

SHIELDED CABLES AND WIRES  
PREPARATION OF SHIELDED CABLE FOR TERMINATION

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1. GENERAL

1.1 Scope of Section

1.11 This section covers the general requirements and methods for terminating and removing the shields of coaxial and twin-conductor office cables.

1.12 Each figure of this section illustrates only conditions to which reference is made in the text and is not to be considered as covering the requirements for other conditions that may be involved.

1.13 The requirements covered in this section shall be followed except as modified by applicable specifications and drawings.

1.2 Arrangement of Tools, Precautions, and Verification

1.21 Refer to Section 700 of Handbook 9 for information pertaining to these items.

2. INSTALLING EQUIPMENT

2.1 In addition to the tools and supplies ordinarily required for butting and stripping switchboard type cables and for connecting operations the following are required for the operations covered by this section.

2.11 Tools

- R-1682 Scissors, Electrician's
- R-3186 Set, Stripping Coaxial Cable
- R-2862 Stripper, 754 Cable
- R-2154 Stripper, Cable Shielded
- R-2165 Stripper, Power Wire
- R-3457 Stripper, Cable and Wire, Shielded
- R-3088 Tool, Wire Skinning
- R-2884 Stripper, Power Wire

2.12 Supplies

- R-3365 Paints, Cement, Clear Protective
- RM-64473 Paints, Lacquer, Cellulose Acetate
- R-3359 Tape, Gray Plastic, 1/2"
- R-3428 Tape, Gray Plastic, 3/4"
- R-3676 Sleeves, Plastic Insulation

3. COMMON REQUIREMENTS AND METHODS

3.1 Terminating Information

3.11 Prepare all cables for termination in accordance with the detailed information (dimensions, etc.) indicated on the terminating drawings furnished the job as referred to in Section 700 of Handbook 9.

**CAUTION:** When cables are to be terminated at coaxial type connectors, jacks, plugs and terminals, strictly adhere to the shiner length dimensions indicated on the terminating drawings for the inner cable conductor(s) in order to avoid loose or kinked inner conductor(s).

3.111 When the terminating drawings indicate that the O.D. of a cable shall be built up to the I.D. of a jack, etc. using a 1A or 2A cord cushion or rubber bushing, place the cord cushion or bushing over the cable before removing the outer cable sheathing. To facilitate placing of bushing on the cable, it will be permissible to split the bushing with a pair of diagonal cutters. Rubber bushings are used on miniature coaxial cables.

3.112 When the terminating drawings indicate that shield connections shall be made by means of a solderless crimped connection, place the outer sleeve or other outer part over the cable before removing the shield.

3.2 Skinner Lengths for Cable Conductors

3.21 The required skinner lengths for the inner conductor(s) of coaxial or twin-conductor office cables are either:

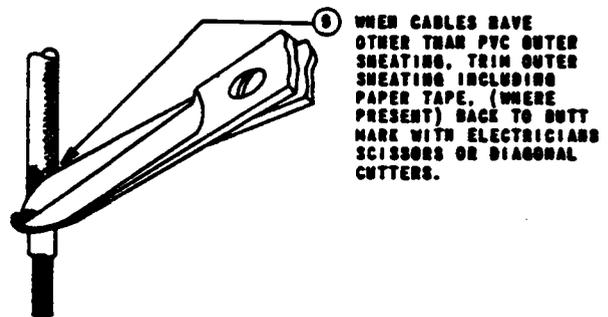
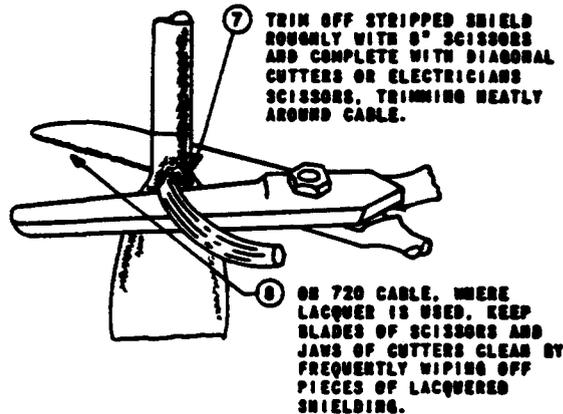
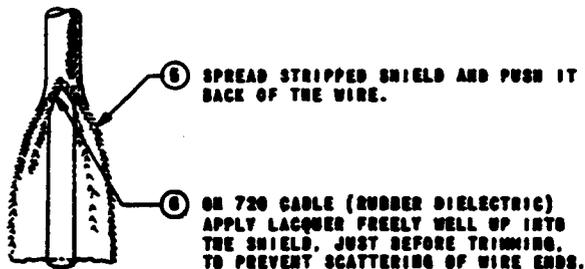
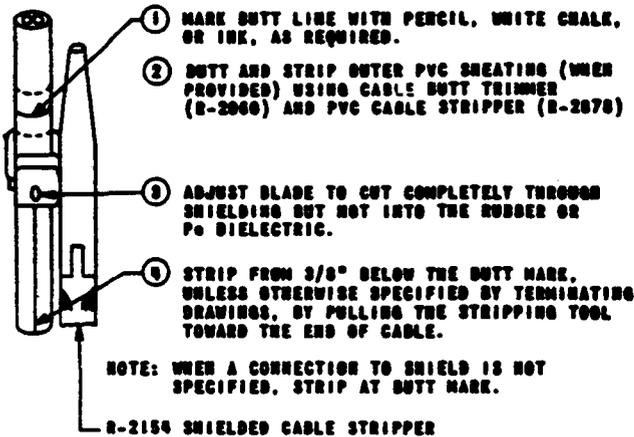
- a) Indicated on the terminating drawings referred to in Section 700 of Handbook 9.
- b) Indicated on the associated bay cabling plan.
- c) Controlled by the mounting location of the shield ground connector.
- d) When skinner lengths are not indicated on the bay cabling plan or terminating drawings or the shield is not terminated at a shield connector, the skinner lengths are to be 1 1/2 inches.

3.3 Cuts in Dielectric

3.31 Exercise care when preparing cable ends for termination in order to avoid any circumferential groove in the cable dielectric while cutting the shielding. It is desirable that no damage be done to the inner dielectric, but a very slight scoring of the dielectric is permissible. However, for coaxial cable, it should not exceed 1/64 inch in depth, gauged by eye.

