

Part Number	Model "G" Terminating Machine 356462-[]
356462-2	End/Side-Feed Version with Manual Precision Adjust
356462-5	Side-Feed (Only) Version with Auto Precision Adjust (No TE CQM)
356462-9	End/Side-Feed Version with Manual Precision Adjust (with TE CQM)
1-356462-0	End/Side-Feed Version with Auto Precision Adjust (with TE CQM)
1-356462-1	Side-Feed Only Version with Manual Precision Adjust (with TE CQM Sensors)
1-356462-2	Side-Feed Only Version with Auto Precision Adjust (with TE CQM Sensors)
1-356462-3	End/Side-Feed Version with Manual Precision Adjust (with TE CQM Sensors/Low Force)

Figure 1

1. INTRODUCTION

These instructions cover the differences between the AMP-O-LECTRIC Model "G" Terminating Machine 356462-[] for Through-Splice Terminals (Figure 1) and the AMP-O-LECTRIC Model "G" Terminating Machine 354500-[] for end-of-wire applications.

Refer to customer manual 409-5842 for information about Model "G" Terminating Machine 354500-[].

When reading this document, pay particular attention to **DANGER**, **CAUTION**, and **NOTE** statements.



Denotes an imminent hazard which may result in moderate or severe injury.



Denotes a condition which may result in product or equipment damage.



Highlights special or important information.



Dimensions in this manual are in metric units [with U.S. customary units in brackets].

Reasons for reissue are provided in Section 8, REVISION SUMMARY.

2. DESCRIPTION

The AMP-O-LECTRIC Model "G" Terminating Machine was designed to be used as a stand-alone semi-automatic bench machine. The modifications described below allow application of through-splice terminals and other terminals that require access to both sides of the wire crimper.

The guards of the Model "G" Terminating Machine 356462-[] have been modified to allow access to both sides of the crimper for through-splice type applications. The right side door of the machine allows the operator to present a wire to the rear of the wire crimper. See Figure 2.

A front guard has been modified to remove the guard insert, and is supplied with the through-splice applicator assembly. A guard is attached to the frame of the Model "G" Terminating Machine to protect the operator during wire termination. A second safety interlock switch is mounted on this guard and is actuated by the closure of the front guard. The two interlocks on the Model "G" Terminating Machine 356462-[] duplicate the operation of the interlocks on the Model "G" Terminating Machine 354500-[] for end-of-wire applications.

The -5, -11, and -12 terminating machines do not include guards on the right hand side of the terminating machine. The interlock switch in each of these machines is mounted to a bracket instead of on the right side door. Since the end-feed guard insert is also mounted to the right side guards, the -5, -11, and -12 machines are NOT intended for use with end-feed applicators.

DANGER

Do not use end-feed applicators with -5, -11, or -12 terminating machines.

This terminating machine uses the through-splice side-feed and end-feed applicators described in 408-8318 to apply through-splice terminals.

NOTE

Refer to 408-8318 for applicator descriptions and maintenance.

The through-splice applicator ram is bolted to the ram of the "G" Terminating unit, and the applicator base is bolted to the terminating unit base plate. See Figure 3.

NOTE

Model "G" Terminating Machines 356462-[] will not accept heavy duty, miniature quick-change type applicators.

3. INSTALLATION

Refer to 409-5842 for installation instructions for the Model "G" Terminating Machine.

Instructions for applicator installation are covered in 408-8318.

