

Figure 1

1. INTRODUCTION

This instruction sheet covers AMP 180° Cable Clamp Assembly 224533-1 which supports cables that are being terminated with the CHAMPOMATOR* 2.5 Bench Terminating Machine and CHAMPOMATOR 3A Semi-Automatic Cable Terminating Machine.

NOTE

For detailed information on the operation of the CHAMPOMATOR 2.5 and 3A machines, refer to AMP Customer Manuals 409-5839 and 409-5771, respectively, which are supplied with the machines.

2. DESCRIPTION (Figure 1)

The cable clamp assembly attaches to the mandrel assembly, which is supplied with the various tooling kits used with the machine. The clamp is inserted into the back of the mandrel, and a locking screw secures the clamp in place. The cable clamp assembly can be positioned in the mandrel assembly as required for the specific application by loosening the locking screw, sliding the clamp assembly to the desired position, and tightening the locking screw.

The cable clamp assembly features a stationary handle, a movable handle, and clamp assembly jaws

(cable gripper). In use, the operator squeezes the movable handle toward the stationary handle, which opens the clamp assembly jaws to accept the cable.

3. INSTALLATION

To install the cable clamp assembly:

1. Locate T-slot in the back of the tooling kit mandrel assembly.
2. Slide the cable clamp assembly into the T-slot as shown in Figure 2.
3. Position the clamp assembly so that the clamp jaws are centered over the connector area and tighten the locking screw with a 5/32-in. hex wrench.

4. CLAMP OPERATION

NOTE

Make sure that the machine is programmed to operate with a 180° cable dress before applying any connectors.

1. Check that the clamp is in the correct position as required for the connector being applied. Adjust if necessary.

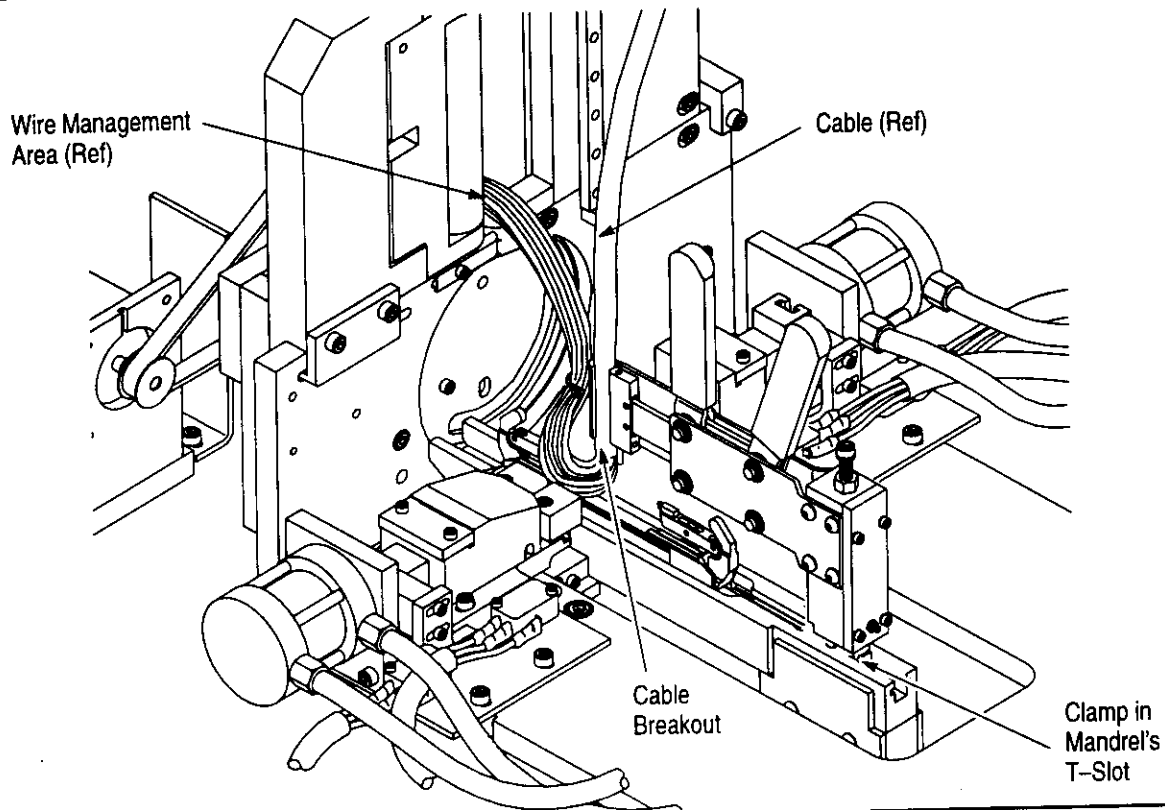


Figure 2

2. If necessary, move the clamp assembly out of the way by lifting upward on the assembly and pivoting the assembly in either direction.

3. Place a connector on the connector fixture.

4. Place a properly stripped cable into the machine's wire management area, then pull the cable back into the cable clamp and locate the cable breakout as required for the application.

5. Open the clamp jaws by squeezing the handles, then insert the cable and release the handles to hold the cable in place.

6. Terminate the cable to the connector as described in the instructions supplied with the machine.

7. When the termination procedure is complete, open the cable clamp assembly jaws and remove the cable from the jaws.

8. Pull upward on the clamp assembly and rotate the clamp assembly out of the way, and remove the completed connector assembly.