NOTE: No cut in dielectric is permitted when using miniature coaxial cable KS-19224-L1.

CAUTION: USE CARE WHEN STRIPPING AND TRIMMING THE SHIELD OF CABLE TO AVOID PUNCTURING THE FINGERS OR THE ENDS OF THE SMALL SHIELD WIRES.



CAUTION: NO LACQUER IS TO BE USED ON 75 OHM CABLE, OR OTHER CABLE WITH Po DIELECTRIC BECAUSE OF POSSIBLE DAMAGE TO Po.

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FIG. 1 STRIPPING AND BUTTING TWIN-CONDUCTOR OFFICE CABLES (PARS. 4.14, 4.21, 4.22, 4.412)

3.4 Butting and Stripping Cables

➔ 3.41 Butt and Strip the outer PVC sheathing of any shielded cable (except 750 type, 761A, KS-19224-L1 and L2, KS-19414-L1 and KS-20906-L1) in the same manner as PVC covered switchboard cables.

3.411 The above exceptions are covered in Paragraph 4.9.

3.42 Before Stripping any shielded cable, cut off any excess length of cable more than 3 inches longer than the required skinner length, using cable shears or 8" scissors.

3.5 Finishing Cable Butts When Shield Connections are Not Specified

3.51 When wiring diagram indicates that the shield is not to be connected to a terminal, another shield or coaxial type apparatus, finish butts as follows:

R-3676 Plastic Sleeves for Insulating Ungrounded Ends of Shielded Cables and Wires

<u>Cable or Wire Code</u>	<u>Detail No.</u>	<u>Color</u>
750-Type	1	Orange
760	3	Yellow

3.511 750 and 760 Cables, cut the shield and outer jacket flush at butt point and slide sleeve over butt allowing it to extend approximately 3/8" on each side.

➔ 3.512 KS-19414-L1, KS-20906-L1, 761A, 762A Cables, and all other shielded cables and wires, cut the shield and outer jacket flush at butt point and cover the butt with a one half lapped layer on R-3359 tape extending approximately 3/8" on each side of butt.

4. SPECIFIC REQUIREMENTS AND METHODS

4.1 720 Type Cable

4.11 Treat 723 Cable (two 720 cables enclosed in a cotton braid) in the same manner as two individual 720 cables.

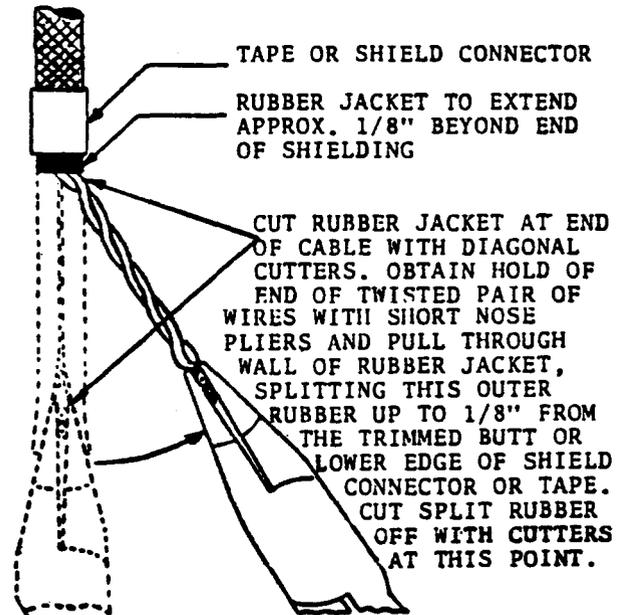


FIG. 2 REMOVING RUBBER JACKET - 720 CABLE (PAR. 4.13)

4.111 Butt and strip the outer cotton jacket in the same manner as fabric covered switchboard cables using the cable stripper (R-62267).

4.112 When the outer cotton jacket, the two inner PVC jackets and the shields are all butted at the same point, tape the butt as a whole with R-3359 tape instead of wrapping the acetate fiber tape around the outer cotton jacket.

4.12 When 720 or 723 Cables Terminate at terminal strips with fanning strips, butt these cables at close as practicable to the back of the associated hole in the fanning strip.

4.13 Remove the shield and rubber jacket as shown in Figure 1 and Figure 2, respectively.

4.14 Apply clear protective cement (R-3365 to all exposed rubber covered conductors before skinning (including unequipped leads). On shop formed cables the cement will be applied by the shop. The coating of cement prevents deterioration of the rubber insulation.

**CAUTION:** The R-3365 cement is flammable. Keep tubes covered when not in use and away from an open flame.

4.141 The R-3365 cement has a high viscosity. Therefore, in order to prevent the cement from dripping onto equipment or clothing always follow the following rules when using this cement:

- (a) When removing the cap or after the cap has been removed, hold the tube in a vertical position since the cement will drip out if the tube is held or placed in a horizontal position.
- (b) Always squeeze the tube slowly with increasing pressure since the cement will gush out if the tube is squeezed suddenly.

4.142 Untwist the paired wires. Insert each wire into the neck of the tube and slowly push the wire down into the tube until the neck of the tube touches the rubber jacket.

4.143 Withdraw the wire slowly from the tube to avoid excessive dripping of the cement and also to insure that the insulation will have a uniform coating of cement. Hold the wire above the tube for approximately one minute and then wipe off any excess drop of cement that may form at the end of the wire.

4.144 Check each wire after the cement has dried (cement shrinks when dried) and if the insulation is not completely covered with cement, then give the wire another application of cement. The drying time for this cement is approximately 15 to 30 minutes.

4.145 As the cement in the tube is used, slowly roll up the end of the tube to a point where only sufficient length is left to accommodate the skinners, then slowly press the tube along each edge until most of the cement is utilized.

