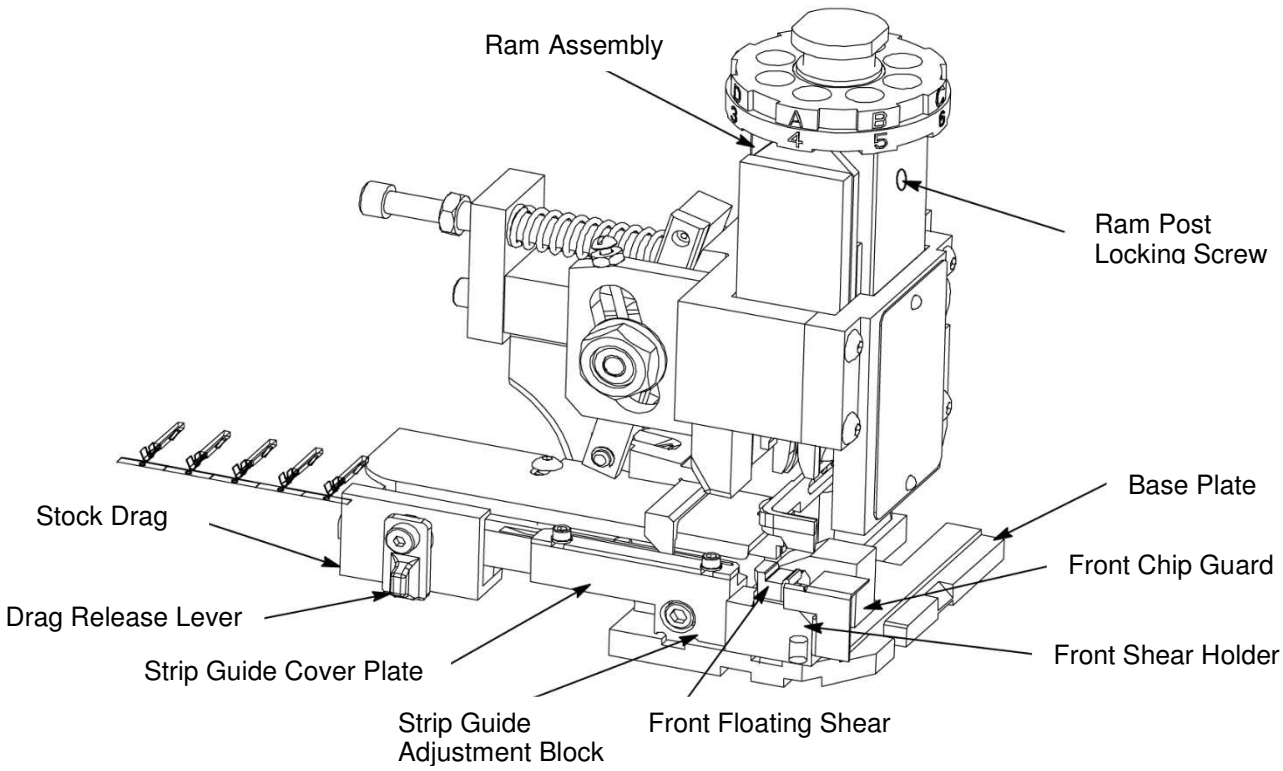

Figure 1

1. INTRODUCTION

The Heavy Duty Miniature Quick-Change Applicator (side-feed type) with mechanical and air-feed systems apply side-feed strip terminals to pre-stripped wires (see Figure 1). Each applicator accepts the strip form of certain terminals, which are identified on the applicator parts list and exploded view drawing (Applicator Log) for each applicator. The terminal listed on the data plate is the one that was specified when the applicator was ordered. Some terminals have two carrier strips; others, just one.

This instruction sheet, the parts list and exploded view drawing packaged with the applicator, and the appropriate Customer Manual (409-5128 for the Basic AMP-O-LECTRIC* Machine; 409-5207 or 409-5289 for the Model "T" Terminating Unit; 409-5842 for the Model "G" Terminating Machine; or 409-10047 for the AMP-3K* and AMP-5K* Terminating Machines), provides all the information required to operate and maintain the applicator and machine (or unit).

Reasons for reissue of this document are provided in Section 10, REVISION SUMMARY.

2. APPLICATOR DESCRIPTION

2.1. General

The side-feed applicators now feature a heavier, more rugged construction than previous models. This lets them stand up to the higher crimping pressures needed to apply terminals to the larger wire sizes.

Although these applicators accept only certain terminals, they provide valuable application flexibility. The wire crimp can be easily adjusted for as many as four different wire sizes, and the insulation crimp can be adjusted to accept eight insulation diameters.

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These applicators can be used in various machines (depending on stroke length capability) and all the necessary equipment.

Some of these applicators have air-powered feed mechanisms. The air feed systems allow for better control of the feed finger's movement and provide a longer feed stroke. These features are required only in a few specialized applications.