5. CLAMP ADJUSTMENT

The clamp can be adjusted for horizontal position and vertical position. Additionally, a dowel pin on the cable

gripper can be adjusted to serve as a guide for positioning the cable.

5.1. Horizontal Adjustment (Figure 3)

If the clamp assembly jaws do not align with the center of the connector, the horizontal position of the clamp jaws should be adjusted.

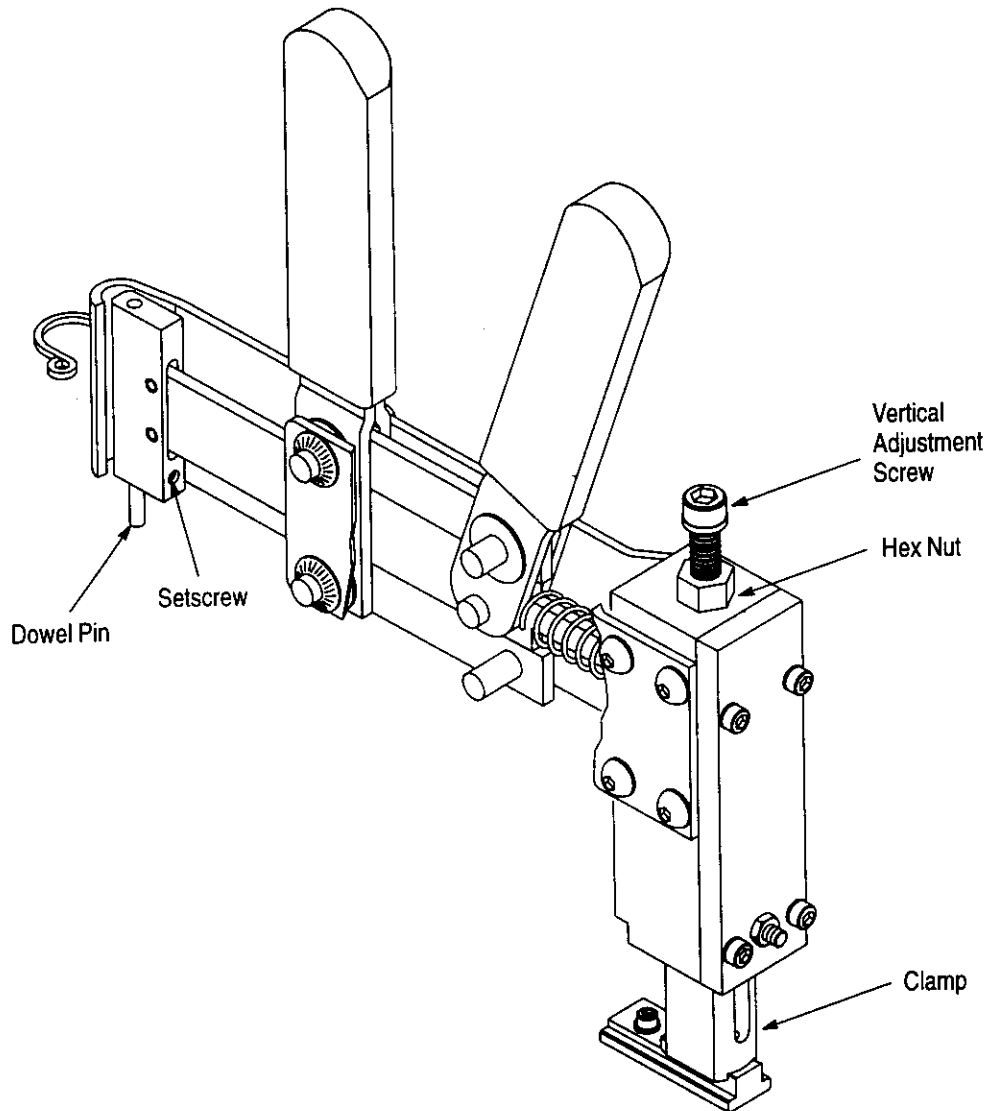
NOTE

Horizontal adjustments to the entire clamp assembly can be made by loosening the locking screw and sliding the clamp assembly along the T-slot in the mandrel.

5.2. Vertical Adjustment (Figure 3)

The clamp assembly should be adjusted so that the cable breakout is the correct distance from the connector during the termination procedure. To adjust the vertical position of the clamp assembly:

1. Use a 1/2-in. open end wrench to loosen the hex nut on the vertical adjustment screw.
2. Using a 5/32-in. hex wrench, turn the vertical adjustment screw **CLOCKWISE** to raise the clamp assembly, or **COUNTERCLOCKWISE** to lower the clamp assembly as required.
3. Tighten the hex nut to hold the clamp in position.



NOTE: Portion of the short clamp side removed for clarity.

Figure 3

5.3. Dowel Pin Position (Figure 3)

The dowel pin, which is located on the cable gripper, serves as a guide for placing the cable breakout correctly while loading the cable in the clamp jaws. The dowel pin can be moved as required for the application. To move the dowel pin:

1. Use a 1/16-in. hex wrench to loosen the setscrew shown in Figure 3.
2. Slide the dowel pin to the desired position.
3. While holding the dowel pin in position, tighten the setscrew.

6. REPLACEMENT PARTS

Replacement parts for Cable Clamp Assembly 224533-1 are listed on the drawing shipped with the tool. When ordering replacement parts, refer to the component part number and description. Order replacement parts through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605 or write to:

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