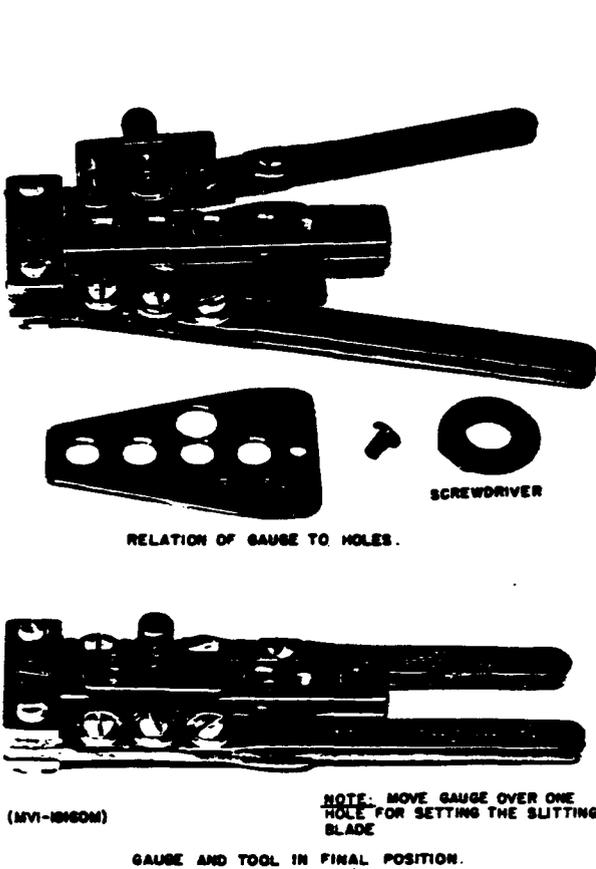


FIG. 3 ADJUSTING BLADES ON COAXIAL CABLE STRIPPER (PARS. 4.21, 4.213, 4.511)

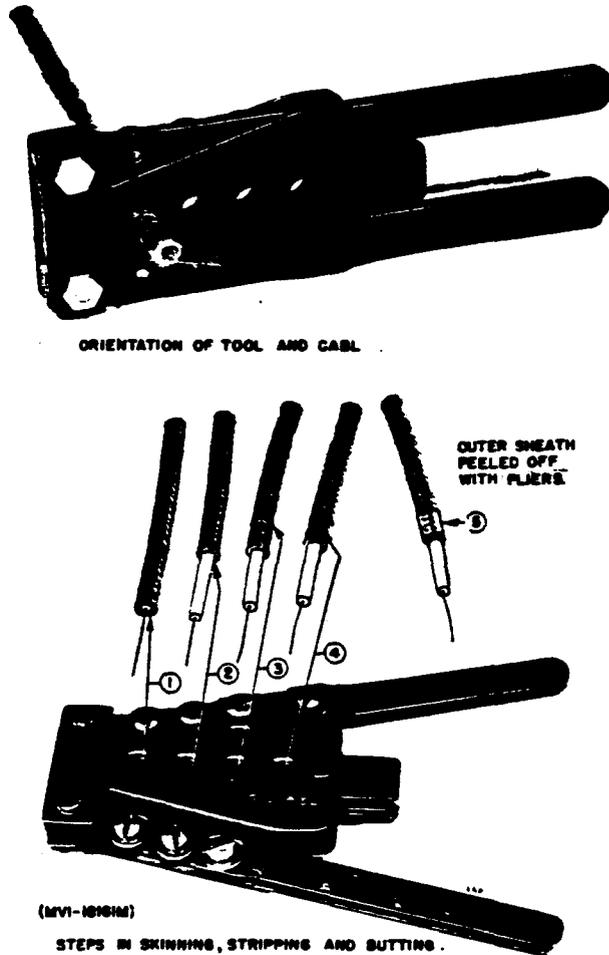


FIG. 4 USE OF COAXIAL CABLE STRIPPER (PARS. 4.21, 4.214, 4.511)

\* Ref. to Thumb Nail to be removed.

4.15 Skin the inner conductors, using either the R-3186 or R-2165.

4.2 724, 726, 727A, 728A, 730A, 731A, KS19906, L1 and SDC-75-2S (RG-59/U) Cables

**NOTE:** Since all these cables except 726 have an untinned central conductor (plain copper), defer skinning the central conductor until ready to connect in order to avoid corrosion and consequent difficulty in tinning the wire when soldering.

4.21 Strip and butt 724, 726, 727A, 728A, 730A, 731A, KS19906, L1 and SDC-75-2S (RG-59/U) cables using the coaxial cable stripping set (R-3186). See Figures 3, 4 and 4A.

4.211 The R-3186 stripper was designed primarily for 724 type cable. Included in the set are collet plates and gauges for 724, SDC-75-2S (RG-59/U) and 730 type cables. The 724 collet plate and gauge may also be used for 726, 727 and 728 type cables and the 730 collet plate and gauge may also be used for 731 type cable.

4.212 To strip the KS19906-L1 cable use the KS19906-L1 Collet Plate and Gauge with the Coaxial Cable Stripper (R-3186). (Refer to Par. 4.8.)

4.213 The blades are set for the proper cutting depth, as follows: (Refer to Figure 3)

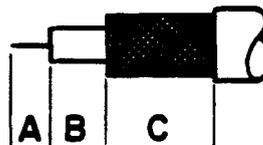
- 1) Remove collet plate.
- 2) Loosen blade screws so they are just friction tight.
- 3) Place gauge in open tool.
- 4) Close tool tightly and push blades in against gauge.
- 5) Holding tool tightly closed, tighten the screws.
- 6) Remove gauge and replace plate on tool.

4.214 In using the stripper (refer to Figure 4), it should be held tightly closed while rotating it at least 180°, in steps 1 to 3, to assure a complete cut around the cable. In Step 2 particularly, it is important that the tool be oriented as shown, since this places the stripping pressure against the beveled edge of the blade. This, together with slight easing of closing pressure on the tool when stripping, will avoid scraping the dielectric.

4.215 The 730 Stop Assembly (Figure 4A) is designed so that the preparation of cable ends may be done more accurately and with more uniformity. Assemble and adjust Stop Assembly as follows:

- (a) Assemble the Stop Assembly per Figure 4A.
- (b) Remove the guard plate screw from the R-3186 Coaxial Cable Stripper. This screw is very short so care should be taken to see that it doesn't get lost.
- (c) Screw the Stop Assembly into the hole usually occupied by the guard plate screw. Align the Stop Screws with the holes in the guard plate and tighten Post Screw.
- (d) To set Stop Screw, measure from the top surface of the Bar Assembly to the bottom of the Screw Stop head and tighten lock nuts. (Figure 4A.) Each preparation dimension must be computed as though measuring from the end of the cable.

