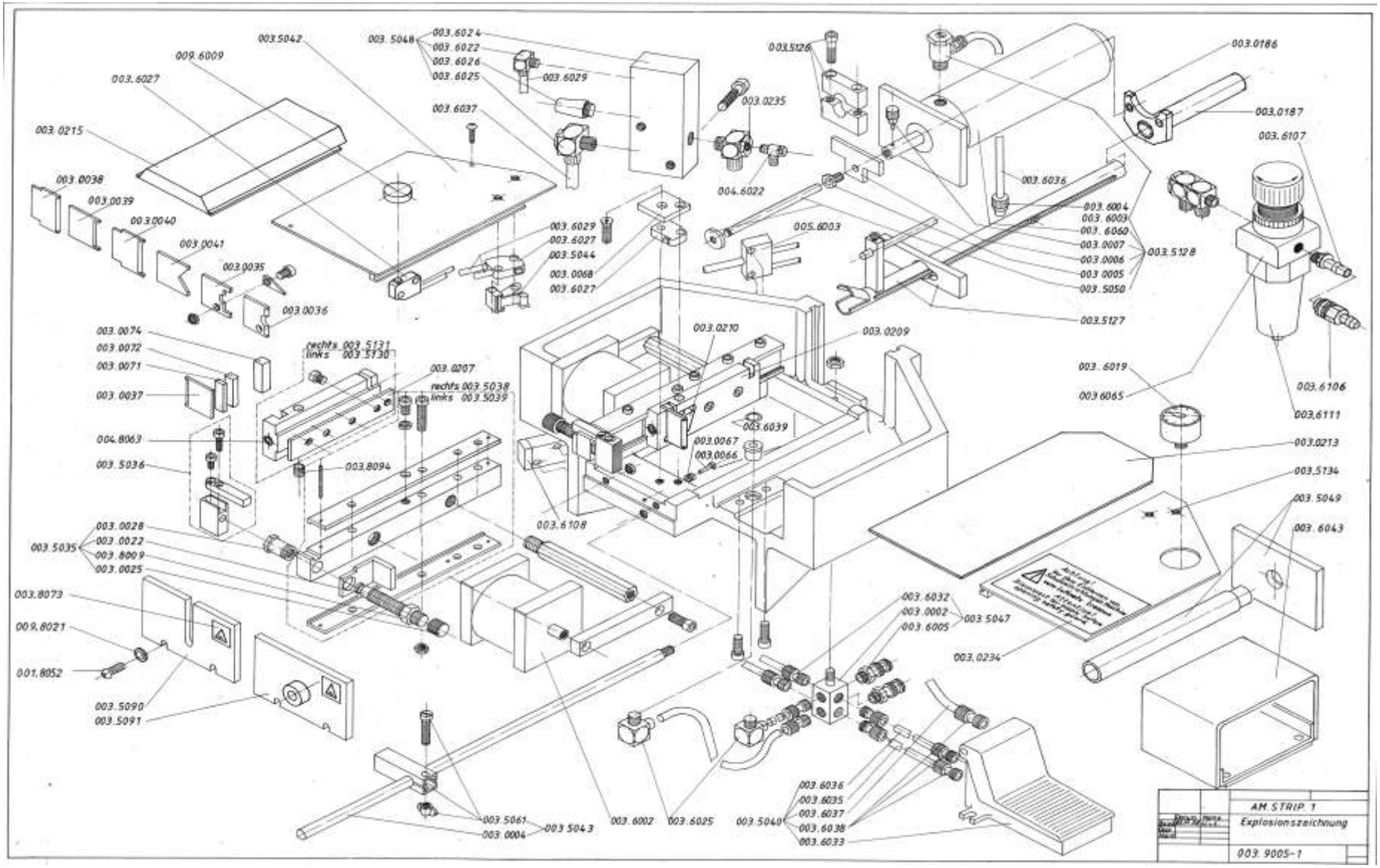
Explosion sketch AM.STRIP.1	oo3.9oo5-1
Application Possibilities of the AM.STRIP.1	
Pneumatic Plan	
Preparation of the Working Bench	