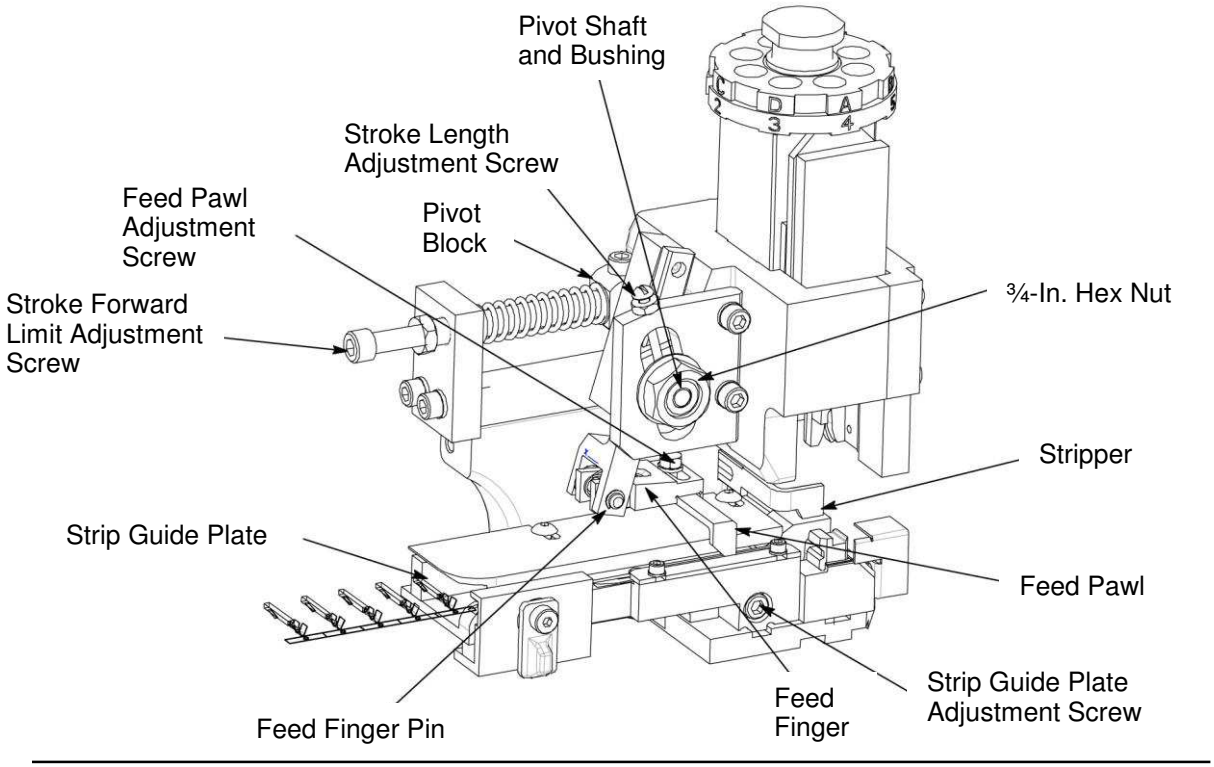

Figure 2

The main components of the applicators with mechanical feed are identified in Figure 1 and Figure 2. The ram assembly is shown in detail in Figure 3.

The terminal strip is fed into the applicator with the barrel (wire) end first, between the front (outer) and rear (inner) strip guides. It passes the stock drag, and the LEAD terminal is positioned over the anvil (for PRE-FEED applicators) or one terminal length from the anvil (for POST-FEED applicators). The feed pawl feeds one terminal during each cycle of the machine. The terminals are fed by the action of the feed cam and a series of rods and levers which move the feed pawl.

The ram post (also referred to as the ram mounting post) engages the post adapter of the machine ram, and it is the machine ram that actuates the applicator.

Just below the ram post are the wire disc and insulation disc. The wire disc has as many as four pairs of pads, depending on the number of different wire sizes the terminals will accept. Each pair of pads has a different height. By rotating the disc, each pair of pads can be lined up with the two bosses on the ram post adapter (see Figure 3) to change the length of stroke of the wire crimper over the anvil. The insulation disc contains eight pads of different heights. When this disc is turned, the pads line up with the top of the insulation crimper to change the insulation crimp height.

The wire crimper is held in a preset position by two pins on the ram assembly and by the crimper bolt. The insulation crimper and the front shear depressor are also held by the crimper bolt. The insulation crimper is free to move up and down so the insulation crimp may be changed. The front shear depressor pushes the front floating shear down to cut the crimped terminal from the strip.