**EXAMPLE:**



A	B	C
3/16	1/8	3/8

COMPUTED A DIMENSION = 1/4  
 $(A + 1/16^* = 1/4)$

COMPUTED B DIMENSION = 3/8  
 $(B + A + 1/16^* = 3/8)$

COMPUTED C DIMENSION = 3/4  
 $(C + B + A + 1/16^* = 3/4)$

\* THIS DIMENSION COMPENSATES FOR THE THICKNESS OF THE GUARD PLATE

(MVI-1665)

(e) Insert a piece of scrap cable, if available, into the stripper until cable hits the Screw Stop and execute stripping action. Check dimensions and reset Screw Stop if necessary.

(f) To clear stripper of debris, grasp Bar Assembly as close to Post Assembly as possible, pull out and swing assembly to the right or left. Shake out debris and return assembly to its working position. If cable jacket or dielectric will not fall out freely use a spudger or similar object to clear holes.

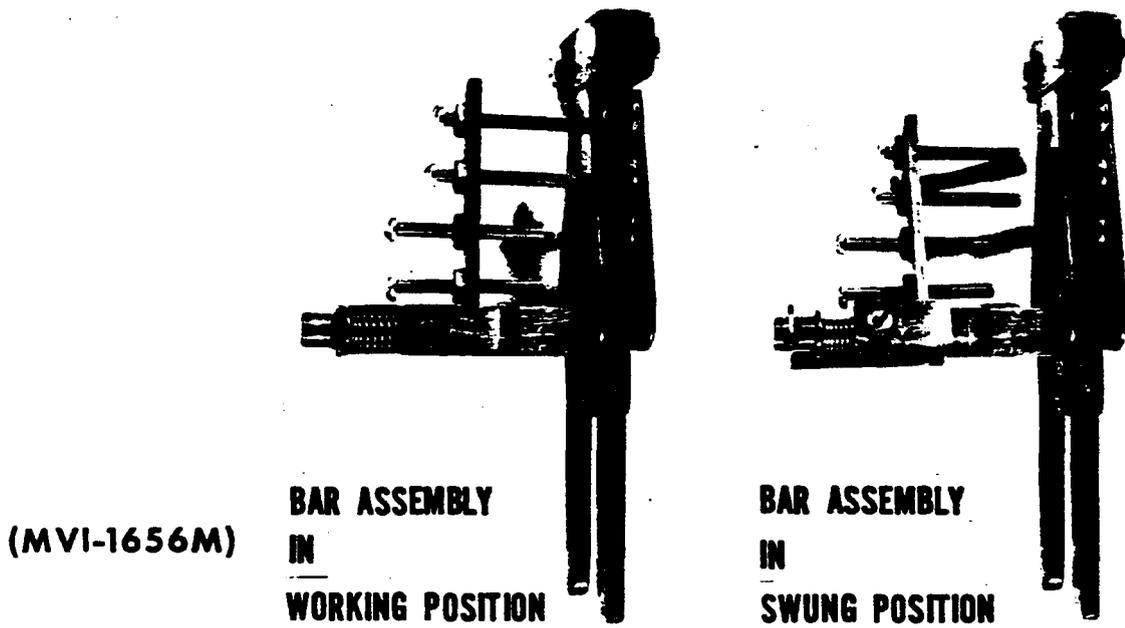
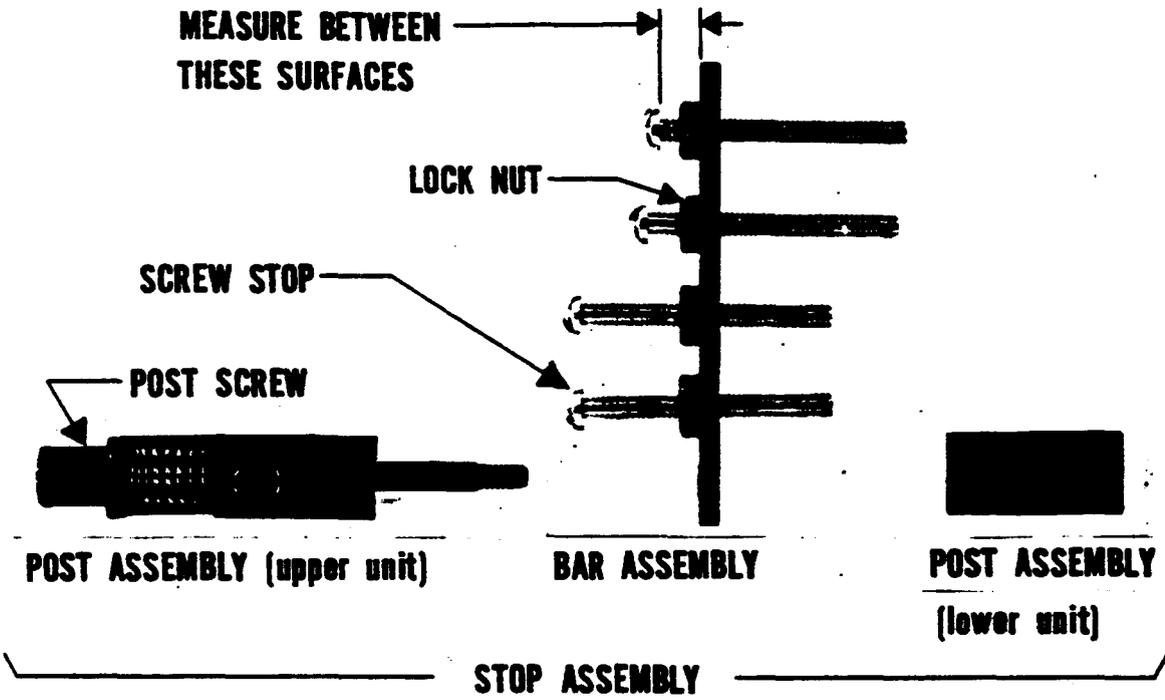
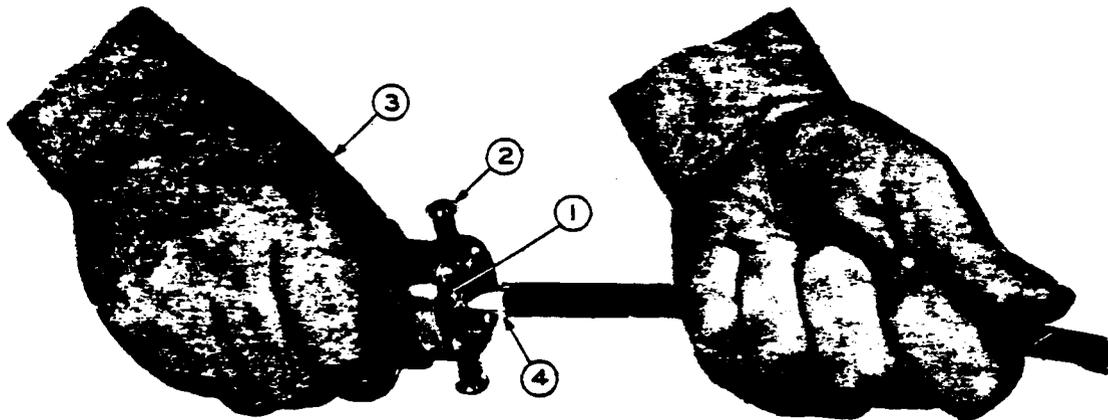


