

Figure 1

1. INTRODUCTION (Figure 1)

This instruction sheet covers the use of Document Package 854060-1. The package of prints, and other documents, covers the AMP-O-ELECTRIC* Model "K" Terminating Machine, "T" Terminating Unit, and AMPOMATOR* CLS Machine conversions for the applicator. The three applicator basic numbers are: 680017, 852293, and 853358, . Refer to Instruction Sheet 408-8095.

This document will list the prints and publications required for you to convert each machine with the proper accessories to run this particular applicator.

There are several documents that may be used typically with some of all of the machines:

114-2124 Ultra-Pod FASTON* Fully Insulated Receptacles and Tabs

408-8053 Conversion Guide, Miniature Quick-Change Applicators

408-8059 Preventative Maintenance, Miniature Quick-Change Applicators

You should already have in your possession the appropriate customer manual, which has its own added appendix. The specific applicator drawing was not included, but was packaged with your applicator when purchased.

When following these instructions, pay particular attention to DANGERS, CAUTIONS, and NOTES.



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.

Refer to Section 3, REVISION SUMMARY for reasons given for this revision.



Compressed air used for cleaning this applicator must be reduced to less than 30 psi, and effective chip guarding and personal protective equipment (including eye protection) must be used.

2. AMP-O-LECTRIC MODEL "K" TERMINATING MACHINE CONVERSION

This machine must already be equipped with Machine Conversion Kit No. 690675-2, to adapt it for use with the miniature applicators. The kit includes Instruction Sheet 408-8022, which explains how an applicator with mechanical feed is installed and removed. Refer also to Instruction Sheet 408-8053, Conversion Guide for Miniature Quick-Change Applicators, which explains feed conversion.

2.1. Air Feed Modification (Figure 2)

The procedure for applicators with air feed systems is the same, with the addition of the following steps (Item Number references are on the three applicator basic drawings):

1. Loosen two screws holding the reel support to the right side of the machine. Slide the valve bracket (with on/off valve forward) between the reel support and machine, and then re-tighten the screws.
2. Install female branch tee 23791-2, Item 165.

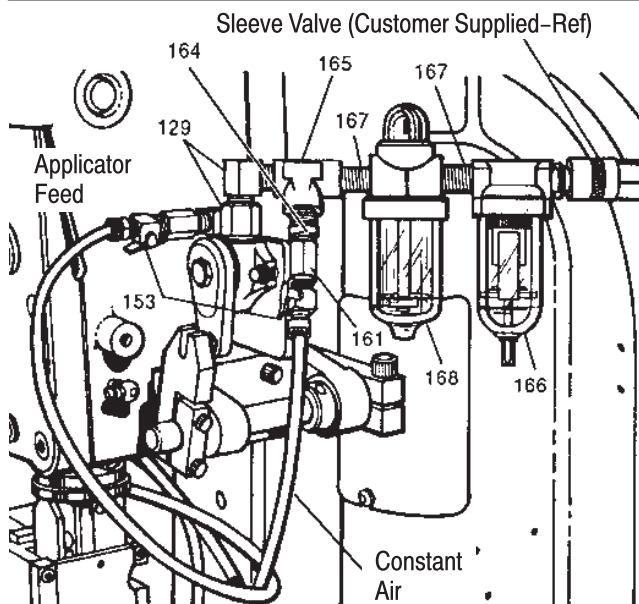


Figure 2

3. Install nipple 22311-2, Item 167, into branch tee, Item 165.
4. Install lubricator 28582-1, Item 168, onto nipple, Item 167.
5. Install nipple 22311-2, Item 167, into lubricator 28582-1, Item 168.
6. Install filter 28580-1, Item 166, onto nipple 22311-2, Item 167.
7. Install sleeve valve, (customer supplied), into filter 28580-1, Item 166.
8. Install bushing 992369-9, Item 164, into Item 165.
9. Install quick-connect body 26108-1, Item 161, into Item 164.
10. Connect applicator constant air quick-connector into quick-connector body 26108-1, Item 161.
11. Insert applicator feed quick-connector into quick-connect body.
12. Connect air supply to sleeve valve. With valve open, feed finger should extend.
13. Hand cycle machine through one complete cycle. Refer to Customer Manual 409-5128, while CLOSELY watching operation of applicator. Feed finger should retract at beginning of DOWNWARD stroke and extend again as ram nears end of UPWARD stroke.
14. Load applicator with terminals as described in Instruction Sheet 408-8095, Section 3, then repeat Step 5 in Paragraph 3.1 while watching crimping action and feeding of terminals. Make any adjustments to the applicator as described in Section 4, and to the machine as described in Customer Manual 409-5128.
15. Connect electrical power to machine and turn machine "ON". Make several test cycles under power, to be sure that crimping action is correct. Make any additional adjustments that may be necessary.
16. If machine is not to be used immediately, disconnect power cord and air line.

2.2. Flow Control and Quick Exhaust Valve

Refer to the applicator assembly drawing and Figure 3 for proper installation of flow control valve, Item 109, and the quick exhaust valve, Item 148.

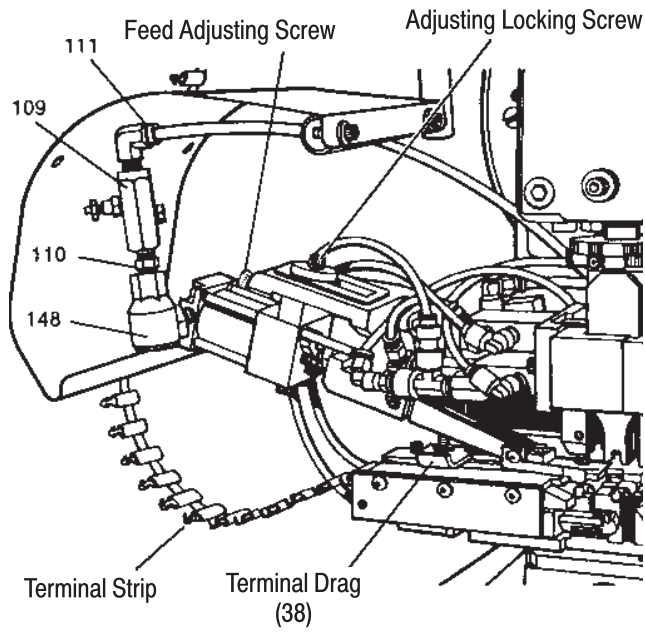


Figure 3

3. REVISION SUMMARY

This section provides reasons for the latest revision including:

- Updated document to corporate requirements
- New format
- Deleted obsolete part numbers and obsolete reference documentation
- Deleted Paragraphs 2.1, 2.2.13, and Sections 3, 4, and 5
- Deleted original Figures 3 and 4