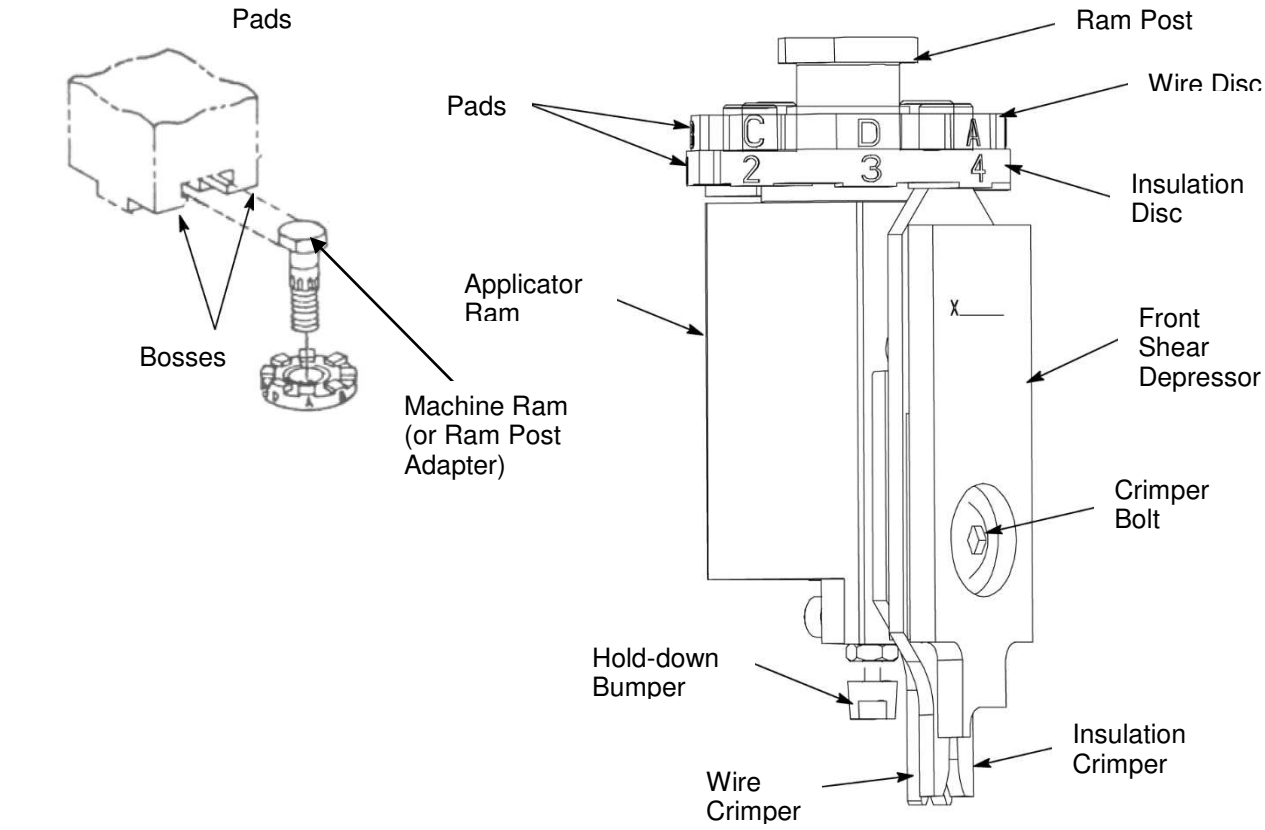

Figure 3

The hold-down bumper is attached to the ram and holds the terminal in place during the crimping and shearing process. (Note: Some applicators have a solid metal hold-down that may require adjustment when changing the wire size and/or crimp height.)

Terminals with dual carrier strips require a shear depressor, spacer, and terminal holder. These parts are attached to the feed cam side of the ram assembly. The rear shear depressor pushes the rear floating shear down to cut the terminal from the rear carrier strip, and the terminal holder keeps the terminal from raising during the crimping and shearing process. The rear floating shear and rear shear holder are mounted on the base plate.

The applicator's mounting surface is its base plate. The anvil, the front shear holder, the rear shear holder (if used), the terminal support, the strip guide adjustment block, and the applicator housing are mounted on the base plate. The strip guide plate is fastened to the strip guide adjustment block. The stock drag, the strip guide cover plate, and the front and rear strip guides are mounted on the strip guide plate.

2.2. Applicators with Mechanical-Feed Systems

Two lengths of feed cams are available for these applicators. The length of the feed cam to be used is determined by the length of the machine stroke. For example, a machine with a 28.58-mm [1.125-in.] stroke MUST use an applicator with a SHORT feed cam and a machine with a 41.28-mm [1.625-in.] stroke MUST use an applicator with a LONG feed cam.

The POST-FEED cam advances the lead terminal over the anvil on the DOWNWARD stroke of the ram assembly, which leaves the anvil clear when the machine is at rest.

The PRE-FEED cam advances the lead terminal over the anvil on the UPWARD stroke of the ram assembly, so that a terminal is over the anvil when the machine is at rest.

2.3. Applicators with Air-Feed Systems

In these applicators, the feed cam and its mechanical system of rods, levers, and springs are replaced by an air cylinder and a series of valves. In the air feed system, the feed action is started when the foot switch is depressed to begin the machine cycle. At the beginning of the ram's DOWNWARD stroke, the feed mechanism of the machine switches the on-off valve to the "off" position, which shuts off the air supply to the extension side of the feed cylinder. When this happens, a spring inside the cylinder retracts the cylinder shaft and the feed finger attached to it. The ram continues downward, completes the crimping action, and starts back up.

As it approaches the fully raised position, the machine feed mechanism switches the on-off valve back to the "on" position. This supplies air to extend the feed finger and move the next terminal over the anvil. The flow control valve controls the speed of the feed finger stroke.

NOTE
The air supply connection must be connected to an air supply line providing 80-100 psi [5.50-6.90 bar].