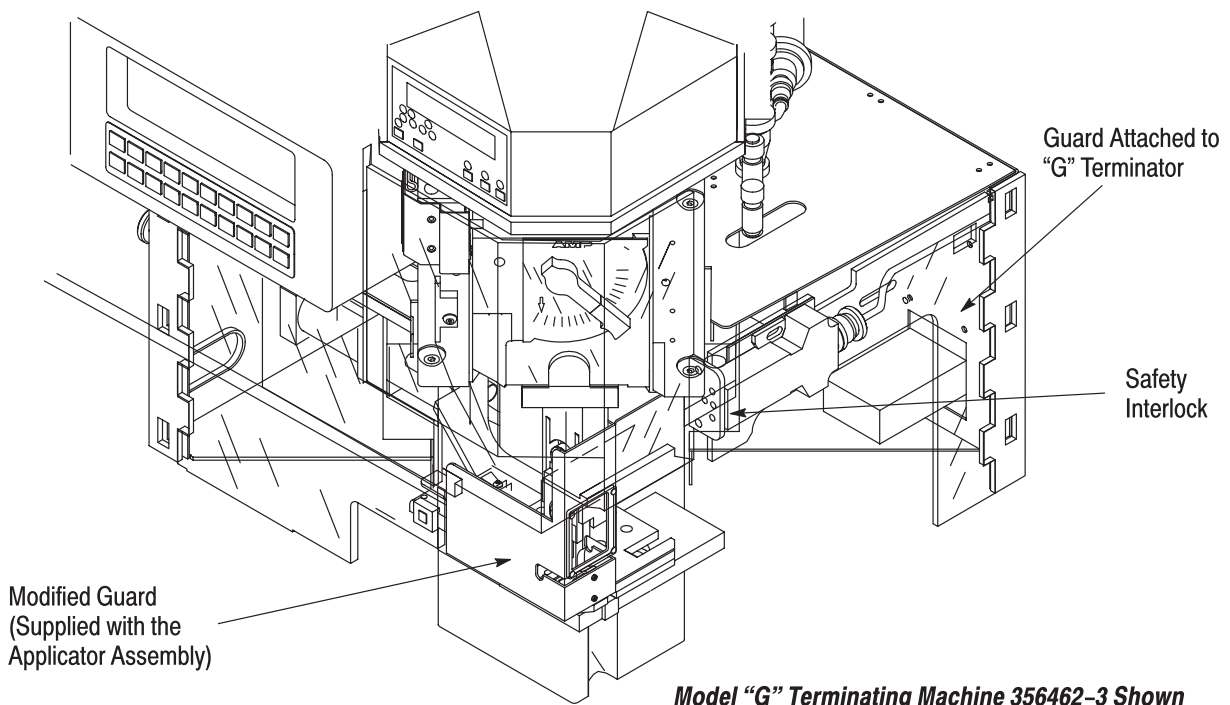
4. OPERATION**NOTE**

*Through-Splice type applications are self-guarded to protect the operator from pinch points not guarded by the machine. ALL terminating units are intended for use with self-guarded applicators **only**.*

DANGER

To avoid personal injury, BE SURE to use only self guarded applicators. Failure to use self-guarded applicators could result in physical injury while performing terminations.

Refer to 409-5842 for Model "G" Terminating Machine operating instructions.