FIG. 4A STOP ASSEMBLY ATTACHED TO R-3186 COAXIAL CABLE STRIPPER (PAR. 4.215)



1. PLACE ARROW OPPOSITE CENTER OF BLUE CONDUCTOR.
2. PRESS THE TWO BLADES FULL DEPTH INTO THE POLYETHYLENE JACKET.
3. PULL TOOL WITH A STRONG FIRM MOTION TOWARD THE END OF THE CABLE.
4. TRIM END OF JACKET WITH DIAGONAL CUTTERS. (MVI-13362M)

FIG. 5 STRIPPING Pe JACKET (BELT-754 CABLE (PAR. 4.32))

(g) Care should be exercised to see that debris does not fall among apparatus and equipment creating a potential source of service interruptions.

4.22 Where there are only a few cable ends to be processed and the R-3186, coaxial cable stripping set is not available on the job, the cables may be stripped and butted as shown in Figure 1. Use the power wire stripper (R-2165) to skin the inner conductor.

#### 4.3 754-Type Cable

4.31 Remove the shield as shown in Figure 1.

4.32 Remove the polyethylene jacket (or belt) with the 754 cable stripper (R-2862), as shown in Figure 5.

4.33 Skin the inner conductors with the wire skinning tool R-3088.

NOTE: Since the wires in the cable are untinned (plain copper), the skinning should be deferred until ready to connect, in order to avoid corrosion and consequent difficulty in tinning the wires when soldering.

#### 4.4 760-Type Cable

4.41 Remove shield as shown in Figure 1.

4.42 Remove polyethylene belt as shown in Figure 6.

4.43 Skin the inner conductors with the wire skinning tool R-3088.

NOTE: Since the wires in this cable are untinned (plain copper), the skinning should be deferred until ready to connect in order to avoid corrosion and consequent difficulty in tinning the wires when soldering.

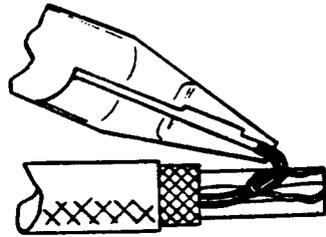
#### 4.5 KS-8086 Cable

4.51 Strip and Butt KS-8086 Cable as follows:

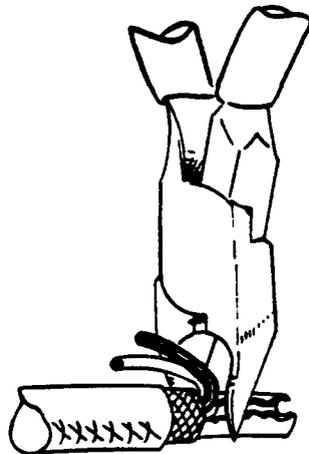
4.511 Use the coaxial stripping set (R-3186), if it is available on the job. Refer to Paragraph 4.21 and Figures 3 and 4 for information concerning the use of this set. It may be necessary to set the blades up without a gauge, to obtain the proper cutting depths.



- ① CUT PE BELT AT END OF CABLE WITH DIAGONAL CUTTERS. CUT BACK FAR ENOUGH SO THAT BLUE CONDUCTOR CAN BE GRIPPED WITH SHORT NOSE PLIERS.



- ② GRIP END OF BLUE CONDUCTOR WITH SHORT NOSE PLIERS AND HOLD END OF PE BELT WITH HAND. PULL BLUE CONDUCTOR BACK TOWARD BUTT OF CABLE FOLLOWING TWIST OF LEADS. THIS WILL TEAR PE BELT. PULL OUT WHITE CONDUCTOR IN SAME MANNER.



- ③ CUT OFF SPLIT PE BELT WITH DIAGONAL CUTTERS.

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FIG. 6 STRIPPING PE JACKET (BELT-760 CABLE) PAR. 4.42)

4.512 If the coaxial stripping set (R-3186) is not available on the job, butt and strip cable as shown in Figure 1. Use the power wire stripper (R-2165) to skin the inner conductor.

4.52 Apply clear protective cement (R-3365) to the exposed rubber covered inner conductor in the same manner as outlined in Paragraph 4.14.