3. APPLICATOR INSTALLATION AND REMOVAL

DANGER
Be SURE power to the machine is turned "off" (or power cord is disconnected) BEFORE installing or removing applicator.

CAUTION
With applicator in the machine, NEVER attempt to cycle machine under power WITHOUT terminals properly loaded, as described in Section 4; otherwise, the tooling may be damaged.

3.1. AMP-O-LECTRIC Machine

A. Installation

This machine must be equipped with Machine Conversion Kit PN 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 put into and taken out of the machine.

B. Removal

1. Turn machine "off" and disconnect power cord.
2. Unload applicator as described in Section 4. Remove hold-down bracket and movable stop, then slide applicator away from stop on base mount until ram post is clear of machine ram.

3.2. Model "T" Terminating Unit

A. Installation

1. Turn "off" or disconnect power to unit.
2. Push IN release bar on quick-change base plate. Locking latch will pivot downward.
3. Place applicator on quick-change base plate, then slide it back until two notches engage stops at back of plate. At the same time, guide ram post into ram post adapter.
4. Flip locking latch UP to secure applicator in place.

B. Removal

1. Disconnect power cord.
2. Cut terminal strip one or two terminals from end of applicator.
3. Push IN release bar on quick-change base plate. Locking latch will pivot downward.
4. Slide applicator forward until clear of ram post adapter.

3.3. Model "G" Terminating Machine

Refer to Customer Manual 409-5842 for installation and removal procedures.

4. APPLICATOR LOADING AND UNLOADING

NOTE
Some terminal strips require the use of a terminal lubricant. Wick-type lubricators apply lubricant to the terminal strip as it feeds into the applicator. Terminal lubricants reduce tooling wear and help reduce damage to the plating on some terminals.

CAUTION
Depending on the final use of the crimped terminal, terminal lubricators are not always recommended. To determine if your applications warrant the use of a terminal lubricator, contact your field representative.

NOTE
If your application, warrants the use of a terminal lubricator, the recommended lubricant is Stoner Mechanical Lubricant E807, available from Stoner, Inc. Call 1-800-227-5538 or visit their website.

4.1. Terminal Strip Loading

CAUTION
Before loading terminal strip in applicator, be SURE the installed applicator is the right one for terminal to be applied. Compare terminal number on reel with numbers listed on applicator parts list.

1. Turn "off" or disconnect power to machine.
2. Be sure ram assembly is all the way up. If necessary, hand-cycle machine to raise the ram. (Refer to customer manual for machine.)
3. Remove applicator guard assembly.
4. Raise stock drag by turning drag release lever upward. Remove length of terminal strip left in applicator by grasping terminals at the strip guide entry, raising the feed pawl, and pulling strip straight out of applicator.
5. With reel of terminals installed on reel support, feed terminal strip into applicator between strip guides.

CAUTION
Be SURE terminal strip enters strip guides with barrel (wire) end toward the stock drag, and the open side up.

6. Raise feed pawl and continue to feed terminal strip until LEAD terminal is over anvil and feed pawl engages hole in carrier strip.
7. If terminals are POST-FED, lift feed pawl and pull the strip back one terminal length. The lead terminal will then be moved over the anvil on the downward stroke of the ram assembly.
8. Turn drag release lever downward to lower the stock drag.
9. Be sure tip of feed pawl is in feed hole in carrier strip.

NOTE
Some carrier strips have additional holes which are not used for feed purposes.

10. Hand-cycle the machine several times to make sure the applicator is properly adjusted as described in Section 5.
11. Re-install applicator guard assembly.

4.2. Terminal Strip Unloading

1. Cut terminal strip one or two terminals from end of applicator.

NOTE
Applicator should never be unloaded unnecessarily. A section of terminal strip should always be left in the unit. Since it is not necessary to remove strip section for cleaning, lubrication, or repair, it should only be removed as a part of the loading procedure.

2. If terminals are POST-FED, turn drag release lever upward to raise stock drag, lift the feed pawl, and move the lead terminal over the anvil.

5. ADJUSTMENTS

5.1. Wire Crimp Adjustment

1. Select pad letter (A, B, C, or D) from data plate for AWG wire size to be used.
2. Turn wire disc (upper disc) to line up selected pad letter with BOSSES ON MACHINE RAM (or RAM POST ADAPTER (reference Figure 3). This provides the right crimp height for that wire size.
3. After making insulation crimp adjustment described in paragraph 5.2, make several test cycles and inspect terminations CLOSELY.
   a. Look for rough or sharp edges around crimped barrels (flash), deformed crimps, bent terminals, or other defects caused by worn or broken tooling. If necessary, replace tooling as described in Section 6.
   b. If terminations appear normal, measure crimp height of each termination as described in Instruction Sheet 408-7424, packaged with the applicator. Crimp height must agree with measurement specified on parts list for wire size being used. Record crimp height dimensions for reference.
   c. If crimp height is INCORRECT, remove applicator and install one that is KNOWN to produce terminations of CORRECT crimp height. Make several test cycles and repeat Step b. If crimp height is INCORRECT for this applicator, problem is machine shut height, and corrective information can be found in appropriate machine manual. If crimp height is CORRECT, problem is in original applicator, and corrective measures are presented in paragraph 6.5, Adjustable Crimp Height Repair.
4. During extensive operation, periodically repeat Step 3 to make sure that applicator is producing correct terminations.

