


# *Boyd Machine Co. Inc.*

## Operating Instructions - Accustrip Model 199

1. Install proper cutter and guide bushing per cutter installation instructions. (See Installation of Accessories)
2. Attach air supply to air inlet of Accustrip. Air supply should be between 40-90 PSI.
3. Check that all tools are removed from machine.
4. Install proper clamp block and gage blocks per installation instructions. ( See Installation of Accessories)
5. Slide both right-hand and left-hand gage blocks to outside positions and lock with holding screws.
6. Plug line cord into power receptacle.
7. Turn machine on.
8. Press start switch until feed is actuated, then release. Allow machine to cycle and return to outer positions.
9. If two gage blocks are installed on machine, always keep gage block locked that is not being used.
10. Slide gage block to inward position.



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11. Loosen quick clamp by lifting lever.
12. With end of cable against face of gage block, close clamp snugly. Over tightening may damage cable.
13. If SMA body is attached to cable, align retaining ring groove on SMA body with ring on jaws of clamp and close clamp securely. Gage block is not used.
14. Slide gage block to outward position. Make sure block is in its outermost position.
15. Engage feed mechanism by pressing start switch (green pushbutton) until clamp block begins travel, then release.
16. When quick clamp returns to its outward position, remove cable and slide gage block back into place.

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17. Inspect center pin of cable for possible marking or scoring by cutter. If pin is scored remove quick clamp assembly and see Step 5 at Installation of Accessories.
18. Re-install quick clamp assembly and repeat steps 10-17.
19. If point is required on center conductor, hand feed prepared cable into pointing spindle, keeping cable at right angles to machine and level. Light pressure is all that is necessary to produce a clean burr-free point. Slight rotation of cable can help in keeping point centered in cutter.

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### Additional Instructions Model 550

The Accustrip Model 550 is a manually operated machine in which the feed mechanism is operated by means of a lever assembly instead of the electromechanical operation of the Model 199. All other installation and operating procedures are the same as Model 199 except as follows:

1. Gage Block is used as a reference only. Strip length is adjustable by means of a set screw on traverse assembly.

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