#### 4.6 RG-58/U Cable

4.61 Remove the shield by bunching it up and cut off with electrician's scissors (R-1682) or diagonal cutters.

4.62 Skin the inner conductor(s) with wire skinning tool (R-3088).

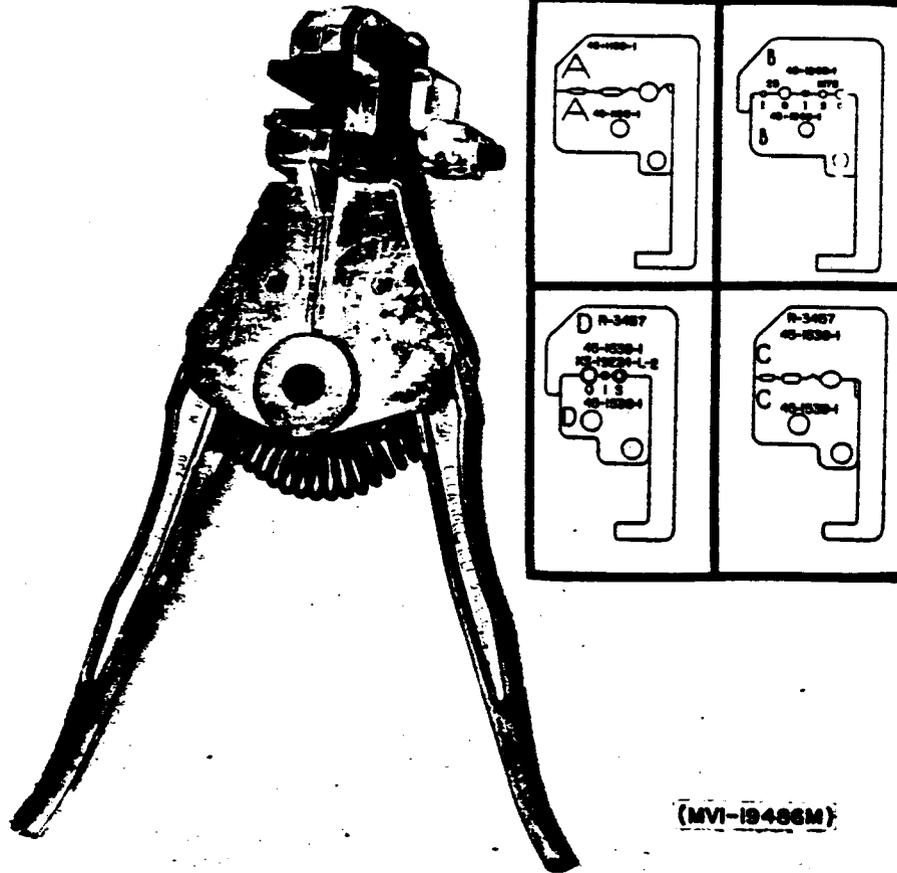
#### 4.7 730A, 731A Cable

4.71 Strip and Butt the 730A, 731A Cable as follows:

4.711 Use the Coaxial stripping tool (R-3186), if it is available on the job. Refer to Paragraph 4.21 and Figures 3, 4 and 4A for information concerning the use of this set.

#### 4.8 KS-19906-L1 Cable

4.81 Strip and butt the KS-19906-L1 cable with the coaxial stripping tool R-3186. Refer to Paragraphs 4.21 and Figures 3, 4 and 4A for information concerning the use of this set. Because there isn't much demand for the KS-19906-L1 cable, the KS-19906-L1 Collet Plate and Gauge needed for stripping and butting the cable shall be ordered direct from the supplier as shown in Handbook 250, Section 4, Set R-3186.



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FIG. 7 R-3457 SHIELDED CABLE AND WIRE STRIPPER  
(PARS. 4.91, 4.911, 4.912, 4.913, 4.914)

4.9 Shielded pairs of 761A Cable, 762A (10 pr 761A), 763A, 750-type Cables, KS-19224L-1 and L2 miniature Twin Conductor Cables

4.91 The R-3457 Shielded Cable and Wire Stripper, shown in Figure 7 is a plier-type hand tool for butting, stripping and skinning the cables listed above, equipped with sets of removable blades. The blades are shown in Figure 7. The procedure for processing shielded cable with the blades shown in Figure 7 is explained in Paragraph 4.9.

4.911 The blades marked "A" shown in Figure 7, are a special set of blades with three holes. The right hole removes the outer jacket from 761A cable; the center hole removes the outer jacket and shield from 761A cable or BF type paired wire, or the shield from the shielded pairs of 750 type cables; and the left hole removes the dielectric from 22 and 24 gauge wires.

4.912 The blades marked "B" shown in Figure 7, are stripping blades with five holes. The first three holes starting from the right side of the blade are for KS-19224 L1 miniature coaxial cable. The hole marked "O" removes the outer jacket; the hole marked "S" removes the outer jacket and shield; and the hole marked "I" removes the conductor dielectric. The "B" blades are used for stripping the KS-19414-L1 and KS-20906-L1 miniature twin conductor cables. The 2S-0 hole removes the outer jacket, the M75-0 hole removes the shield, (use scissors to trim shield if cut using M75-0 hole is not even) and the 2S-I hole removes the conductor dielectric.

4.913 The blades marked "C" are a special set of blades with three holes for stripping 763A cables. The right hole removes the outer jacket. The center hole removes the outer jacket and shield and the left hole removes the individual conductors dielectric.

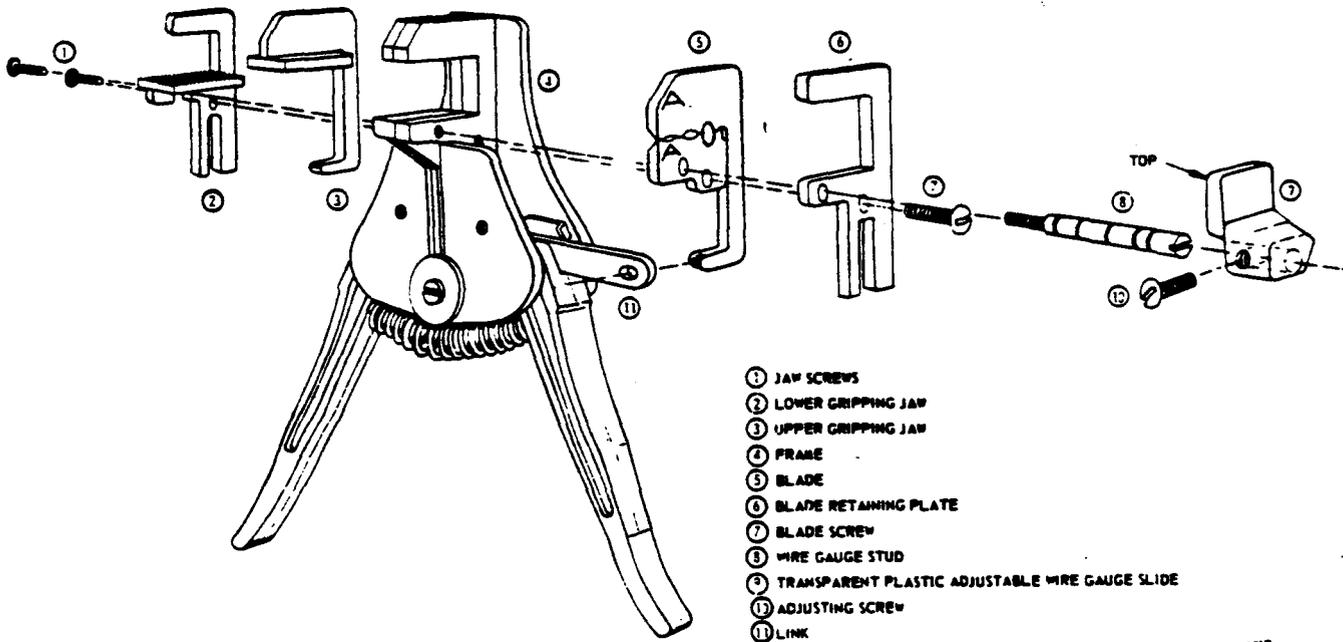


FIG. 8 PRINCIPAL PARTS AND ASSEMBLY SEQUENCE FOR R-3457  
(PARS. 4.915, 4.916, 4.92)

4.914 The blades marked "D" are a special set of blades with three holes for stripping the KS-19224-L2 cable. The right hole removes the shield, the left hole removes the outer and the center hole removes the dielectric from the center conductor.