5.2. Insulation Crimp Adjustment

To adjust insulation crimp height, turn insulation disc (lower disc) to line up the number (1 through 8) with top of insulation crimper on ram assembly. No. 8 makes the tightest crimp and No. 1 the loosest, a difference of approximately 1.78 mm [.070 in.]. To find the insulation crimp you want, start with No. 1 and make test crimps. Increase the setting one number at a time until you get the proper insulation crimp height.

5.3. Terminal Strip Feed Adjustment

1. With terminal strip properly loaded, check position of lead terminal over anvil by actuating the applicator to move the feed pawl to the forward limit of its stroke. Lead terminal MUST be centered on anvil.
2. If the lead terminal is centered on the anvil, the forward limit adjustment is correct. Go on to Step 5. If NOT centered, continue with Step 3.
3. Loosen screw on top of pivot block (see Figure 2). Turn the stroke forward limit adjustment screw COUNTERCLOCKWISE to move the forward limit toward anvil, or CLOCKWISE to move the forward limit away from anvil. Tighten screw on top of pivot block.

a. **Applicator with mechanical-feed systems** (Figure 2)

(1) Loosen screw on top of pivot block.

(2) Turn stroke forward limit adjustment screw COUNTERCLOCKWISE to move forward limit toward anvil, or CLOCKWISE to move forward limit away from anvil.

(3) Tighten screw on top of pivot block.

b. **Applicator with air-feed systems** (Figure 4)

(1) Loosen slightly the feed cylinder locking screw on top of feed cylinder bracket (see Figure 4).

(2) Turn on-off valve to the “off” position (AMP-O-LECTRIC machine), or disconnect air supply to feed cylinder (automatic equipment). Feed finger should retract.

(3) Turn feed adjustment screw CLOCKWISE to RETRACT forward limit or COUNTERCLOCKWISE to EXTEND forward limit of stroke.

c. Retighten feed cylinder locking screw, turn on-off valve to "on" position (AMP-O-LECTRIC machine) or reconnect air supply to feed cylinder (automatic equipment).

4. Repeat Steps 1, 2, and 3 as required. When adjustment is correct, go on to Step 5.

5. Watch the feed pawl as the machine is hand-cycled several times. It should have enough – but not too much - overtravel on the backstroke to pick up the next terminal.

NOTE

At the end of its backstroke, the feed pawl should be at the back edge of the feed hole to be used. The backstroke MUST NOT be longer than this, or the feed pawl might not drop into the feed hole.