10.2 Other Documents

Copy Certificate of Conformity

be-ri
FEINTECHNIK
RITTMEYER

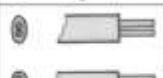
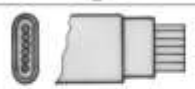
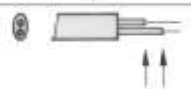
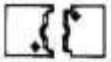
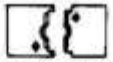
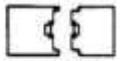
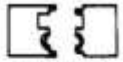
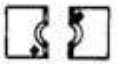
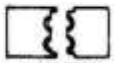
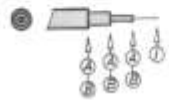
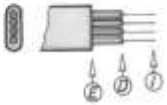
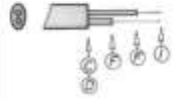
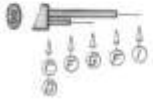
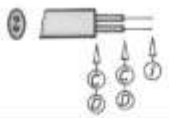
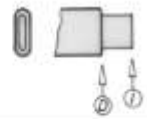
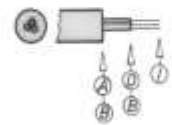
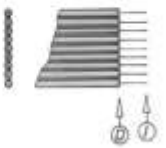
ARTOS
ENGINEERING FRANCE



be-ri
FEINTECHNIK RITTMEYER

ARTOS
ENGINEERING FRANCE

Possible Applications of the AM.STRIP.1 - AM.STRIP.2 - AM.STRIP.2 V

	Stripping / Removing						Cutting			Stripping + Slitting
form - type	A	B	C	D	E	F	G	H	I	J
cable	 stranded wires	 multicore jacket cables	 twin cables	 flat cables	 flat cables	 stepped	 stepped	 round cables	 flat cables	 flat cables
Quantity of the blade pairs	1-pair	1-pair	1-pair	1-pair	2-pair	2-pair	1-pair	1-pair	1-pair	1-pair + slitting blades
blades	die blades I 1. 003.2005 – 003.2099 2. 004.2010 – 004.2129  1= from ∅ 0,5 – ∅ 9,9 mm 2= from ∅ 1 - ∅ 12,9 mm	die blades I  1= from ∅ 0,5 – ∅ 9,9 mm 2= from ∅ 1 - ∅ 12,9 mm	flat die blades  1. 003.0099 2. 004.0112	flat stripping blades I 1. 003.0037 2. 004.037  1= max. 20 mm wide 2= max. 35 mm wide	flat stripping blades offset 1. 003.0085 2. 004.0095  1= max. 20 mm wide 2= max. 35 mm wide	die blades, one side  1. 003.0082 2. 004.0092	flat shear blades, one side  1. 003.0084 2. 004.0092	prismatic blades  1. 003.0041 2. 004.0041	flat shear blades I 1. 003.0039 2. 004.0039  1= max. 22 mm wide 2= max. 37 mm wide	flat stripping blade I 1. 003.0037 2. 004.0037  1= max. 20 mm wide 2= max. 35 mm wide
	die blades II 1. 003.2100 – 003.2150 2. 004.2130 – 004.2250  1= from ∅ 10 - ∅ 15 mm 2= from ∅ 13 - ∅ 25 mm	die blades II  1= from ∅ 10 - ∅ 15 mm 2=from ∅ 13 - ∅ 25 mm	die blades, double  1. 003.0081 2. 004.0091	flat stripping blades II 1. 003.0038 2. 004.0038  1= max. 30 mm wide 2= max. 45 mm wide	**Example 1, 2 u. 3** **Round cable up to max. 3 core (with part stripping)** 1. 	**Example 4, 5 u. 6** **Flat cables** 4. 	**Example 7** **Stripping – in steps** 7. 	**Example 8** **Cutting – in steps** 8. 	fat shear blades II 1. 003.0040 2. 004.0040  1= max. 32 mm wide 2= max. 47 mm wide	slitting blade  1. + 2. 003.0114
	prismatic blades 1. 003.0041 2. 004.0041  only up to ca. 8 mm²			flat stripping blade with side cut  1. 003.0100 2. 004.0113	2. 	5. 				
				spec. flat stripping blades  1. 003.0066 2. 004.0096	3. 	6. 				

