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## MODEL 66 SERIES CUTTER HEAD OPERATING INSTRUCTIONS

**DO NOT OPERATE TOOL UNTIL YOU HAVE READ THOROUGHLY, AND UNDERSTAND COMPLETELY, ALL INSTRUCTIONS, RULES, ETC., ON THIS PAGE. THESE ARE IMPORTANT SAFETY INSTRUCTIONS AND SHOULD BE KEPT FOR FUTURE REFERENCE. CONTACT ERASER IF INSTRUCTIONS ARE NOT CLEAR.**

### **OPERATION:**

**Safety glasses or other suitable eye protection should be worn when operating this unit.**

The cutter head works with centrifugal force to cause the blade cartridge to cut into the cable at predetermined strip lengths and depths to strip the cable. The cartridge may contain up to three blades, depending on the specific application.- The spacing of the blades for strip lengths is determined by the application and is fixed. The depth of the blades, however, can be adjusted by use of the blade adjusting screws found on the cutter head blade cartridge. To operate the unit, insert a piece of the cable to be stripped into the cutter head until it hits the strip stop.

**NOTE:** Hold cable firmly and present it to the cutter head straight for best results. Set the unit's timer to four to five seconds to allow the cutter head to fully complete the strips. Turn the unit on by pressing the foot switch on the machine, and continue pressing the switch until the unit stops. When the cutter head has come to a complete stop, remove the cable from the head. Remove the slugs using pliers or fingers. Remove the slugs starting from the end and working inwards. Examine the strip. If any of the blades has cut in too far or not far enough, remove the cutter head from the machine and use a small screwdriver to adjust the blade depth via the blade adjusting screws located on the blade cartridge. Turn screws about 1/4 turn clockwise to bring the blade deeper or 1/4 turn counter-clockwise to retract the blade.

The center conductor length can also be adjusted if necessary. To do this, turn the screw located in the male coupling of the cutter head. The screw is accessed through a hole in the end of the coupling. After making any required blade depth and center conductor length adjustments, retighten the set screw that holds the strip length stop screw, replace the cutter head in the machine. Using a clean piece of cable, test again. Repeat adjustments if necessary until desired results are achieved.

### **SPECIAL INSTRUCTIONS:**

#### **Large diameter or stiff cables:**

The cutter head works best when the cable is presented straight. Any curvature as is often found in large stiff cables will cause cuts that are too deep on one side and not deep enough on the other. Smaller cables with curvature will usually be straightened by the cutter head blades as they strip.

#### **Large diameter, semi-rigid or soft flexible cables:**

These types of cables can cause drag on the blades due to their construction. Stripping results may be unsatisfactory or inconsistent due to the drag. This problem can be helped by applying a small amount of lubricant to the cable end before inserting it into the cutter head. White Teflon grease or silicone lubricant are two good choices to reduce drag and improve stripping results on these types of cables. Use of lubricant is especially required when stripping semi-rigid cable to reduce the friction of the metal cable jacket against the cutter head tube and blades.

## **MAINTENANCE:**

### **Cutter Head:**

This Cutter Head is all metal and can be cleaned with any type cleaning material. The part number label may be damaged by cleaning. Ensure that no slugs or pieces of braid are stuck in the head, which can cause stripping problems. Replace blades as necessary. See below for blade replacement instructions.

### **Blade Replacement:**

To replace one or more blades in the cutter head, first remove the head from the machine. To access the blade cartridge use a Phillips head screwdriver to remove the three screws holding the top plate onto the cutter head. Remove the top plate and lift the blade cartridge up and out of the bottom plate. Back out the adjustment screws, remove spring material and lift out cutting blades. Replace with new blades. Re-install spring material under blades, install cartridge, and replace top plate with screws. NOTE: Install two machine screws in the silver standoff and the plastic standoff. Install coarse thread screw in the lead standoff.

## **TROUBLESHOOTING:**

### **PROBLEM:**

Strip not deep enough.

### **SOLUTIONS:**

1. Adjust blade depth screw on cutter head clockwise.
2. Increase timer "on" time.

### **PROBLEM:**

Strips too deep.

### **SOLUTIONS:**

1. Adjust blade depth screw on cutter head counter clockwise.
2. Decrease timer "on" time.

### **PROBLEM:**

Strips inconsistent.

### **SOLUTIONS:**

1. Check that cable is straight.
2. Use lubricant on large cables or semi-rigid cables.
3. Check there are no slugs or debris caught in cutter head.

### **PROBLEM:**

Cutter head jammed.

### **SOLUTIONS:**

1. Clean out slugs from cutter head.