6. If feed pawl stroke length is satisfactory, feed adjustments are complete. If not, continue with Step 7.

7. Adjust feed pawl stroke length.

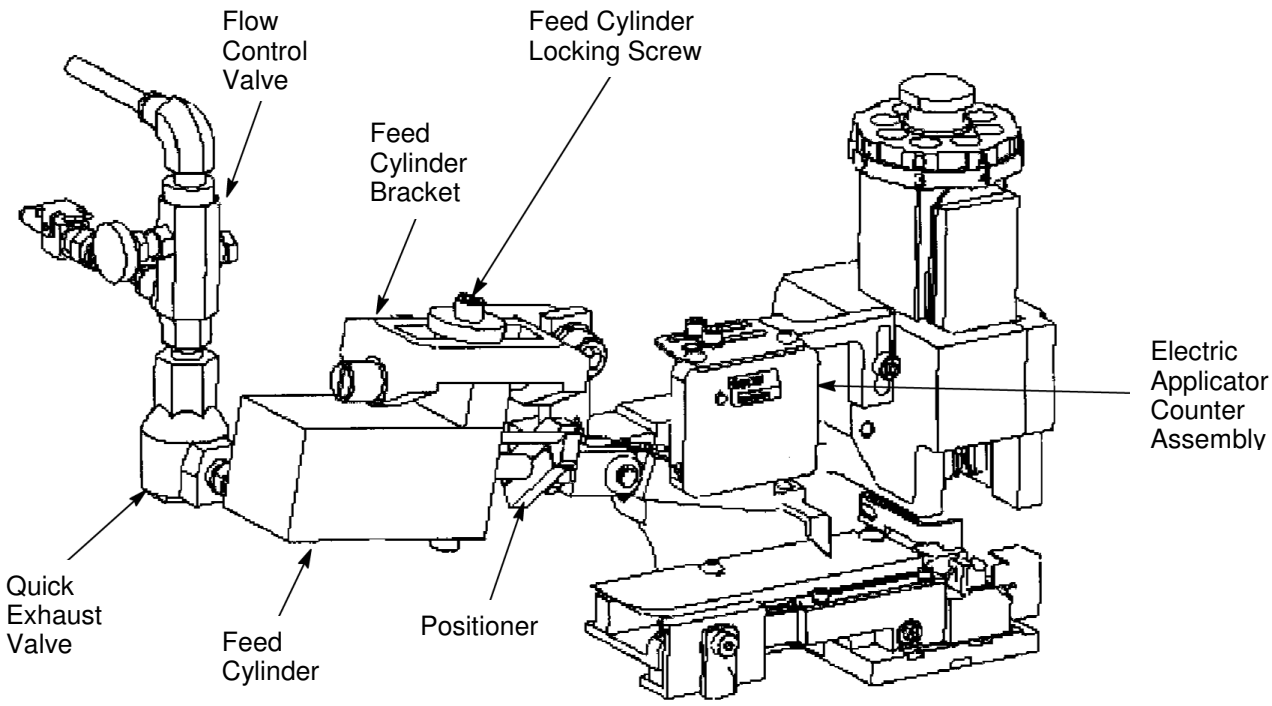

Figure 4

a. **Applicator with Mechanical Feed Systems**

(1) Loosen slightly the 3/4-in. hex nut, on side of applicator, to allow the pivot shaft to move in slot (see Figure 2).

(2) Loosen locknut on stroke length adjustment screw, and turn the screw CLOCKWISE to SHORTEN the backstroke or COUNTERCLOCKWISE to LENGTHEN the backstroke. Tighten locknut to secure screw.

(3) Be sure pivot shaft bushing is UP against the stroke length adjustment screw. Tighten the 3/4-in. hex nut. Repeat Step 5 to check stroke length.

(4) Repeat Steps 7 through 9 until stroke length is correct.

b. **Applicator with Air Feed Systems**

(1) With machine at rest and feed finger extended, loosen two screws holding positioner to feed cylinder shaft and move positioner in required direction on shaft.

(2) Retighten screws.

(3) Repeat Step 5 to check stroke length.

5.4. Strip Guide Plate and Feed Pawl Adjustments

This procedure moves the plate on which the strip guides are mounted. Since the terminal strip is fed into the applicator between the strip guides, it is moved front and back over the anvil as the strip guides are moved.

The adjustment of the feed pawl to match any change in the position of the front strip guide is also described here:

1. From bottom side of strip guide plate, loosen the screw that holds the strip guide adjustment block to the strip guide plate.
2. With the LEAD terminal centered over anvil, lift and hold (or block) the feed pawl up to clear the front strip guide.
3. Turn strip guide plate adjustment screw CLOCKWISE to move strip guide plate TOWARD REAR, or COUNTERCLOCKWISE to move it TOWARD FRONT. The insulation barrel of the lead terminal should be as close as possible to the floating shear. Tighten screw to hold strip guide plate in position.
4. Loosen screw holding feed pawl to feed finger (feed pawl holder). Move feed pawl until its tip drops into slot in front strip guide. Retighten screw.
5. Hand-cycle terminating unit, checking for proper terminal feed and strip guide plate alignment.
6. If necessary, reposition shear holder(s) as described in paragraph 5.6.

5.5. Strip Guide Adjustment

This adjustment is not used very often, because it is only needed when the rear strip guide is not parallel to the strip guide plate, the strip guides are not parallel to each other, or there is a variation in strip width.

NOTE

The strip guides are correctly positioned on the strip guide plate when the applicator is built, and normally do NOT need adjustment. DO NOT use this procedure for front-to-rear positioning of strip refer to paragraph 5.4, Strip Guide Plate and Feed Pawl Adjustments.

1. Lift and hold (or block) the feed pawl up to clear the front strip guide, and loosen screws holding strip guides to strip guide plate.
2. Move the rear strip guide in the desired direction, making sure it is parallel to the strip guide plate, and then retighten the holding screws.
3. Align the front strip guide with the holes in the terminal carrier strip, but be sure the strip guides are parallel, and that the terminal strip can move freely with a minimum of side clearance. Retighten the screws.

NOTE

If feed pawl is not aligned with the front strip guide, refer to paragraph 5.4, Step 4.

4. Hand-cycle terminating unit, checking for proper terminal feed and strip guide alignments.

5.6. Adjustment of Shear(s) and Shear Holder(s)

With lead terminal centered over anvil, check to see if floating shear(s) cuts the terminal from the carrier strip(s) correctly. If necessary, make the following adjustments:

NOTE
The applicator must be removed from the terminating unit for this procedure. See removal procedure under Paragraph 3.1 or 3.2. Remove the applicator ram before proceeding.

A. Front Shear Adjustment

1. From the bottom of the base plate, loosen the two screws that secure the shear holder to the base plate.
2. Move the shear holder and floating shear in the desired direction, and retighten the screws.

NOTE
There should be minimal clearance between the floating shear and the anvil; the shear must move up and down freely, and must be square to the back of the anvil.

3. With the applicator ram replaced and the lead terminal centered over the anvil, check that the floating shear correctly cuts the terminal from the carrier strip. If shearing action is not correct, repeat Steps 1 and 2 or check for worn or damaged tooling.

B. Rear Shear Adjustment (Dual Carrier Strip Product Only)

The rear shear is more likely to need adjustment because it is affected by differences in terminal strip widths and strip guide plate adjustments.

1. From the bottom of the base plate, loosen two screws that hold the rear shear holder to the base plate.
2. With the terminal strip inserted into applicator, and the lead terminal centered over the anvil, move the rear shear holder in the direction required to obtain the proper cutoff tab.
3. Check that the shear is square to the end of the terminal, and then tighten the holding screws.
4. Depress the floating shear and check for proper shearing action and proper cutoff tab.
5. If necessary, repeat Steps 1 through 4 or check for worn or damaged tooling.