Model "G" Terminating Machine 356462-3 Shown

Figure 2

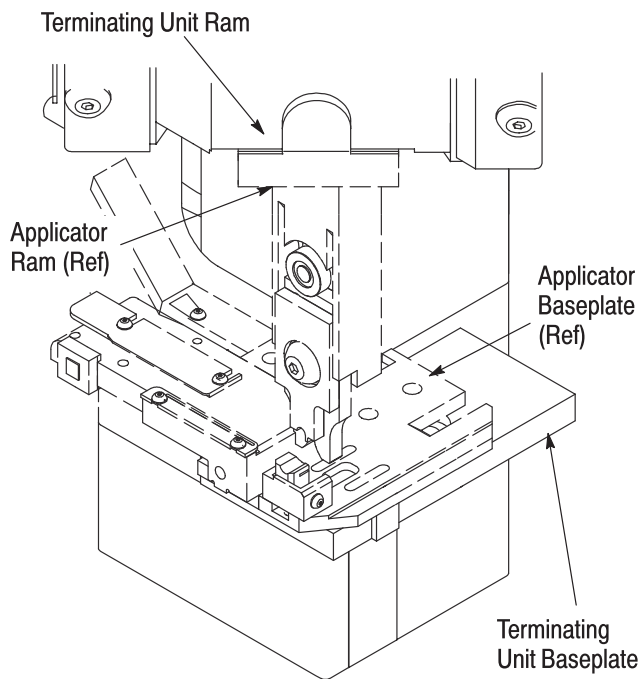


Figure 3

5. PREVENTIVE MAINTENANCE

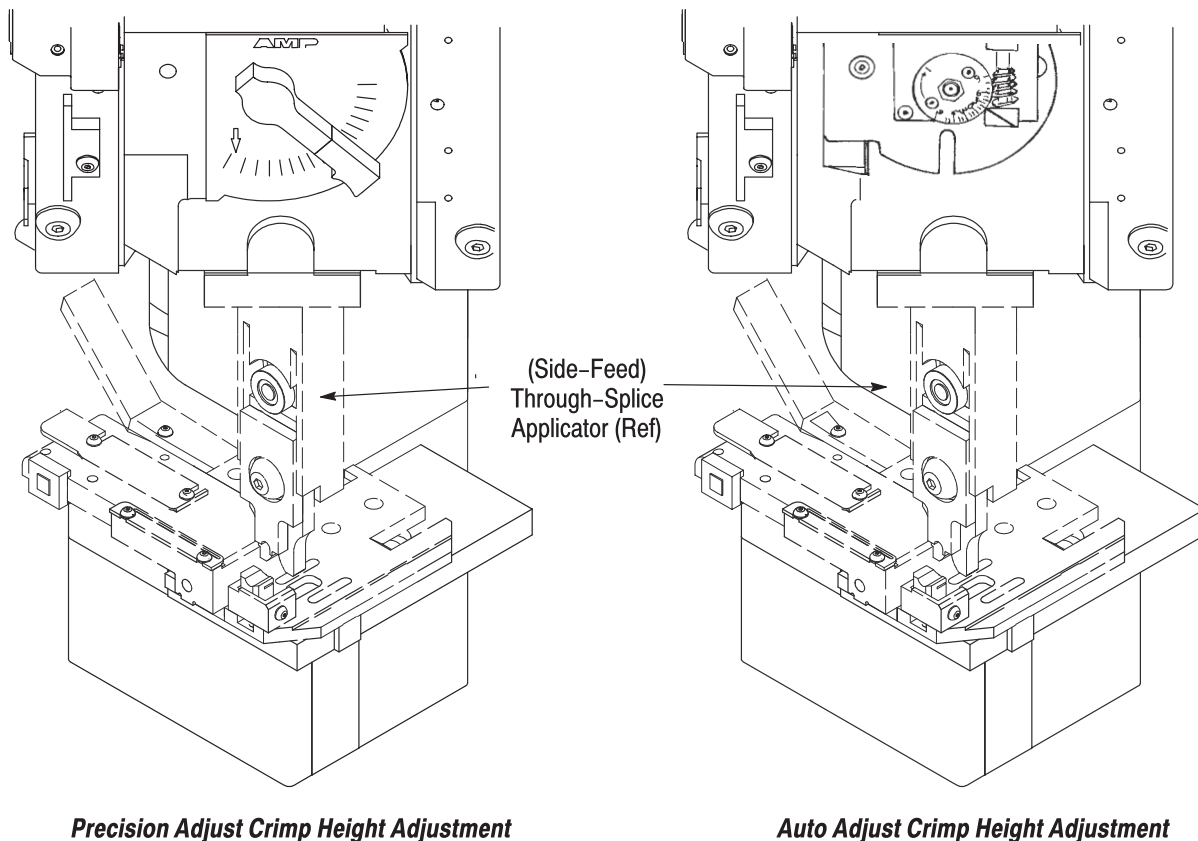
Preventive maintenance will keep the terminating machine in good working order and ensure maximum reliability and service from all of its components. Refer to Customer Manual 409-5842 for preventive maintenance procedures.

6. ADJUSTMENTS

6.1. Crimp Height Adjustments

Crimp heights on Model “G” Terminating Machines 356462-2, -5, -9, -11, and -13 are made with the precision adjustment mechanism shown in Figure 4. Crimp heights on Model “G” Terminating Machine 356462-10 and 356462-12 are made with the auto adjust mechanism, also shown in Figure 4.

For minor crimp height adjustments, refer to Paragraph 6.3 in 409-5842. For major crimp height adjustments, refer to Paragraph 5.1,B in 408-8318.



Precision Adjust Crimp Height Adjustment

Auto Adjust Crimp Height Adjustment

Figure 4

6.2. Guard Insert Adjustments

To adjust the guard insert, proceed as follows:

1. Loosen the two screws that secure the mounting bracket to the machine frame and reposition the bracket.
2. If required, align the slot in the guard with the termination tooling by loosening the two screws that hold the guard insert to the bracket, and repositioning the slot.

The interlock switch mounted on the guard insert may need to be repositioned if the guard insert is moved. Adjust the interlock switch by loosening the two switch mounting screws and moving the switch back so that the front door closes without bottoming on the switch.

6.3. Termination Area Adjustments

Position the guard so that when the wires are put into the termination area, the back of the slot is used to locate the wires over the wire barrel.

7. TROUBLESHOOTING AND OPTIONS

Refer to customer manual 409-5842 for a list of error messages, probable causes of the errors, and remedies.

Machine options are also available for this terminating machine, including Part Number 1725190-1, the End-Feed Guard Kit.

The End-Feed Guard Kit allows the customer to use machines 356462-5, 1-356462-1, and 1-356462-2.

8. REVISION SUMMARY

Since the last release of this instruction sheet, the logo was changed, several machine part numbers were obsoleted, and several numbers were added.