4.915 The wire gauge stud shown in Figure 8 has been marked at 1/4" intervals for measuring the proper shiner length when performing the skinning operation. The first mark appears at the 1/8" point, but because of the thickness of the blade retaining plate, this mark measures approximately 1/4" from the face of the blade. The 1" mark and the last mark are heavier than the others. The last mark on the stud measures 1-1/8" from the blade face.

4.916 The transparent plastic adjustable wire gauge slide and adjusting screw shown in Figure 8 slides along the wire gauge stud and may be placed at the appropriate mark for measuring the desired shiner length.

4.9161 For skinning shorter lengths, the plastic slide will be placed on the stud so that the adjusting screw is on the left with the wire gauge stud pointing at the operator. In this position the plastic slide will slide up flush against the blade face. To measure a 1-5/8" shiner, the slide must be removed, flipped over, and placed on the stud so that the

adjusting screw is on the right with the wire gauge stud pointing at the operator. In this position and with the front of the slide placed on the 1-1/8" mark, the distance from the blade face to the end of the slide will measure 1-5/8".

4.9162 When the length of that portion of the cable or wire to be butted and stripped exceeds the length of the wire gauge stud, turn the plastic slide so that the top is down. In this position it will not interfere with the butting and stripping operations.

4.92 For removing and inserting blades, follow the sequence shown in Figure 8.

4.921 It may be necessary to squeeze handles of tool slightly to allow link to be released from or drop into slot in frame.

4.922 When inserting blades, insert blade screw and stud; screw down but do not tighten. The squeeze handles of tool until blades are fully closed and tighten screw and stud. This will insure proper blade alignment.

4.93 Prior to performing any butting and stripping operations on actual job cables, the installer should make several practice strips on scrap pieces of cable in order to gain some proficiency in the use of the tool.

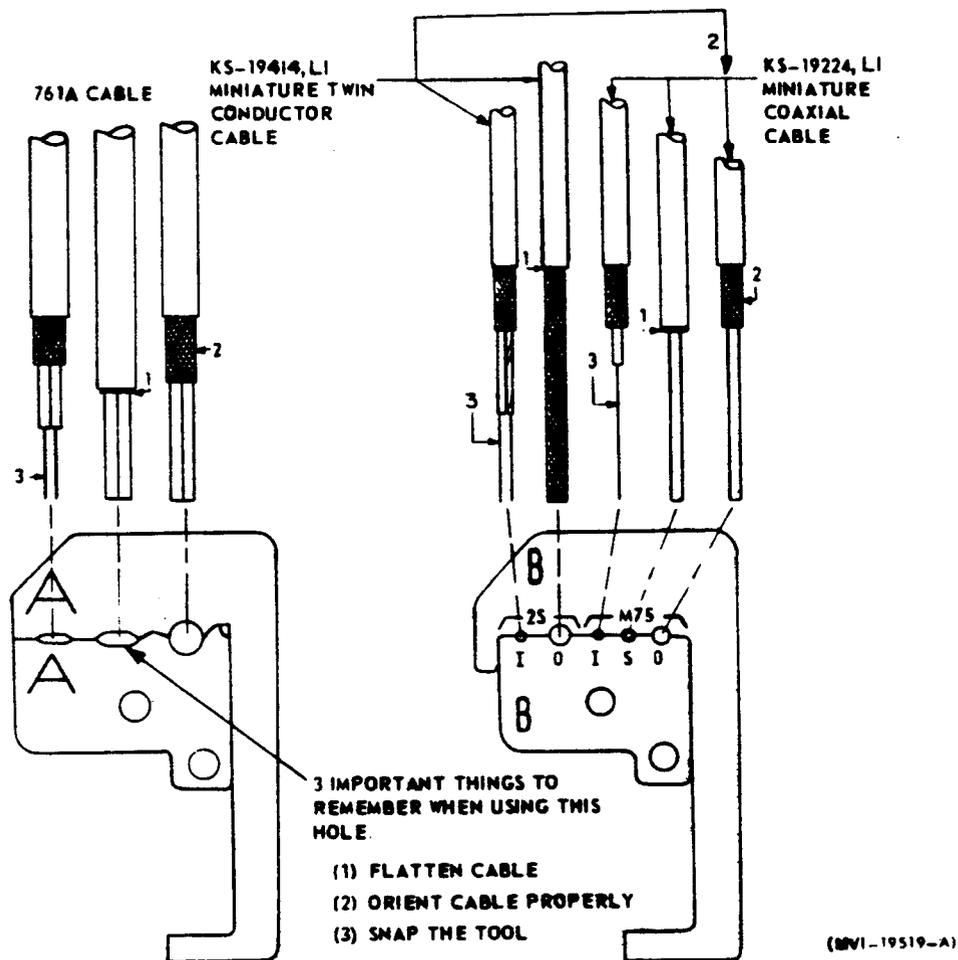


FIG. 9 SEQUENCE OF OPERATIONS FOR USING "A" AND "B" BLADES OF R-3457  
(PARS. 4.94, 4.95, 4.96, 4.97, 4.98, 4.99)