6. REPAIR AND REPLACEMENT OF PARTS

These procedures cover the applicator parts which most often need repair or replacement because of wear. Remove the applicator from the machine before doing any maintenance work. Refer to the exploded view drawing and parts list packaged with the applicator for identification of parts. Be sure to order replacements for parts used from spare parts stock so that they will be available when needed.

DANGER
Be SURE the power and air supplies to the machine are disconnected BEFORE repair or replacement of parts. Machine ram should be in the raised position.

NOTE
Wipe parts with a clean, dry, cloth as they are removed from applicator. Then, when putting them back into applicator, wipe mating surfaces with your fingers to make sure that all lint and other foreign matter has been removed.

6.1. Anvil Replacement

1. From bottom of applicator base plate, remove the screw which holds anvil in place.
2. Turn drag release lever upward, raise feed pawl, and pull strip back so lead terminal is between strip guides.
3. Remove anvil from groove in top of base plate.

4. Install anvil using reversed procedure. If a new anvil is needed, be sure part number of new anvil agrees with number on applicator parts list.

NOTE
When the anvil is replaced, the front shear and holder must be re-aligned (reference paragraph 5.6.A.)

5. Re-align crimpers as described in paragraph 6.3.

6.2. Floating Shear Replacement

NOTE

It is not necessary to remove shear holder(s) to replace floating shear(s). Before removing floating shear(s), note orientation for re-installation. The floating shears are spring-loaded, so, exercise care during removal.

1. Turn drag release lever upward, raise feed pawl, and pull strip back so lead terminal is between strip guides.
2. Push down on the floating shear, then remove shear retaining screw from side of shear holder.
3. Slowly release pressure on floating shear. Compression spring will push it out of shear holder.
4. After removing floating shear, lift compression spring out of shear holder.
5. Inspect spring for damage and replace it if necessary. Refer to parts list for correct number.
6. Re-install floating shear(s) using reversed procedure. If installing new shear, be sure part number agrees with the number on the parts list.
7. Raise feed pawl and move lead terminal over the anvil. Turn drag release lever down to lower stock drag.
8. Check shear holder adjustment as described in paragraph 5.6, Adjustment of Shear(s) and Shear Holder(s).

6.3. Crimper Replacement

1. Loosen the crimper bolt slightly and remove ram assembly from applicator by pulling upward. It may be necessary to move the feed finger forward to release the ram assembly.
2. Remove crimper bolt which holds the front shear depressor, front shear depressor spacer, tubular spacer, insulation crimper, crimper spacer, and wire crimper in place on the ram assembly. Note position of parts for re-installation.
3. Re-install parts using reversed procedure. The upper end of the wire crimper must be up against the pins on the ram assembly, and the top hole on the crimper must mate with the roll pin in the ram assembly. Tighten the crimper bolt ONLY finger tight.

NOTE
Insulation crimpers with legs of equal length, that are identical front and back, may be positioned with either side out. All other insulation crimpers MUST be positioned with part number facing the direction noted during removal. If new parts are used, be SURE part numbers agree with numbers on parts list.

4. Put ram assembly back into applicator, and install applicator in machine.
5. Lift feed pawl and pull terminal strip back until lead terminal is between strip guides.
6. Form a piece of heavy paper over anvil, then slowly hand-cycle machine while watching alignment of crimpers with anvil. When ram assembly has reached bottom of stroke, carefully tighten crimper bolt. Crimpers MUST move freely over anvil after paper is removed.

6.4. Feed Pawl Replacement

1. Remove the adjustment screw which holds the feed pawl to the feed finger (feed pawl holder).
2. Replace feed pawl using reversed procedure. If new pawl is installed, be SURE the part number agrees with the number on the parts list.
3. Adjust feed pawl as described in paragraph 5.4.

6.5. Adjustable Crimp Height Repair

Under the insulation disc is a laminated washer which may break or compress after extensive use. This could cause the applicator to produce terminations with a different crimp height than specified. To correct this problem, perform the following steps:

1. Subtract specified nominal crimp height from average crimp height recorded as a part of paragraph 5.1, Wire Crimp Adjustment. This difference will be the thickness of washer(s) (PN 690125-1) to be ADDED under the insulation disc.

NOTE
Washer PN 690125-1 is a peel-type, laminated washer consisting of five layers, with each layer being 0.05 mm [.002 in.] thick.

2. Remove ram assembly from applicator, and loosen ram post locking screw in the side of applicator ram (reference Figure 1).
3. Hold ram assembly with ram post pointing down, and unscrew ram from ram post, leaving wire disc and insulation disc in place. If necessary, the end of the ram post may be placed in a vise to free both hands for turning ram.

NOTE
DO NOT REMOVE wire disc and insulation disc from ram post. Detent balls and springs will pop out and may become lost if discs are removed.

