AMP INCORPORATED
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AMP★ STANDARD APPLICATOR WITH AIR FEED (Side Feed Type) FOR SERPENT‡ CONTACTS

Instruction Sheet
AI 8081
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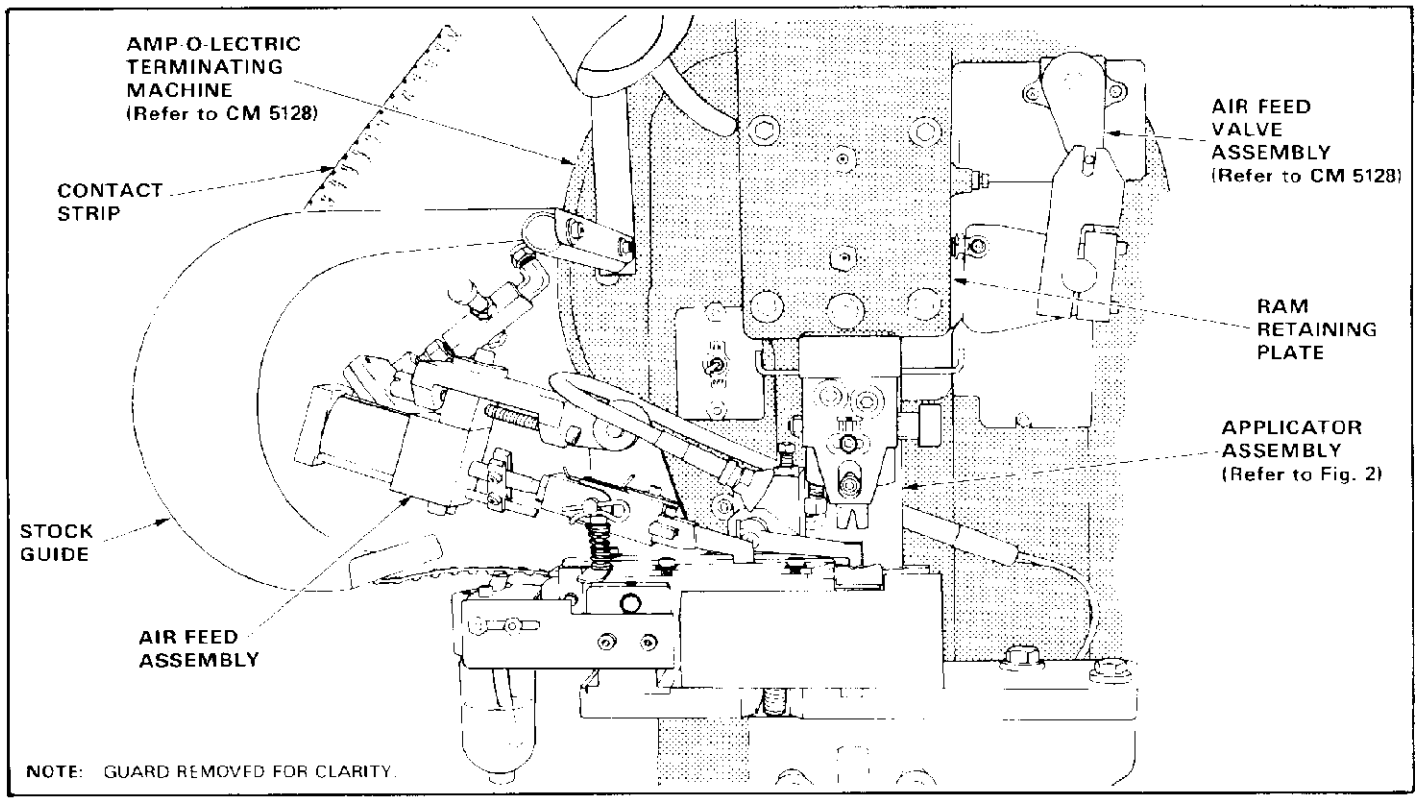

Fig. 1

1. INTRODUCTION

These instructions cover applicators that crimp Serpent contacts onto pre-stripped wires. The applicators have been designed for use in an AMP-O-LECTRIC★ Model "K" Terminating Machine.

The contacts are supplied to the applicator in strip form from a reel mounted on the machine reel support. Refer to the parts list supplied with the applicator for terminal number(s), wire and insulation ranges, and the specified crimp heights for each wire size. The crimp heights are measured in accordance with Instruction Sheet IS 7424.

This instruction sheet, the parts list and exploded view drawing packaged with the applicator, and Customer Manual CM 5128 provide all the information necessary to operate and maintain the applicator and machine.

2. DESCRIPTION

Major components of the applicator are identified in Figures 1 through 6. The contact strip enters the applicator from the left, passing over the lubricator, then in between the strip guides and under the stock drag mounted on the strip guide plate. The lead contact is always positioned over the anvil at the beginning of each machine cycle. This requires air pressure from the air valve assembly mounted on the machine to be applied to the extension port of the feed air cylinder.

On the downward stroke of the machine ram, air pressure to the feed air cylinder is shut off by the air valve assembly to allow the air feed cylinder to retract by internal spring pressure, and to exhaust the air within through the quick-exhaust valve. At this point the feed finger picks up the next feed point in the contact strip.

As the ram fully bottoms, and with the pre-stripped wire inserted in the lead contact in the "target area," the contact is crimped by the wire crimper and insulation crimper to produce the correct crimp height. At the same time, the table depressor screw on the ram pushes the strip guide plate downward against spring pressure, and the shear attached to the plate shears the contact carrier strip as the shear passes the shear block.

On the upward stroke of the ram, the terminated contact is released for removal from the "target area," and the feed air cylinder is again pressurized to advance the feed finger and position the next contact over the anvil to complete the cycle.

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