4.94 For processing 761A and 762A (10 pr. 761A's) with "A" blade refer to Figures 9 and 10 and proceed as follows:

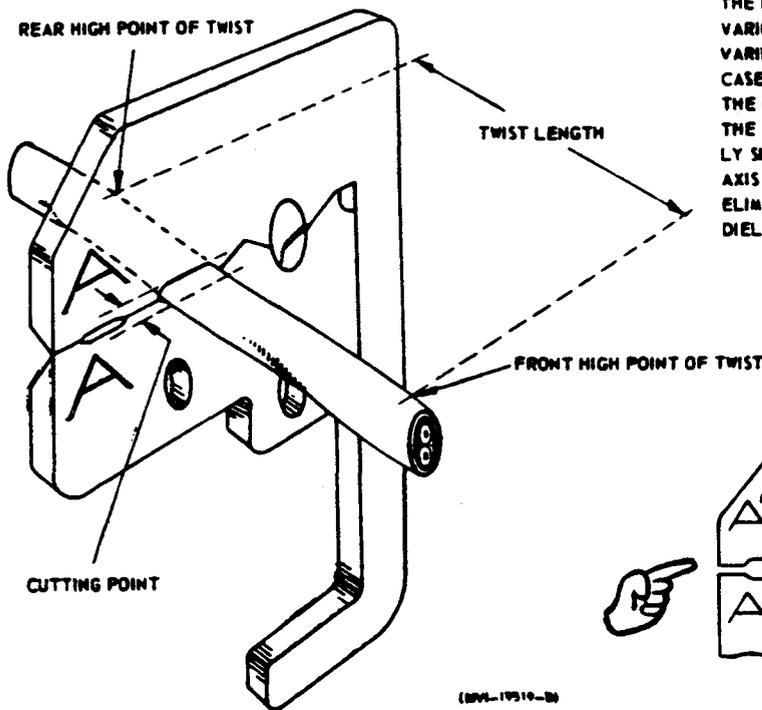
- (a) Remove outer jacket and shield with center hole in blade. Trim any uncut strands of shielding with the diagonal cutters. It will be necessary that the cable to be stripped using this hole be properly oriented. See Figure 10 for proper orientation of cable.

**NOTE 1:** Prior to performing the above operation, flatten the cable as much as possible by bending it back and forth, several times, over the forefinger of one hand. This is necessary to insure proper orientation as shown in Figure 10. In order to insure a clean shield cut, make this

cut with quick snap of the tool. A slight nicking of the conductor's dielectric is permissible but it must not exceed 1/64" in depth.

**NOTE 2:** The 762A cable consists of 10-761A type cables. The 762A cable shall be processed the same as the 761A type cable once the outer cover has been cut back exposing the 10-761A cables (Figure 1). Use an R-1682 (Electricians Scissors) to remove the outer cover of the 762A cable.

- (b) Remove the outer jacket of 761A cable using the large hole on the right of the blade.



THE DISTANCE BETWEEN THE HIGH POINTS OF THE TWIST OF THE VARIOUS CABLES AND WIRES TO BE STRIPPED WITH THESE BLADES, VARIES BETWEEN APPROXIMATELY 1/4" TO 2" HOWEVER, IN ALL CASES, THE CABLE OR WIRE IS TO BE ORIENTED AS SHOWN, SO THAT THE CUTTING POINT WILL BE APPROXIMATELY 1/2" IN FRONT OF THE REAR HIGH POINT ALSO, THE MAJOR AXIS OF THE ELLIPTICALLY SHAPED CABLE OR WIRE MUST BE PARALLEL TO THE MAJOR AXIS OF THE HOLE. THIS ORIENTATION IS NECESSARY IN ORDER TO ELIMINATE THE POSSIBILITY OF SCRAPING THE INNER CONDUCTOR'S DIELECTRIC WHEN REMOVING THE OUTER JACKET AND SHIELD.

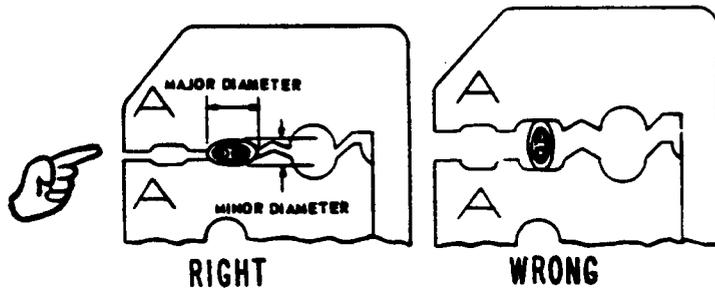


FIG. 10 ORIENTATION OF CABLE OR WIRE FOR CENTER OF "A" & "C" BLADE (PARS. 4.94 & 4.98)

(c) Remove both inner conductor's dielectric simultaneously or singly, using the hole on the left of the blade.

4.95 For processing the shielded pairs of 750 type cable with the "A" blade, refer to Figure 9 and proceed as follows:

- (a) Remove shield with center hole in blade as described in (a) above for 761A cable.
- (b) Since the shielded pairs are not jacket individually, no operation is required with the hole on the right for 750 type cable.
- (c) Remove both inner conductor's dielectric simultaneously or singly, using the hole on the left of the blade.

4.96 For processing KS-19224-L (M75) miniature coaxial cable with the "B" blade, refer to Figure 9 and proceed as follows:

- (a) Remove outer jacket and shield with hole marked "S".
- (b) Remove outer jacket with hole marked "O" on right side of blade.
- (c) Remove inner conductor dielectric with the hole marked "I" (third hole from right side of blade).

4.97 For processing KS-19414-L1&KS-20906-L (2S-WTE) miniature twin conductor cable with the "B" blade, refer to Fig. 9 and proceed as follows:

- (a) Remove outer jacket with hole marked "O" (fourth hole from right side of blade).
- (b) Remove the shield with the hole marked "O": (first hole from right side of blade).

NOTE: Trim any uncut strands of shielding with the diagonal cutters or scissors.

- (c) Remove the conductor dielectric with the hole marked "I" (fifth hole from right side of blade).

4.98 For processing 763A cable with "C" blades, refer to Figure 10 for proper orientation of cable in "C" blades.

- (a) Remove outer jacket and shield with center hole.
- (b) Remove the outer jacket from the first hole on right side of blades.
- (c) Remove the conductor dielectric from each wire individually with the hole located on left side of blades.

4.99 For Processing the KS-19224-L2  
Cable with "D" blade as follows:

- (a) Remove outer jacket and shield in one operation with the hole marked "S".

NOTE: To insure a satisfactory cut of the shield, the cut must be made at least 2" back from the end of the cable being prepared.

- (b) Cut center conductor to length using the end of the shield as the reference point. (Use cutters).
- (c) Remove outer jacket exposing the shield to length required, with the hole marked "O".
- (d) Remove dielectric from the center conductor with the hole marked "I".

➔ Arrowed lines indicate new or changed information.

Manager, Engineering Transmission Products

Reason for Reissue:  
To add KS-20906L-1 Miniature Twin  
Conductor Cable