4. Place washer(s) of thickness determined in Step 1 on ram post. If old washer is broken and must be replaced, measure thickness of broken washer with a micrometer. Add this measurement to amount to be added (determined in Step 1), and select new washer(s) of this thickness. Place new washer(s) on ram post.
5. Hold ram with hole facing downward, screw ram post into ram, and tighten by hand until snug.
6. Check that numbers on wire disc and letters on insulation disc line up properly over the top of insulation crimper. Discs are held in position by ball detents. If necessary, turn ram post back slightly until numbers and letters line up, then tighten ram post locking screw to fasten ram post in position.

NOTE
Turn wire and insulation discs to other positions. When the "click" of the detent ball is heard, check for centering of number or letter over insulation crimper.

7. Put ram assembly back into applicator.
8. Install applicator in machine and make some test crimps. Measure crimp height, and check it against crimp height specified on applicator parts list. If crimp height is within specified tolerances, applicator may be placed in service. If not, repeat this procedure starting with Step 1.

7. FINE ADJUST ASSEMBLY FOR HEAVY DUTY MINIS

Some applicators may contain Fine Adjust Assembly PN 879103-[ ] used in conjunction with the side-feed applicators to provide a greater number of crimp height options without the necessity of changing parts.

The Fine Adjust Assembly PN 879103-[ ] consists of a ram post, a wire crimp height adjustment disc, and an insulation crimp height adjustment disc (reference Figure 5), which replace the ram post, wave washer, wire disc, insulation crimp disc, and shim on the applicators. In addition, Fine Adjust Assembly PN 879103-[ ] uses a spacer that replaces the normal production spacer.

7.1. Wire Crimp Height Adjustment Disc

The wire crimp height adjustment disc in this assembly is an adjustable plate with fifty-four increment notches. Each increment represents a change in crimp height of 0.015 [.0006]. Turning the crimp height adjustment disc clockwise decreases the crimp height; turning the disc counterclockwise increases the crimp height.

NOTE
Every tenth increment is denoted by a letter ("A" to "F") with the increments between each letter represented numerically ("1" to "9"). Wire sizes and their relevant crimp heights will be listed on the log sheet with the corresponding reference setting, such as "A6," "C4," and so forth.

7.2. Insulation Crimp Height Adjustment Disc

The insulation crimp height adjustment disc in this assembly is a plate with twelve variable pad heights. Each pad represents a change in insulation crimp height of 0.15 [.006]. Turning the lower disc clockwise decreases the insulation crimp height; turning the disc counterclockwise increases the insulation crimp height.

NOTE
Insulation crimp height is normally a non-measured dimension and varies according to the diameter of insulation being used.

7.3. Fine Adjust Removal and Re-Assembly

Fine Adjust Assembly PN 879103-[ ] is factory installed and should require no further adjustment. If the assembly must be removed from the ram, be sure to loosen ram post locking set screw (reference Figure 1). The ram post can then be removed. Upon re-assembly, be sure that the two ball detents on the fine adjust assembly are aligned with the centerline of the insulation crimper and oriented relative to the front of the tooling (as shown in Figure 5). Ensure that the correct spacer (as per the appropriate applicator log) is re-assembled. Be sure that the ram post and ram post locking set screw are tight before re-installing the applicator into the appropriate terminating unit.

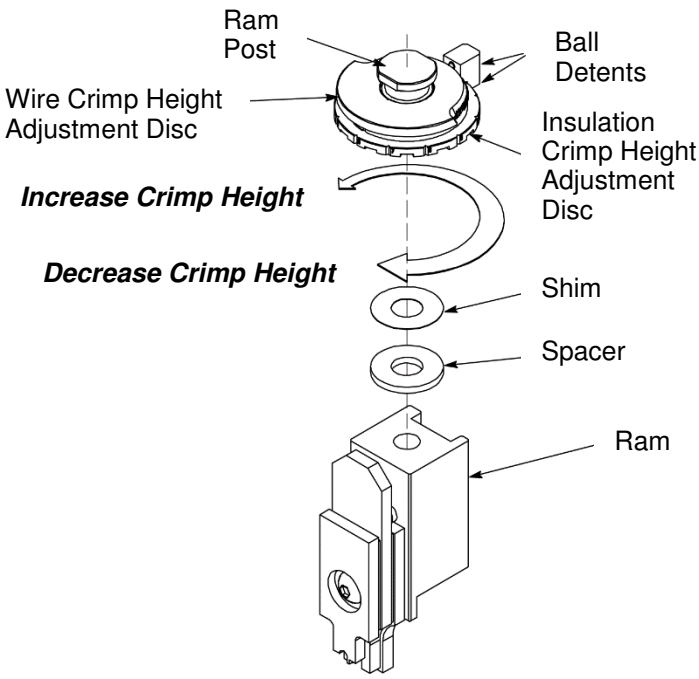

Figure 5

8. CLEANING AND LUBRICATION

For best performance and minimum downtime, applicator should be cleaned, inspected, and lubricated; refer to Instruction Sheet 408-8059 for daily and monthly cleaning.

9. APPLICATOR STORAGE

For proper applicator storage, refer to Instruction Sheet 408-8059.

10. REVISION SUMMARY

At the end of paragraph 2.3., added the following NOTE: The air supply connection must be connected to an air supply line providing 80-100 psi [5.50-6.90 bar].