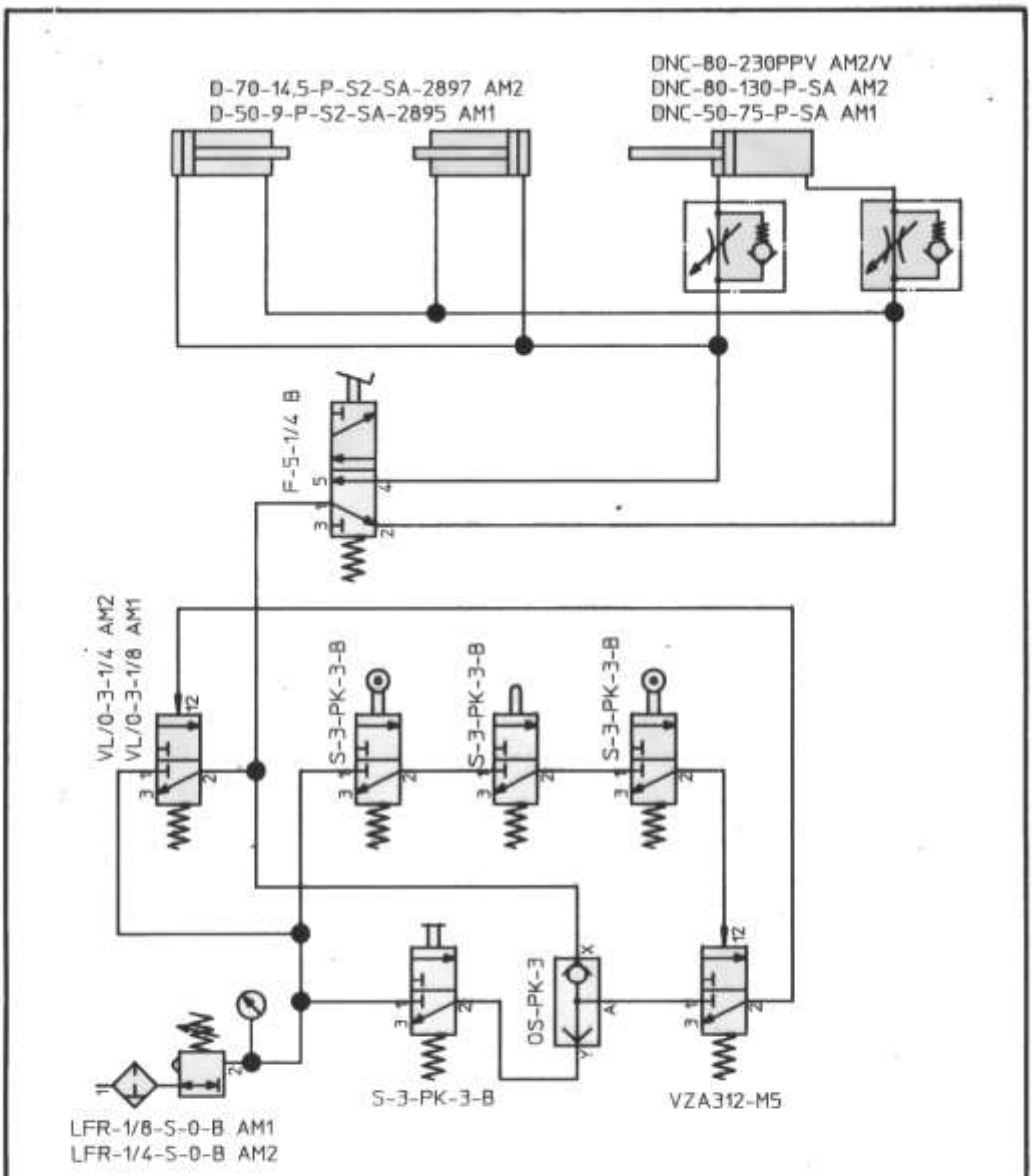
Explanation of the sings:

= for AM.STRIP.1

= for AM.STRIP.2 + 2V

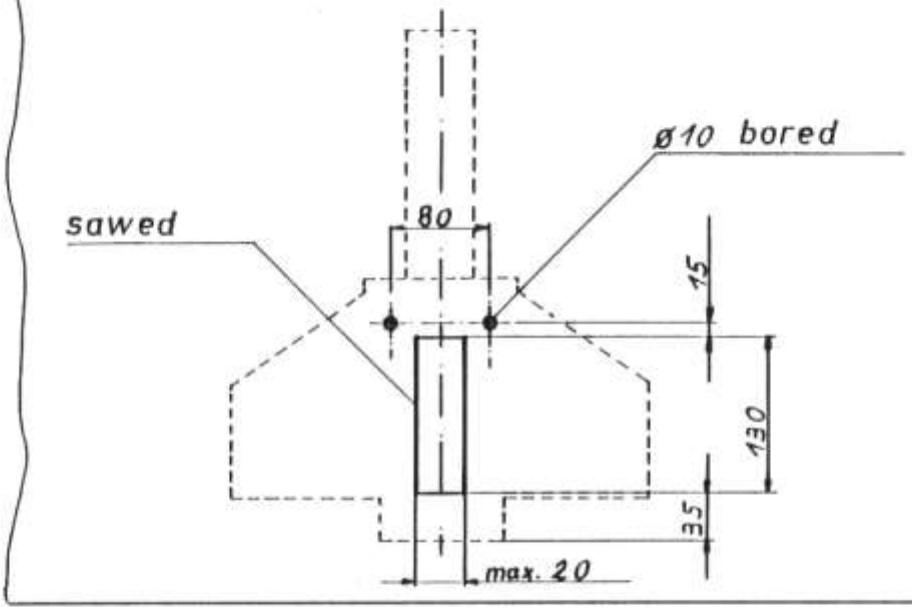
=cutting point of the blades, which are treated in this column

= cutting point with mentioning of the form type and so with the possible blades (here: column A and B)



Material	Stückzahl							
Gerätte-Nr. 003-004		Buch-stabe	kommt vor	Änderung	Vorgang	Tag	Name	Norm
Diese Maße werden bei Abnahme besonders geprüft					Filtepause von			
2002	Gez.	Gepr.	Norm	be-ri FEINTECHNIK R.RITTMEYER GmbH	Benennung: pneum. Schaltplan AM1-AM2-AM2/V			
Tag 28.05								
Name Meckmann								
Maßstab	Maße ohne Toleranzangabe nach ISO 2768 - mK			Zeichnung-Nr. 003.9035				
Blätter A0	A1	A2	A3 1x	A4 Blatt				

working bench



				Maßstab	1:5
				AM. STRIP 1	
			Datum	Name	
			Bearb	3.1.95	Brinkjans
			Gepr		
			Norm		
				preparation working bench	
					Blatt
Zust	Änderung	Datum	Name		Bl

ARTOS
ENGINEERING FRANCE

Distribué en France par :

14 Route d'Auray – ZA de Talhouët
56330 PLUVIGNER
Tel : +33966 90 42 70
Email : info@artosfrance.com
Siret : 34273353200044

CE

EG-KONFORMITÄTSERKLÄRUNG
im Sinne der EG – Maschinenrichtlinie 2006 / 42 / EG Anhang II A

Hiermit erklären wir, dass die nachfolgend bezeichnete Maschine aufgrund ihrer Konzipierung und Bauart sowie in der von uns in Verkehr gebrachten Ausführung den einschlägigen grundlegenden Sicherheits- und Gesundheitsanforderungen der EG-Maschinenrichtlinie entspricht. Bei einer nicht mit uns abgestimmten Veränderung der Maschine verliert diese Erklärung ihre Gültigkeit.

EC-CERTIFICATE OF CONFORMITY
in accordance with the EC Machinery Directive 2006 / 42 / EG appendix II A

We hereby declare that on the basis of its conception and design and in the version of the relevant and fundamental safety and health regulations, put into circulation by us, the machine mentioned in the following meets the currently valid EC Machinery Directive. This declaration will immediately cease its legal force if the machine is altered in any way without our permittance.

Hersteller Producer	FEINTECHNIK R.Rittmeyer GmbH	
Bezeichnung der Maschine Machine Designation	AM.STRIP.1 / AM.STRIP.1 / S	
Maschinentyp Machine Type	Pneumatische Abisoliermaschine / Pneumatic stripping machine	
Einschlägige EG-Richtlinien Fundamental EC-Directives	EG-Maschinenrichtlinie 2006 / 42 / EG Anhang II A	EC Machinery Directive 2006 / 42 / EG Appendix II A
Harmonisierte Normen Hamonized Standards	-	-
Nationale Normen National Standards	DIN 45 635	DIN 45 635

Maschinennummer Machine No. _____

Datum Date _____

Unterschrift Signatory Manufacturer _____

Renate Rittmeyer-Müller Walter Rittmeyer

Angaben zum Unterzeichner Position of the Signatory: Geschäftsführer / Managing Director

be-ri

FEINTECHNIK
R.Rittmeyer GmbH
Höltenweg 103
48 155 Münster
Germany

Tel. **+49 . (0)251.96115–0**
Fax **+49 . (0)251.624 525**
Email **info@rittmeyer-beri.de**
Web **rittmeyer-beri.de**